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# 3M

## Hot Melt Adhesive

### 3762LM • 3762

Technical Data

July, 2016

**Product Description** 3M™ Hot Melt Adhesives are heat applied, 100% solids adhesives. They are fast setting thermoplastic adhesives with good “hot tack” and low to medium viscosity.

3M™ Hot Melt Adhesives bond to a wide variety of substrates such as corrugated, beadboard, repacking chipboard, recouperage, wood and many other lightweight materials.

**3M™ Hot Melt 3762LM** Low temperature application for handling ease. Economical hot melt with excellent “hot tack” and fast set.

**3M™ Hot Melt 3762** Low viscosity adhesive with “quick grab” properties.

#### Features

- 100% solids, no VOCs
- Easy to use
- Fast-setting adhesive obtains strength in seconds
- Low Melt (LM) adhesives are designed for low temperature application and heat sensitive substrates
- “Quick grab” for instant adhesion that cools to a tack free solid
- Ideal for packaging and woodworking applications.

#### Typical Physical Properties

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

	3M™ Hot Melt Adhesive	
	3762LM	3762
<b>Color (solid)</b>	Light Amber	Tan
<b>Density (g/cm<sup>3</sup>)</b>	1.01	0.95
<b>Flashpoint (°F)</b>	560	500

#### Directions for Use

**1. Surface Preparation:** Surfaces must be clean, dry and dust free. Wipe with a solvent such as isopropyl alcohol for plastic substrates to aid in removing oil and dirt.\*

\***Note:** When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer’s precautions and directions for use.

**2. Application:** 3M™ Hot Melt Adhesives are designed for application with a 3M™ Hot Melt Applicators. Read and follow the precautions and directions for use in the user’s manual before operating the applicator. 3M™ Hot Melt Adhesives are applied at 350-385°F, except the Low Melt (LM) series which are designed to be applied at 250-275°F. LM series are adhesives designed for lower temperature application but still yield long-lasting bonds.

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## Directions for Use (continued)

**Open Time** is the maximum amount of time between dispensing adhesive and joining surfaces. Reported open time are based on 1/8" extruded beads and will vary based on bead size, dispense temperature and ambient temperature.

Extruded bead sizes can be customized using 3M™ applicator tips.

**3. Coverage:** 3M™ Hot Melt Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead.

**4. Set Time:** After the bond is made, 3M™ Hot Melt Adhesives immediately build strength and no clamping is necessary. Set will occur faster on cold or metallic substrates.

## Typical Application Properties

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

	3M™ Hot Melt Adhesive	
	3762LM	3762
<b>Application Temperature<sup>1</sup></b>	250-270°F/ 121-132°C	350-385°F/ 177-196°C
<b>Viscosity (cps)<sup>2</sup></b>	4000 @ 250°F	1870 @ 375°F
<b>Open Time (seconds)<sup>3</sup></b>	25	35
<b>Delivery Time (seconds)<sup>4</sup></b>	45	30
<b>Available sizes/forms</b>	5/8"x8"Q 5/8"x2" TC 1"x3" PG 1/2"x12"AE 1/8" Bulk	5/8"x8"Q 5/8"x2" TC 1"x3" PG 1/2"x12"AE

(1) Recommended application temperature range. Temperature can be adjusted to regulate desired viscosity, delivery rate and pot life.

(2) Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

(3) For 1/8" semicircular bead, Douglas Fir to Douglas Fir.

(4) Extrusion time for one 1"x3" PG cartridge.

## Typical Performance Properties

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

	3M™ Hot Melt Adhesive	
	3762LM	3762
<b>Heat Resistance<sup>1</sup></b>	130°F/ 54°C	130°F/ 54°C
<b>Ball &amp; Ring Melt Point<sup>2</sup></b>	205°F/ 96°C	201°F/ 94°C
<b>Shear Strength<sup>3</sup></b>	480 psi	545 psi
<b>Peel Strength<sup>4</sup></b>	6 pwi	7 pwi
<b>UL94 Listing</b>	n/a	V2
<b>FDA Indirect Food Contact<sup>5</sup></b>	21 CFR 175.105	21 CFR 175.105

(1) Highest temperature that the adhesive will support a 2 psi dead load.

(2) ASTM E28-67.

(3) Douglas Fir to Douglas Fir.

(4) Canvas to Douglas Fir.

(5) Permitted for indirect food contact subject to the limitations in applicable CFR section(s).

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<b>Storage</b>	Store product below 120°F (49°C).
<b>Shelf Life</b>	When stored at the recommended conditions, this product has a shelf life of 2 years after 3M ships the product to a customer or distributor.
<b>Pre cautionary Information</b>	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
<b>Product Use</b>	All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.
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**ISO 9001:2000**

**3M**

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.

## Industrial Adhesives and Tapes Division

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