

Application Success with 3M™ Hot Melt Adhesives

3M™ Hot Melt Adhesives offer many benefits for success with a variety of assembly and/or closure applications.



Open time or bonding range is the maximum time between applying adhesive and joining the surfaces. With 3M™ Hot Melt Adhesives you have wide latitude in bonding range selection to meet your process needs.



Move assemblies immediately and eliminate clamps, fixturing and drying time and energy. Each adhesive is engineered for efficient application with an easy-to-use 3M portable applicator.

Minimal operator training.

B

3M™ Hot Melt Adhesives are applied as a molten liquid, so they quickly fill gaps and wet the entire bonding surfaces. As a result, they often exceed 100 psi shear strength, quickly giving your application fast, convenient strength. Select from many options to fit your specific application — including peel resistant or highly heat resistant options.

3M[™] Hot Melt Adhesives Features and Benefits

Bonds Variety
of Surfaces



Unlike mechanical fasteners and sealing tapes, hot melt adhesive is virtually invisible between the mating surfaces.

Since hot melts are dispensed as liquids, it is easy to apply exactly where adhesive is needed.



You can combine a wide variety of materials ranging from wood to corrugated cardboard, heat-sensitive foam and even plastics and metals. For heat sensitive materials, low melt adhesives are dispensed at lower temperatures.

3M[™] Hot Melt Adhesives Selector Guide

Step 1: Select your assembly type



Small Joint Assembly Small joints are typically irregularly shaped, but only a few inches of overlap area.



Large Surface Lamination
Two surfaces of similar size, either
rigid or flexible, are bonded or
laminated together where majority of
the surface is covered by adhesive.

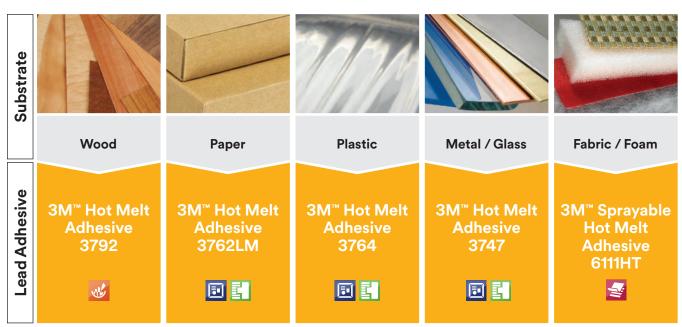


Mounting and Trim Attachment Small objects are mounted or added to a large surface.



Sealing, Potting and Encapsulating Adhesive flows over and around a component or fills a chamber to protect and seal components therein.

Step 2: After selecting your assembly, choose the substrate and identify the adhesive that performs best for your application.



Hot Melt Adhesive is dispensed at 350-385°F. Low Melt Adhesive is dispensed at 250-270°F.

NOTE: Low Melt (LM) adhesives liquefy at lower operating temperatures for bonding heat sensitive surfaces such as bead board and foams.

NOTE: High Temperature (HT) has high temperature resistance.

Lead Markets and Applications



Furniture and Woodworking

Common Assembly: Small Joint Assembly, Large Surface Lamination, Mounting and Trim Attachment

- Great product performance for various small joint, mounting and trim attachment, and large surface lamination assemblies in furniture, upholstery, cabinetry and more.
- Bonds well to wood, particleboard, MDF, laminate, foam, and fabric. Nearly instant bonding strength speeds up production — eliminating the need for clamping and mechanical fasteners.
- Low melt adhesives are available for lower operating temperatures and bonding heat sensitive surfaces.

Lead
Adhesives

3792 3792LM

Multi-purpose for wood, fabric and many other substrates with a long open time Multi-purpose low melt for heat sensitive surfaces



Transportation and Electrical

Common Assembly: Large Surface Lamination, Sealing, Potting and Encapsulating

- Fast, durable product performance for various small joint, mounting and trim attachment, large surface lamination and potting assemblies for automotive interior and electrical component manufacturing.
- Bonds well to foams, fabrics, non-wovens and difficult surfaces, such as LSE plastics.
- Some products are available as sprayable hot melt. All products can be tested to meet your specification requirements.

