

# 3M™ Dry Layup Adhesive 2.0 W7900

## Product Description

3M™ Dry Layup Adhesive 2.0 is a sprayable, soluble synthetic elastomer based adhesive designed for bonding/holding glass fabrics and roving, other reinforcements and other materials (i.e. flow media) in place during the infusion process.

**Note:** The data presented in this preliminary data sheet are 3M's best estimates for the current product construction being evaluated. While this product is being developed for general commercialization, this product is still considered developmental at this time and change in product construction or process conditions may occur that can cause subsequent changes in product characteristics or performance. User should consult with 3M before making any business plans in reliance upon the future availability or the current properties of this product.

## Features

- Fast tacking
- Work time range from 1 second to 30 minutes
- Green color allows control of the application level
- Robotic application possible
- Color-change technology

## Typical Physical Properties

Properties	Aerosol	Bulk
Base	Soluble synthetic elastomer	Synthetic elastomer
Solvents	Aliphatic hydrocarbon, Acetone, cyclohexane	Aliphatic hydrocarbon, Acetone, cyclohexane
Color (dry)	Green	Green
Solids (by weight.)	19–21%	26–28%
Specific Gravity (Ref std: water = 1)	0.8	0.9
Flash Point (TCC) (Test Method: Tagliabue Closed Cup)	-156.0°F (-104.4°C)	-4.0°F (-20.0°C)
Hazardous Air Pollutants	No	No
VOC (Less H <sub>2</sub> O & Exempt Solvents)	<25%	< 341 g/L
CARB Compliant	Yes	No

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

Read and follow the precautions on label and SDS before using product.

## Directions for Use

### Surface Preparation

Adhesive and surfaces to be bonded should be at 65°F (18°C) or above. For best results all surfaces to be bonded must be clean, dry and free from dirt, dust, oil, wax or grease, etc.

### Typical Application Level\*

- 0.5 g/ft<sup>2</sup> (5.4 g/m<sup>2</sup>)
- Color target is very light green
- Do not apply excess adhesive. (Higher amounts of adhesive could affect composite properties and infusion process.)

\* Typical Application Level is provided for reference purposes only. Customer must define and control the proper amount for each specific application. See Caution statement.

### Application – Aerosol

1. Shake can before using.
2. Turn spray tip so arrow points to dot on rim of can (always point spray tip away from yourself and others).
3. Hold can 8–14 inches (20–25 cm) from surface to be sprayed to obtain 4" (10 cm) spray pattern. Target color is very light green.

Upright orientation of can should be maintained during application.

Can should be moving before the nozzle is pressed and after it is released to avoid over application at start and stop of spraying.

Move can horizontally without overlap of spray pattern.

Keep finger and glove out of the way of the spray pattern to avoid splatter and nozzle clogging.

4. Apply a light, uniform coat of adhesive to one surface to be bonded.
5. Make bond while adhesive is tacky.
6. Join surfaces with firm pressure.
7. After use, invert can and depress spray tip until spray is free of adhesive.

### Application – Bulk

1. Mix adhesive thoroughly before using by agitating adhesive container.
2. Using spray equipment, apply a light, uniform coat of adhesive to one surface to be bonded. Target color is very light green. See options for bulk application listed below. **Brushing or rolling is not recommended.**
3. Make bond while adhesive is tacky.
4. Join surfaces with firm pressure.

## Application Equipment Suggestions for Bulk

Product Name	Quantity
3M™ PPS™ Paint Protection System with 3M Spray Gun**	1/case
Pressure Pot System with 3M Spray Gun**	1/case
Bulk Pumping System with 3M Spray Gun**	1/case

** Spray Gun Options	Air Cap	Fluid Nozzle in. (mm)	Inlet Air (psi)
3M™ Spray Gun Series 12S /12SZ	7 or 9	.05 or .06 (1.3 or 1.5)	25
3M™ Accuspray™ HG18	1.8	0.07 (1.8)	20

\*\* Spray gun properties are for reference purposes only. Customer must define and control the proper amount for each specific application. See caution statement.

## Caution

The customer is responsible for evaluating the impact of the 3M™ Dry Layup Adhesive 2.0 W7900 on the mechanical properties of their composite to confirm it meets their performance requirements. Applying the proper amount of Dry Layup Adhesive is important. Do not apply excessive adhesive – excess amounts could affect composite properties and infusion process. Customers are responsible for implementing controls, such as visual standards or robotic application, to ensure the proper application level suitable to the customer’s application.

## Use Restrictions

Local air quality regulations may manage or prohibit the use of surface preparation and cleanup materials based on VOC content. Consult Federal, state and local air quality rules before use.

Bulk product not for sale or use in: California, Connecticut, Delaware, Georgia\*, Illinois\*, Indiana\*, Maine, Maryland, Massachusetts, New Hampshire, New Jersey, New York, North Carolina, Ohio\*, Pennsylvania, Rhode Island, Texas\*, Utah, Virginia\*, and Washington DC.

\* some areas

## Packaging

Available Sizes
Aersol Spray (net weight: 14.7 oz (418g))
Bulk (5 gallon pail)

## Storage

Store product at 60–80°F (16–27°C) for maximum storage life. Higher temperatures can reduce normal storage life. Lower temperatures can cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis.

## Shelf Life

When stored at the recommended conditions in the original, unopened container this product has a shelf life of 15 months from date of shipment.

**Caution:** Contact your 3M representative for information on 3rd party testing.

<b>United States</b> 800 755 2654	<b>Spain</b> 34 91 3216000	<b>Italy</b> 39 02 70351	<b>South Korea</b> 82 2 3771 4043	<b>Brazil</b> 0800 13 23 33	<b>Japan</b> 81 3 3709 8283
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For more information on our wind energy product line, contact 3M Renewable Energy at 800 755 2654 or visit us at [3M.com/wind](http://3M.com/wind).

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