



# Scotch-Weld™ 3747 Adhesive

## Product Data Sheet

Updated : April 2008  
Supersedes : March 1996

**Product Description** Scotch-Weld Adhesive 3747 is a high performance general purpose adhesive with good heat resistance and flexibility. Scotch-Weld 3747 exhibits good adhesion to a wide variety of substrates such as hard and soft woods, fabric, rigid and flexible foams, ABS, GRP, Polycarbonate and PVC.

### Physical Properties

Not for specification purposes

<b>Base</b>	EVA	
<b>Colour</b>	Tan	
<b>Viscosity</b> cP at 190°C 1	4100	
<b>Temperature Control Setting</b>	4	
<b>FDA Accepted</b> 2	Yes	
<b>Sizes Available</b>	26 x 73 mm for the Scotch-Weld Air Powered Applicator. 15 x 203 mm for the Scotch-Weld Touch Control Quadrack Applicator. 15 x 48 mm for the Scotch-Weld Touch Control Applicator. 12 x 300 mm for the Scotch-Weld All Electric Applicator.	
<b>Shelf Life</b>	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	
1 Brookfield Thermosel Viscometer. 2 FDA Reg. 175.105 (adhesives) CFR Title 21.		

### Performance Characteristics

Not for specification purposes

<b>Delivery Rate for 26 x 73 mm slug</b>	45 seconds	
<b>Ball and Ring Softening Point</b> 3	104 °C	
<b>Heat Resistance</b>	63 °C	
<b>Impact Resistance</b>	11 in/lbs at -18°C 25 in/lbs at 22°C	

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<b>Peel Strength at 22°C</b> 4	35 N/10mm	
<b>Shear Strength at 22°C</b> 5	2.9 MPa	
<b>Tensile Strength at 22°C</b>	5.1 MPa	
<b>Elongation</b>	1300 %	
<b>Bonding Range 3mm bead</b> 6	45 seconds	
<b>3</b> ASTM E-28-6-7. <b>4</b> On Canvas. <b>5</b> On Douglas Fir. <b>6</b> 3mm semi circular bead, Douglas Fir to Douglas Fir.		

### 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.



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