Lead Adhesives 3748 6111HT Bonds to plastic with high peel performance; Good thermal shock resistance and non-corrosive to copper; 3748VO is self extinguishing Sprayable hot melt with long open time; High temperature resistant



Packaging and Corrugated Carton Sealing

Common Assembly: Small Joint Assembly

- Quickly bonds and seals any size of corrugated carton invisibly. Durably bonds coated, printed and waxed surface that may be difficult to seal with tape.
- Low melt adhesives are available for lower operating temperatures and bonding heat sensitive surfaces.

Lead	
Adhesives	

3762

Fast-setting with "hot tack"

3762LM General purpose, fast setting with "hot tack"



Product Assembly

Common Assembly: Small Joint Assembly, Large Surface Lamination, Mounting and Trim Attachment

- Fast, durable product performance for small joint, mounting and trim attachment, large surface lamination and more.
- Many solutions are available to quickly assemble and attach materials for your design.
- Low melt adhesives are available for lower operating temperatures and bonding heat sensitive surfaces.

Lead Adhesives		3764	Bonds to all plastics, including low surface energy (LSE), flexible at low temp
	Adilesives	3792LM	Multi-purpose low melt for heat sensitive surfaces



Point-of-Purchase, Displays and Trade Exhibits

Common Assembly: Small Joint Assembly, Large Surface Lamination, Mounting and Trim Attachment

- Fast, durable product performance for small joint, mounting and trim attachment, large surface lamination and more.
- Bonds well to wood, foam, fabric, and plastics.
- Low melt adhesives are available for worker-friendly temperatures and bonding heat-sensitive surfaces.

Lead	3762LM	General purpose, fast setting with "hot tack"
Adhesives	3792LM	Multi-purpose low melt for heat sensitive surface

