



Scotch-WeldTM 3789 Adhesive

Product Data Sheet

Updated : April 2008
Supersedes : March 1996

Product Description

Scotch-Weld Adhesive 3789 is a high performance plastics bonding hot melt adhesive with high impact resistance and good plasticiser migration resistance.

Physical Properties

Not for specification purposes

Base	Polyamide	
Colour	Brown	
Viscosity cP at 190°C ₁	5200	
Temperature Control Setting	5	
FDA Accepted ₂	Yes	
Sizes Available	26 x 73 mm slugs for the Scotch-Weld Air Powered Applicator. (This size is non-stock) 15 x 203 mm Quadrack Sticks for the Scotch-Weld TC Quadrack Applicator.	
Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	
₁ Brookfield Thermoset Viscometer. ₂ FDA Reg. 175.105 (adhesives) CFR Title 21.		

Performance Characteristics

Not for specification purposes

Delivery Rate for 26 x 73 mm slug	70 seconds	
Ball and Ring Softening Point ₃	132 °C	
Heat Resistance	104 °C	
Impact Resistance	14 in/lbs at -18°C 40 in/lbs at 22°C	

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**Performance
Characteristics Cont'd**
Not for specification purposes

Peel Strength at 22°C 4	28 N/10mm	
Shear Strength at 22°C 5	3.9 MPa	
Tensile Strength at 22°C	3.6 MPa	
Elongation	600 %	
Bonding Range 3mm bead 6	50 seconds	
<p>3 ASTM E-28-6-7. 4 On Canvas. 5 On Douglas Fir. 6 3mm semi circular bead, Douglas Fir to Douglas Fir.</p>		

**Health and Safety
Information**

Hot adhesive vapours may irritate eyes and respiratory system. Do not touch hot extruded adhesive or applicator tip. Avoid prolonged breathing of vapours.
Avoid eye exposure to heated product vapours. In case of skin contact with hot adhesive, immediately flush with cold water and cover with a clean dressing. Do not attempt to remove adhesive, have burn treated by a doctor.

For further health and safety information, please contact the 3M Toxicology Department in Bracknell on (0344) 858000.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



Industrial Adhesives & Tapes Division

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