

Technical Data Sheet

3M™ Heavy Duty 20 Spray Adhesive

Product Description

A high strength, fast grabbing, industrial grade, lace spray aerosol adhesive.



Product Features

- Can be used to bond many different substrates, including wood, plastics, soft foams, fabrics and metal.
- High strength, fast grabbing adhesive forms a powerful, permanent bond.
- Ideal in woodworking and many other applications where high strength is required.


Technical Information Note


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

Typical Physical Properties

Property	Values	Additional Information
Solids Content by Weight	17.3 %	
Spray Pattern	Variable Lace	
Color	Translucent	
Net Weight	13.8 oz	
VOC	51.8 %	
Coverage	26.4 sq ft	View 
Notes: @ 2.5 g/ft² per Can		
Hazardous Air Pollutants (HAPS)	16.8 % by weight	
Dry Time (min)	1 min	View 

Notes: Dry time will depend on ambient temperature, humidity and coverage applied.

Shear Adhesion Failure Test - SAFT	210 °F	View 
Notes: SAFT Shear Adhesion Failure Test with birch plywood, 1 inch overlap, 100 grams used, temperature start at 90°F and ramped 10°F every 10 min. until complete failure.		
Flammable Solvent	Yes	
Flammable Propellant	Yes	
Container Size	20 fl oz	
3M Stock Number	62-4915-4920-0	
UPC Number	00-051111-07861-7	

Base	Synthetic Elastomer	
Bonding Range	1 to 30 min	View 

Notes: 10 mil wet film 2 surfaces

Typical Uncured Physical Properties

Property	Values	Additional Information
Density	6.3 lb/gal	

Storage and Shelf Life

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.

When stored at the recommended conditions in original, unopened container, this product has a shelf life of 18 months from date of manufacture.

Automotive Disclaimer

Select Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

Bottom Matter

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References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/p/d/b40069416/
Safety Data Sheet SDS	https://www.3m.com/3M/en_US/SDS/compliance/20

Family Group

Link Tags:

• 20

Products	Solids Content by Weight	Spray Pattern
20	17.3 %	Variable Lace

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-

Information

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