3M™ Hot Melt Adhesives

		Product/ Cat #	Color	Features/Application Ideas	Sizes	Stock Number	UPC Number	Case Qty	Billing Unit	
ad dduct	Jy: -132°C)	3762LM*	Light Amber	Excellent "hot tack", fast setting for corrugated, beadboard, recouperage, repacking chipboard and wood. Economical, general purpose. Use with low melt applicator only.	5/8" x 8" Q 5/8" x 2" TC 1" x 3" PG 1/2" x 12" AE	62-3720-9132-2 62-3720-9830-1 62-3720-9330-2 62-3720-9531-5	0-00-021200-49125-2 0-00-021200-49134-4 0-00-021200-49128-3 0-00-51115-25579-3	11 11 22 11	LBS	
	chnolog °F (121-	3776LM	Tan	Bonds variety of plastics, woods and light-gauge metals. Use with low melt applicator only.	5/8" x 8" Q 1" x 3" PG	62-3733-9132-5 62-3733-9330-5	0-00-021200-89499-2 0-00-021200-89501-2	11 22	LBS	
	Low Melt Technology: Applied 250–270°F (121–132°C)	3792LM*	Clear	Clear, multi-purpose for wood, coated paper, polyolefins and other heat-sensitive materials. P.O.P. displays. Use with low melt applicator only.	5/8" x 8" Q 5/8" x 2" TC 1" x 3" PG 1/2" x 12" AE	62-3760-9132-8 62-3760-9830-7 62-3760-9330-8 62-3760-9531-1	0-00-021200-82454-8 0-00-021200-82456-2 0-00-021200-83491-2 0-00-051115-25580-9	11 11 22 11	LBS	
	Applie	3798LM*	Light Yellow	Removable "gummy glue" for many substrates. Removes easily without residual tack. Use with low melt applicator only.	5/8" x 2" TC	62-3798-9830-7	0-00-021200-41604-0	11	LBS	
		3731*	Tan	High heat resistance. Bonds plastics including polyethylene, polypropylene.	5/8" x 8" Q 1" x 3" PG	62-3731-9132-9 62-3731-9330-9	0-00-021200-45271-0 0-00-021200-49139-9	11 22	LBS	
		3738*	Tan	High delivery rate and long bonding range. General purpose for foundry sand cores, wood bonding, corrugated, selected plastics and chipboard.	5/8" x 8" Q 5/8" x 2" TC 1" x 3" PG 1/2" x 12" AE	62-3738-9132-4 62-3738-9830-3 62-3738-9330-4 62-3738-9531-7	0-00-021200-65262-2 0-00-021200-82610-8 0-00-021200-82609-2 0-00-021200-82594-1	11 11 22 11	LBS	
		3747	Tan	General purpose for wide variety of plastics, wood and lightweight metals.	5/8" x 8" Q 5/8" x 2" TC 1" x 3" PG 1/2" x 12" AE	62-3747-9132-5 62-3747-9830-4 62-3747-9330-5 62-3747-9531-8	0-00-021200-82561-3 0-00-021200-82560-6 0-00-021200-82221-6 0-00-021200-82220-9	11 11 22 11	LBS	
		3748*	Off- White	Good thermal shock resistance. Non-corrosive to copper for many electronic applications. Bonds polyolefins.	5/8" x 8" Q 5/8" x 2" TC 1" x 3" PG	62-3748-9132-3 62-3748-9830-2 62-3748-9330-3	0-00-021200-76374-8 0-00-021200-82584-2 0-00-021200-82585-9	11 11 22	LBS	
	⁽	3748 VO	Light Yellow	Self-extinguishing version of 3748. Meets UL 1410 requirements.	5/8" x 8" Q 5/8" x 2" TC 1" x 3" PG	62-3768-9132-1 62-3768-9830-0 62-3768-9330-1	0-00-021200-85795-9 0-00-021200-85816-1 0-00-021200-85797-3	11 11 22	LBS	
	Hot Melt Technology: ed 350-385°F (177-196°C)	3750	Tan	Low viscosity for high flow rate, increased production. Good hot tack, quick grab for packaging and woodworking.	1/2" x 10" AE	62-3726-9531-2	0-00-051111-91711-4	11	LBS	
		3750	Clear	Low viscosity for high flow rate, increased production. Good hot tack, quick grab for packaging and woodworking.	1/2" x 10" AE	62-3729-9531-6	0-00-051111-91712-1	11	LBS	
	Hot Mel Applied 350-	3762	Tan	Excellent "hot tack", fast setting for corrugated, beadboard, recouperage, repacking chipboard and wood. Economical, general purpose.	5/8" x 8" Q 5/8" x 2" TC 1" x 3" PG 1/2" x 12" AE	62-3762-9132-4 62-3762-9830-3 62-3762-9330-4 62-3762-9531-7	0-00-021200-65261-5 0-00-021200-82615-3 0-00-021200-82614-6 0-00-021200-82596-5	11 11 22 11	LBS	
	Ϋ́	3764*	Clear	Bonds variety of plastics including polycarbonate, polyethylene, and polypropylene. Flexible at low temperatures.	5/8" x 8" Q 5/8" x 2" TC 1" x 3" PG 1/2" x 12" AE	62-3764-9132-0 62-3764-9830-9 62-3764-9330-0 62-3764-9531-3	0-00-021200-76054-9 0-00-021200-82599-6 0-00-021200-82598-9 0-00-021200-82597-2	11 11 22 11	LBS	
		3779*	Amber	High heat resistance. High strength. Good fuel and oil resistance. Electronics.	5/8" x 8" Q 5/8" x 2" TC 1" x 3" PG	62-3779-9132-8 62-3779-9830-7 62-3779-9330-8	0-00-021200-85799-7 0-00-021200-82603-0 0-00-021200-82602-3	11 11 22	LBS	
		3789 ★ Brown High performance for plastics. Impact resistant. Bonds vinyl and wood. Good fuel and oil resistance.		5/8" x 8" Q 1" x 3" PG	62-3789-9132-7 62-3789-9330-7	0-00-021200-82369-5 0-00-021200-82371-8	11 22	LBS		
		3792*	Clear	Clear, multi-purpose for wood, corrugated, fabric, furniture, upholstery, novelties, and other lightweight materials.	5/8" x 8" Q 5/8" x 2" TC 1" x 3" PG 1/2" x 12" AE	62-3792-9132-1 62-3792-9830-0 62-3792-9330-1 62-3792-9531-4	0-00-021200-65263-9 0-00-021200-82589-7 0-00-021200-82606-1 0-00-021200-82583-5	11 11 22 11	LBS	
		3797	Off- White	High ball and ring. Low viscosity. Good for electrical potting.	1" x 3" PG 5/8" x 2" TC	62-3797-9330-0 62-3797-9830-9	0-00-021200-82592-7 0-00-021200-82593-4	22 11	LBS	
Ī		3794 Hi Tack PSA	Light Tan	Sprayable high tack PSA for bonding plastic, paper, metals, die-cut labels.	Bulk chubs	62-3794-6375-5	0-00-051115-81205-7	30	LBS	
	۷Įu	6111	Tan	Sprayable 100% solventless adhesive for most foams, fabrics, plastics, particle board and thin metal.	0.75" x 0.75" chips	62-6111-9335-0	0-00-021200-96589-0	22	LBS	
	Bulk Only	6111HT	Tan, Blue	Similar to 6111 but has higher heat resistance. Available in tan and blue.	0.75" x 0.75" chips	62-6115-9335-1 62-6113-9335-6 62-6113-9339-8 62-6115-9339-3	0-00-021200-49935-7 0-00-021200-43779-3 0-00-021200-56567-0 0-00-021200-56568-7	22 22 850 850	LBS	
		6116	Off- White	Similar to 6111 but lower than normal viscosity and mainly used on fabrics.	0.75" x 0.75" chips	62-6116-9335-9	0-00-021200-49924-1	22	LBS	

