



Bond more plastics more readily than ever before...



**Plastic fabrication
with convenience,
ease, reliability...
and no screws.**

Building on decades of experience, 3M is now the single source for the widest range of adhesive tapes, liquids, films, and pastes for plastic fabrication. Select from formulations to bond even "difficult-to-bond" plastics with strength enough to replace screws and other mechanical or fusion fastening. This includes structural strength that can exceed 2000 psi in overlap shear.

For application convenience, ease, and productivity, 3M will work with you in evaluating specific methods for your operation. That's everything from bulk dispensing equipment to self-contained hand-held applicators, adhesive on a roll, and more.

3M *Innovation*

Selecting the right 3M adhesive technology for the job

The following is an introduction to 3M adhesive technology for plastic fabrication. Only some of the most commonly used products are presented. This chart is not meant to be all inclusive. Other bonding,

joining, sealing, and reclosable fastening products exist which may be suitable for a particular application. Since various grades of a particular resin can contain different additives or plasticizers which can affect

adhesion, final product selection should only be made **by the users** after evaluation of sample bonds and consideration of a variety of factors such as application and end-use conditions.

3M Adhesive Technologies*	Acrylic	ABS	Nylon	Poly-carbonate	Polyester (PET)	Poly-ethylene	Poly-propylene	Poly-styrene	Poly-urethane (RIM)	PVC (Unplasticized)	PVC (Plasticized)	TPO
Tapes												
VHB™ Tapes	4941, 5952, 4910 (clear)	4941, 5952	4941, 5952	4941, 5952, 4910 (clear)	4941, 5952	Primer 94 with 4941 or 5952	Primer 94 with 4941 or 5952	5952, Primer 94 with 4941	4941, 5952	4941, 5952	4941	Primer 94 with 4941 or 5952
Adhesive Transfer Tape	468MP, F-9469PC, 9472LE	468MP, F-9469PC, 9472LE	468MP, F-9469PC, 9472LE	468MP, 9472LE	468MP, F-9469PC, 9472LE	9472LE	9472LE	468MP, 9472LE	9472LE, 9695	468MP, F-9469PC, 9472LE, F-9465PC	F-9465PC	9472LE, 9695
Double Coated Tape	9495LE, 9795	9495LE, 9795	9495LE, 9795	9495LE, 9795	9495LE, 9795	9495LE	9495LE	9495LE, 9795	9495LE, 9690	9495LE, 9795	9573, 9586F	9495LE, 9690
Adhesives												
Structural Two-part Epoxy	DP-100+, DP-125, DP-190, DP-460	DP-100+, DP-125, DP-190, DP-460	DP-100+, DP-125, DP-190, DP-460	DP-100+, DP-125, DP-190, DP-460	DP-100+, DP-125, DP-190, DP-460	---	---	DP-100+, DP-125, DP-190	DP-100+, DP-125, DP-190, DP-460	DP-100+, DP-125, DP-190, DP-460	DP-100+, DP-125, DP-190, DP-460	---
Structural Two-part Urethane	DP-605, DP-640, 3532 B/A	DP-605, DP-640, 3532 B/A	DP-605, DP-640, 3532 B/A	DP-605, DP-640, 3532 B/A	DP-605, DP-640, 3532 B/A	---	---	DP-605, DP-640, 3532 B/A	DP-605, DP-640, 3532 B/A	DP-605, DP-640, 3532 B/A	DP-605, DP-640, 3532 B/A	---
