



# Hot Melt Stick & Applicator Guide

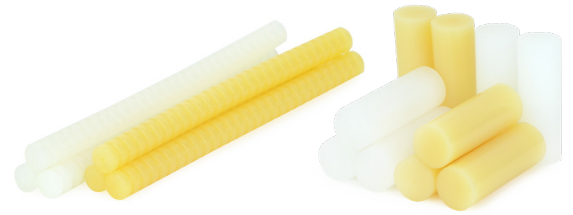
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ADHESIVES



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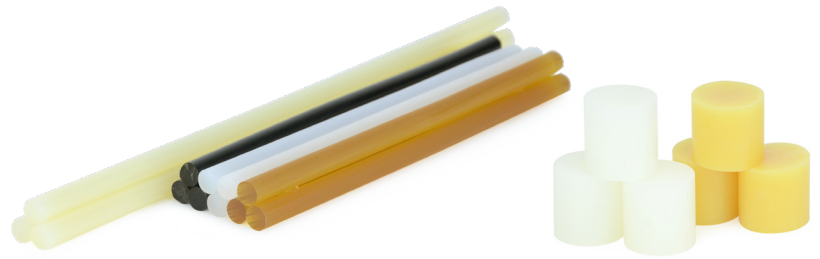
3M	Description & Application	Color / Chemistry	Appl. Temp (°F)	Open Time	Sizes
3762LM	Excellent hot tack, fast setting for corrugated, beadboard, and re-sealing boxes. Economical, general purpose low melt.	Light Amber / EVA	250 - 270	25 seconds	5/8" x 2" TC 5/8" x 8" Q 1" x 3" PG
3776LM	Low melt for bonding a variety of plastics, woods, and light gauge metals.	Tan / EVA	250 - 270	40 seconds	5/8" x 8" Q 1" x 3" PG
3792LM	Multipurpose low melt for wood, coated paper, polyolefins, and heat sensitive substrates. ULV2.	Clear / EVA	250 - 270	40 seconds	5/8" x 2" TC 5/8" x 8" Q 1" x 3" PG
3798LM	Removable low melt for use on many substrates.	Light Yellow/ EVA	250 - 270	30 seconds	5/8" x 2" TC
3731	Plastic bonder for polyethylene and polypropylene with high heat resistance.	Tan / Polyolefin	350 - 385	30 seconds	5/8" x 8" Q 1" x 3" PG
3738	General purpose for foundry sand cores, wood bonding, corrugated, some plastics, and chipboard. ULV2.	Tan / EVA	350 - 385	50 seconds	1/2" x 12" AE 5/8" x 2" TC 5/8" x 8" Q 1" x 3" PG
3747	General purpose for a wide variety of plastics, wood, and lightweight metals.	Tan / EVA	350 - 385	45 seconds	1/2" x 12" AE 5/8" x 2" TC 5/8" x 8" Q 1" x 3" PG
3748	Good thermal shock resistance. Non-corrosive to copper for many electronic applications. Bonds to polyolefin. ULV2.	Off-White / Polyolefin	350 - 385	45 seconds	5/8" x 2" TC 5/8" x 8" Q 1" x 3" PG
3748VO	Self-extinguishing version of 3748. Meets UL 1410. ULV0.	Light Yellow / Polyolefin	350 - 385	30 seconds	5/8" x 2" TC 5/8" x 8" Q 1" x 3" PG
3750	Low viscosity for high flow rate, increased production. Good hot tack, quick grab for packaging and woodworking.	Tan or Clear / EVA	350 - 385	N/A	1/2" x 10" AE
3762	Excellent hot tack, fast setting for corrugated, beadboard, re-sealing boxes, and re-packing chipboard and wood. ULV2.	Tan / EVA	350 - 385	35 seconds	5/8" x 2" TC 5/8" x 8" Q 1" x 3" PG
3764	Bonds a wide variety of plastics including polycarbonate, polyethylene, and polypropylene. Flexible at low temperatures. ULV2.	Clear / EVA	350 - 385	40 seconds	5/8" x 2" TC 5/8" x 8" Q 1" x 3" PG
3779	High heat resistance, high strength. Good fuel and oil resistance. Electronics applications. ULV0.	Amber / Polyamide	350 - 385	25 seconds	5/8" x 2" TC 5/8" x 8" Q 1" x 3" PG
3789	High performance for plastics. Good impact resistance. Bonds vinyl and wood. Good fuel and oil resistance. ULV2.	Brown / Polyamide	350 - 385	50 seconds	5/8" x 8" Q 1" x 3" PG
3792	Multi-purpose for wood, corrugated, fabric, furniture, upholstery, novelties, and other light weight materials. ULV2.	Clear / EVA	350 - 385	50 seconds	5/8" x 2" TC 5/8" x 8" Q 1" x 3" PG
3797	High ball and ring. Low viscosity, good for electrical potting. ULV2.	Off-White / Polyolefin	350 - 385	30 seconds	5/8" x 2" TC 1" x 3" PG