^{*}Also available in bulk.

^{1 -} Made from components listed as indirect food additives under FDA regulations for adhesives (21 CFR 175.105) 2 - Brookfield Thermosel Viscometer in Centipoise

^{3 –} ASTM E-28-6-7 4 – Highest temperature that the adhesive will support a 2 psi dead load 5 – Canvas to Douglas Fir 6 – Douglas Fir to Douglas Fir

^{7-1/8&}quot; semicircular bead, Douglas Fir to Douglas Fir

EC Temp Control Modules	Viscosity CPS ²	Delivery Time for 1" x 3" Cartridge (sec.)	Ball & Ring Melt Point ³ °F (°C)	Heat Resistance ⁴ °F (°C)	Peel Strength PIW ⁵ 72°F (22°C)	Shear Strength PSI ⁶ 72°F (22°C)	Open Time 1/8" Bead ⁷ (sec.)	FDA Listed ¹	UL 94 Listing
1	4,000 @ 250°F	45	205 (96)	130 (54)	6	480	25	Yes	n/a
1	8,250 @ 250°F	47	184 (84)	140 (60)	9	600	40	_	n/a
1	10,500 @ 250°F	57	178 (81)	140 (60)	13	350	40	Yes	V2
n/a	9,500 @ 250°F	n/a	191 (88)	120 (49)	n/a	n/a	30	Yes	n/a
5	12,000 @ 375°F	n/a	315 (157)	265 (130)	22	490	30	-	n/a
4	2,875 @ 375°F	35	186 (86)	130 (54)	13	375	50	Yes	V2
4	4,100 @ 375°F	45	220 (104)	145 (63)	20	430	45	Yes	n/a
4	5,000 @ 375°F	65	292 (144)	175 (79)	18	250	45	Yes	V2
4	5,000 @ 375°F	65	305 (152)	175 (79)	15	275	30	-	VO
n/a	1,900 @ 375°F	30-40	200 (93)	125 (52)	6	500	n/a	_	n/a
n/a	4,800 @ 375°F	35–45	178 (81)	135 (57)	12	250	n/a		n/a
3	1,870 @ 375°F	30	201 (94)	130 (54)	7	545	35	Yes	V2
4	6,000 @ 375°F	55	190 (88)	140 (60)	14	390	40	Yes	V2
5	7,000 @ 375°F	75	325 (163)	300 (149)	18	700	25	Yes	n/a
5	5,200 @ 375°F	70	270 (132)	220 (104)	16	570	50	Yes	V2
4	5,000 @ 375°F	45	179 (81)	140 (60)	13	250	50	Yes	V2
n/a	2,650 @ 375°F	55	304 (151)	170 (77)	10	350	30	Yes	V2
n/a	15,000 @ 325°F	n/a	224 (107)	120 (49)	16	n/a	> 60	Yes	n/a
n/a	3,000- 5,000 @ 375°F	n/a	224 (107)	145 (63)	34	n/a	1 surface: 60 2 surface: 360	_	n/a
n/a	2,500- 4,500 @ 375°F	n/a	284 (140)	175 (79)	26	n/a	1 surface: 180 2 surface: 480	_	n/a
n/a	1,300 @ 375°F	n/a	199 (93)	160 (69)	20	n/a	1 surface: 120 2 surface: 300	-	n/a