Structural Two-part Acrylic	DP-805, DP-810, DP-8005, DP-8010	DP-805, DP-810, DP-8005, DP-8010	DP-805, DP-810	DP-805, DP-810, DP-8005, DP-8010	DP-805, DP-810	DP-8005, DP-8010	DP-8005, DP-8010	DP-8005, DP-8010	DP-810	DP-805, DP-810, DP-8005, DP-8010	DP-805, DP-810, DP-8005, DP-8010	DP-8005, DP-8010
Cyanoacrylate	CA-40H	CA-8, CA-40H, CA-100	CA-8, CA-40H, CA-100	CA-8, CA-40H, CA-100	CA-8, CA-40H, CA-100	---	---	CA-40H,	---	CA-40H,	CA-40H,	---
Curing Hot Melt (thermoset)	TE-031, TE-040, TS-115, TS-230	TE-031, TE-040, TS-115, TS-230	TE-031	TE-031, TE-040, TS-115, TS-230	TE-031, TE-040, TS-115, TS-230	---	---	TE-031, TE-040, TS-115, TS-230	TE-031, TE-040, TS-115, TS-230	TE-031, TE-040, TS-115, TS-230	TE-031, TE-040, TS-115, TS-230	---
Solvent-based	5, 2262, 4475, 4693	5, 1099, 4693	1099, 1357, 4693	5, 1099, 4475, 4693	1099, 1357, 4693	4693	4693	5, 4693	847, 1099	5, 2262, 4475, 4693	5, 2262, 1099, 4475	---
Water-based	2000	2000	2000	2000	2000	2000	2000	2000	---	2000	2000	---
Hot Melt Extrudable	3747, 3764, 3792LM, 3796	3747, 3764, 3792LM, 3796	3731, 3796	3731, 3747, 3764, 3796	3731, 3764, 3796	3731, 3748, 3764, 3796	3731, 3748, 3764, 3796	3764, 3796	3731, 3748, 3764, 3796	3731, 3747, 3764, 3796	3789, 3796,	3731, 3764, 3792LM, 3796
Hot Melt Sprayable	6111, 6111HT, 6114	6111, 6111HT, 6114	6111, 6111HT, 6114	6111, 6111HT, 6114	6111, 6111HT, 6114	6111, 6111HT, 6114	6111, 6111HT, 6114	6111, 6111HT, 6114	6111, 6111HT, 6114	6111, 6111HT, 6114	---	6111, 6111HT, 6114
Aerosol	77, 80, 90	72, 77, 80, 90	77, 90	77	77	72, 76, 90	72, 76, 90	77, 78, 80	74, 76, 77, 90	80	80	72, 76, 90
Bonding Films	557, 560, 615, 668	557, 560, 615, 668	557, 615, 668, 845	557, 560, 615, 668	557, 560, 615, 668	845	845	557, 560, 615, 668	557, 560, 615, 668	557, 560, 615, 668	---	---
Reclosable Fasteners	SJ3571/72, SJ3576/77, SJ3560, SJ3550CF	SJ3571/72, SJ3576/77, SJ3560, SJ3550CF	SJ3530/31, SJ3526/27, SJ3540, SJ3540GT	SJ3571/72, SJ3576/77, SJ3560, SJ3550CF	SJ3571/72, SJ3576/77, SJ3560, SJ3550CF	SJ3530/31, SJ3526/27, SJ3540, SJ3540GT	SJ3530/31, SJ3526/27, SJ3540, SJ3540GT	SJ3571/72, SJ3576/77, SJ3560, SJ3550CF	SJ3530/31, SJ3526/27, SJ3560, SJ3540, SJ3540GT	SJ3571/72, SJ3576/77, SJ3560, SJ3550CF	SJ3522/23, SJ3560, SJ3550CF	SJ3530/31, SJ3526/27, SJ3540, SJ3540GT
Label Stocks	7816, 7860, 7871	7816, 7860, 7871	7860, 7871	7816, 7860, 7871	7816, 7860, 7871	7860, 7871	7860, 7871	7860, 7871	7816, 7860, 7871	7816, 7860, 7871	7600	7860, 7871
Sealants	540, 606, 5354	540, 800, 5354	800, 5354	540, 800, 5354	540, 800, 5354	5354	5354	540, 606, 5354	540	540, 606, 800, 5354	800	5354

* A variety of other bonding, joining, and sealing products are available for these as well as various other plastics.

NOTE: The technical information and data provided here should be considered representative or typical only and should not be used for specification purposes. Final product selection should be made only after consideration of a variety of factors and evaluation of sample bonds.

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