

3M

Hi-Strength 94 ET Spray Adhesive

Technical Data

March 2012

Product Description

A high performance, industrial grade spray adhesive with a unique low telegraphing pebble spray pattern.

Key Features

- Bonds to a variety of demanding substrates like decorative laminate, metal, and some rubbers.
- Typically used in woodworking and specialty vehicle applications, especially where VOC's are a concern.
- Extended tack allows for longer bonding range.
- Features a low telegraphing spray pattern.

Typical Properties

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Product	3M™ Hi-Strength 94 ET Spray Adhesive - Low VOC <20%	3M™ Hi-Strength 94 ET Cylinder Spray Adhesive	3M™ Hi-Strength 94 ET Adhesive
Base:	Synthetic Elastomer	Synthetic Elastomer	Synthetic Elastomer
Solids Content - (by wt.):	20.5%	25%	25%
Density (lbs/gal):	7	7.8	7.9
Viscosity (cps):	N/A	N/A	< 500
Color(s):	Translucent and Red	Translucent and Red	Translucent and Red
Volatile Organic Compounds (VOC):	< 20%	< 80 g/L	< 80 g/L
Hazardous Air Pollutants (HAPS) % wt (calculated):	No	No	No
CARB Compliant:	Yes	N/A	N/A
SCAQMD 1168 Compliant:	N/A	Yes	Yes
GREENGUARD Indoor Air Quality Certified®:	Yes	Yes	Yes
LEED® Eligible:	Yes	Yes	Yes
Coverage @ 2.5 gms /ft ² per lb (sqft):	37	45	45
Spray Pattern:	Variable Lace	Pebble	Pebble or Lace
Dry Time:	1 minute	1 minute	1 minute
Bonding Range:	1-60 minutes	1-60 minutes	1-60 minutes
Shear Adhesion Failure Test - SAFT ⁽¹⁾ :	210F	210F	210F
Flammable Solvent:	Yes	Yes	Yes
Flammable Propellant:	Yes	Yes	N/A

⁽¹⁾SAFT Shear Adhesion Failure Test with birch plywood, 1 inch overlap, 100 grams used, temperature start at 90F and ramped 10F every 10 mn. until complete failure.

Available Sizes

Container Size	94 ET - Clear		94 ET - Red	
	3M Stock Number	UPC Number	3M Stock Number	UPC Number
24 Fl. Oz. (Net Wt. 19.8 oz)	62-4870-4930-6	00-051111-97977-8	62-4873-4930-0	00-051111-97978-5
Large Cylinder – 26.2 lbs.	62-4871-8030-9	00-051111-97979-2	62-4874-8030-3	00-051111-97986-0
Intermediate Cylinder – 128 lbs.	62-4871-8150-5	00-051111-97980-8	62-4874-8150-9	00-051111-97987-7
Jumbo Cylinder – 266 lbs.	62-4871-8300-6	00-051111-97981-5	62-4874-8300-0	00-051111-97988-4
5 gallon pail – 39.5 lbs.	62-4872-8530-3	00-051111-97983-9	62-4875-7535-9	00-051111-97984-6
54 gallon drum – 426.6 lbs.	62-4872-9530-5	00-051111-97990-7	62-4875-9530-8	00-051111-97991-4

3M

Hi-Strength 94 ET Spray Adhesive

Storage	Store product at 60°-80°F (16°-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures may cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis.
Shelf Life	When stored at the recommended conditions in original, unopened container, this product has a shelf life of 15 months from date of shipment.
Precautionary Information	Refer to product label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.
Technical Information	The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.
Product Use	Many factors beyond 3M’s control and uniquely within user’s knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user’s method of application.
Warranty, Limited Remedy, and Disclaimer	Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOMER OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M’s option, replacement of the 3M product or refund of the purchase price.
Limitation of Liability	Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.



Industrial Adhesives and Tapes Division
3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550 • 877-369-2923 (Fax)
www.3M.com/94ET

3M is a trademark of 3M Company.

The GREENGUARD INDOOR AIR QUALITY CERTIFIED Mark is a registered certification mark owned by Air Quality Sciences, Inc. and used under license through the Greenguard Environmental Institute. LEED® is a registered trademark of the United States Green Building Council (USGBC).
©3M 2012