3M™ Hot Melt Applicator System Guide

3M Hot Melt Applicators Systems are trusted solutions that are engineered to help you improve productivity, lower cost and minimize waste in industrial applications. From high volume to detail work, 3M Hot Melt Applicators are uniquely designed to ensure optimum performance through melt-on-demand or progressive feed technology for your production needs.



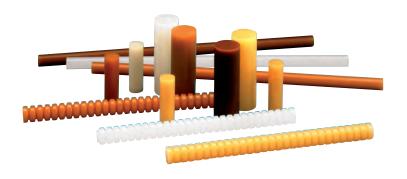
Adhesives Size Selection

3M™ Hot Melt Adhesives are designed and precisely manufactured for use in a 3M Hot Melt Applicator. When paired together, they work as a system, providing optimal performance for your design needs. Use the guide to select the right size for your application.

Select a 3M™ Hot Melt Applicator to fit your needs.

	Adhesive Type	Product/Cat #	Weight¹	Output ² (Ib/hr)	Temperature³ °F(°C)	Power (120V)	Adhesive Dia. x L (in.)	Sticks per Pound	Linear Feet per Stick	Stock Number	UPC Number	Warranty (Months)
	Low Melt	A 3M [™] Hot Melt Applicator LT (Low Temp)	10.0 oz.	2.6	265 (129)	150W	5/8 × 2 TC	55	8	62-9281-9930-6	0-00-021200-82245-2	12
		B 3M [™] Hot Melt Applicator LT with Quadrack Converter (Low Temp)	13.8 oz.	2.6	265 (129)	150W	5/8 × 8 Q	15	29	62-9281-9950-4	0-00-021200-89447-3	12
		C (1 ave Tamp)	4.3 lbs.	6.0) 265 (129)	500W	1 × 3 PG	12	36 -	Cartridge Feed* 62-9783-9630-7	Cartridge Feed* 0-00-021200-89395-7	12
		(Low Temp)	4.0 105.	0.0			17310	12		Magazine Feed** 62-9783-9830-3	Magazine Feed** 0-00-021200-89396-4	
		D 3M™ Hot Melt Applicator TC	10.0 oz.	3.5	385 (196)	150W	5/8 × 2 TC	55	8	62-9990-9935-1	0-00-021200-82244-5	12
ad duct	±	B 3M™ Hot Melt Applicator TC with Quadrack Converter	13.8 oz.	3.5	385 (196)	150W	5/8 × 8 Q	15	29	62-9990-9950-0	0-00-021200-89445-9	12
	Hot Melt	F 3M™ Hot Melt Applicator PGII	4.3 lbs.	7.5	385 (196)	500W	1 x 3 PC	1×3 PG 12 36	36 -	Cartridge Feed* 62-9938-9630-7	Cartridge Feed* 0-00-021200-22033-3	12
	_	3W Tiot West Applicator Fall	4.0 105.	7.5	365 (190)	300VV	17310			Magazine Feed** 62-9938-9830-3	Magazine Feed** 0-00-021200-22034-0	12
		G 3M™ Hot Melt Applicator AEII	20.0 oz.	4.0	400 (204)	100W	1/2 × 10 AE 1/2 × 12 AE	19 14	23 30	62-9796-9930-3	0-00-021200-96594-4	6
	Low Melt or Holt Melt	H 3M™ Hot Melt Applicator EC	24.0 oz.	5.5	260-450 (127-232)	350W	5/8×8Q	15	29	62-9680-9930-9	0-00-021200-89519-7	12

- * Cartridge Feed holds up to 2 adhesive sticks (1" x 3") and the applicator holds 3 more in the chamber for a total of 5.
- ** Magazine Feed holds up to 9 adhesive sticks (1" x 3") and the applicator holds 3 more in the chamber for a total of 12.
- 1 Weight shown is for applicator only; does not include adhesive capacity.
- 2 Adhesive output will vary with conditions and the adhesive used. Values are approximate and are based on maximum steady-state flow.
- 3 Temperatures shown are nominal control values. Actual temperature will range slightly above and below this value.





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

Note: Repair parts are available. Reference owner manuals for information.

Accessories to improve productivity.

3M™ Hot Melt Applicator Accessories and Parts are designed to offer versatility, when dispensing 3M Hot Melt Adhesives. Uniquely designed for 3M Hot Melt Applicators, these accessories and parts maximize the use of 3M Hot Melt Adhesives by improving productivity, optimizing precision, and reducing waste in your assembly process.



Product/Cat #		Description	Stock Number	UPC Number	Case Qty	Billing Unit
9725*		.072" Mini Extension Tip	62-9725-9930-2	0-00-021200-21786-9	3	CS
9726*	. 00	"T" Tip Assembly	62-9726-9930-0	0-00-021200-64542-6	3	CS
9727*	9726 9725	"L" Tip with Adapter	62-9727-9930-8	0-00-021200-64543-3	3	CS
9729*		High Viscosity Valve (TC, EC, PG II)	62-9729-9930-4	0-00-021200-64840-3	3	CS
9785*		.07" Tapered Aluminum Extension	62-9785-9930-6	0-00-021200-82554-5	3	CS
9913*	9727 9729	2-hole Spreader	62-9913-9930-4	0-00-021200-21830-9	3	CS
9916*	9785	3-hole Spreader	62-9916-9930-7	0-00-021200-21836-1	3	CS
9917*		3-hole 1" Spreader	62-9917-9930-5	0-00-021200-21837-8	3	CS
9921*	9913 9916 9917	.090" Fluted Tip	62-9921-0066-9	0-00-021200-21840-8	3	CS
9922*		.063" Fluted Tip	62-9922-0066-7	0-00-021200-21841-5	3	CS
9940*	9921 9922 9940 9946	.125" Fluted Tip	62-9940-6920-1	0-00-021200-22036-4	3	CS
9946		.072" Brass Extension	62-9946-6980-2	0-00-021200-22040-1	3	CS

^{*}Tip works with all $3M^{\mbox{\tiny M}}$ Hot Melt Applicators except $3M^{\mbox{\tiny M}}$ Hot Melt Applicator AEII.

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Product/Cat #		Description	Stock Number	UPC Number	Case Qty	Billing Unit
9945 PGIIBhSd 3M" Hot Melt Applicator		For use with PG II and PG II LT	62-9945-9930-6	0-00-021200-22039-5	1	CS
Heavy Duty Benchstand		For use with EC, TC and LT	62-9945-9935-5	0-00-021200-82418-0	1	CS
9276 3M" Hot Melt Applicator Bench Mount		Includes bench nozzle assembly (Does not include applicator)	62-9276-9930-6	0-00-021200-82277-3	1	CS
9233 3M" Hot Melt Applicator PGII and PGIILT Bench Mount Assembly	6	For use with bench mounted applicator	62-9233-2781-1	0-00-021200-21713-5	1	CS
9277 3M [™] Hot Melt Applicator Foot Pedal Assembly		For use with bench mounted applicator	62-9277-9930-4	0-00-021200-82278-0	1	CS
9761 3M [™] Hot Melt Applicator TC Palm Trigger		For use with Quadrack converter	62-9761-9930-7	0-00-021200-82701-3	10	CS
9275 3M [™] Hot Melt Applicator Quadrack Converter	E THE	To add Quadrack capability to TC and LT applicators	62-9275-9935-7	0-00-021200-83536-0	10	CS
9234 PG ASSY 3M" Hot Melt Applicator TC/EC/LT Valve Assembly Kit		Nozzle and valve replacement for TC, EC, LT	62-9234-9930-5	0-00-021200-21714-2	1	CS

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For more products and information, visit 3M.com/HotMeltAdhesives or call 1-800-362-3550

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, CUSTOM 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.



3M Industrial Adhesives and Tapes Division 3M Center, Building 225-3S-06 St. Paul, MN 55144-1000

Phone 800-362-3550 Fax 877-369-2923

Web 3M.com/HotMeltAdhesives

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