Bostik	Description & Application	Color / Chemistry	Appl. Temp (°F)	Open Time	Sizes
HM0130	Medium open time, used for general assembly bonds and difficult substrates, including ABS. Improved resistance to yellowing and UV exposure.	Semi-Clear / EVA	350 - 400	30 seconds	½" x 10"
HM0720	Highly versatile, bonds to a wide variety of substrates at low temperatures. Good for open or closed-cell foams, styrene, and EPS for specialty packaging.	Semi-Clear / EVA	280 - 400	20 - 30 seconds	½" x 15" 1" x 3"
HM2107	Tough, versatile adhesive with low odor for packaging, furniture assembly, some plastic bonding (porous substrates).	Straw / EVA	392	20 seconds	½" x 10" 1" x 3"
HM2109	Long open time, medium setting, good wettability and flexibility. Good hot tack for corrugated and packaging applications.	Tan / EVA	300	20 - 30 seconds	½" x 10" 1" x 3"
HM2124	Excellent adhesion to many substrates, long set time, flexible for porous and non-porous substrates.	Translucent / EVA-PE	350 - 400	30+ seconds	½" x 10" or 15" 1" x 3"
HM6239	Long open time with high and low temperature resistance, flexibility and resistance to plasticizer migration for vinyl bonding.	Amber / Polyamide	350 - 400	75 seconds	½" x 10"
HM6305	Economical, fast setting adhesive for packaging applications. Excellent quick-tack and good heat resistance for packaging. Adheres to a wide variety of coated and uncoated board stocks.	Pale Yellow / EVA	335 - 360	3 - 8 seconds	½" x 15"
HM6327	Craft, floral, hobby, and other general assembly. Flexible bonds to porous substrates like woods, fabrics, carpeting, and some plastics.	Translucent / EVA	350 - 400	20 - 30 seconds	½" x 15"
HM6363	General assembly and automotive applications. All purpose, high performance, flexible bonds to many substrates for product assembly of dissimilar or difficult materials to bond.	Pale Yellow / EVA	350 - 400	40+ seconds	½" x 15"
HM6368	Short open time with good shear strength and good adhesion to porous materials. High viscosity with wide temperature resistance. For demanding packaging, product assembly, and repair applications.	Light Amber / PE Blend	350 - 400	5 - 10 seconds	½" x 15"
HM6390	Medium open time for general assembly. Bonds well to a variety of substrates, including ABS, lexan, polyethylene, and phenolics.	Pale Yellow / EVA	350 - 400	20 - 30 seconds	½" x 15"

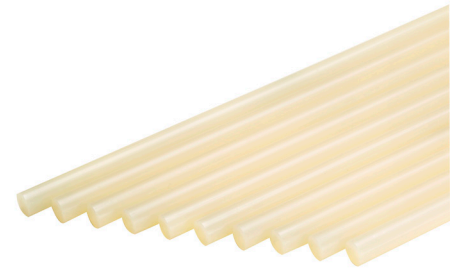


elemelt®



Elemelt	Description & Application	Color / Chemistry	Appl. Temp (°F)	Open Time	Sizes
HMS425	APAO with a long open time for bonding foam to foam, foam to fabric, and other porous substrates. Can be extruded or sprayed.	Off-White / APAO	350 - 375	3 - 7 minutes	½" x 10" ⅝" x 15"
HMS600	General purpose. Bonds many woods & wood composites for woodworking & cabinetry.	Amber / EVA	350 - 400	40 - 50 seconds	½" x 10" or 15"
HMS601	Low melt for packaging & carton sealing. Bonds to most porous materials.	Tan / EVA	250 - 300	5 seconds	½" x 10" or 15" ⅝" x 10" ⅝" x 8" Quad
HMS701	Fast set for corrugated carton sealing. Low temperature resistance. Bonds most porous materials (wood, paper, cloth).	Amber / EVA	250 - 380	15 seconds	½" x 10" or 15" ⅝" x 10" 1¼" x 1¼" ⅝" x 8" Quad 1" x 3"
HMS702	Fast set for corrugated carton sealing & small packaging. Good adhesion to some corrugated packaging & paper products.	Amber / EVA	250 - 380	5 seconds	½" x 10" or 15"
HMS707	High performance for difficult substrates (porous or non-porous). Bonds glass, leather, metals, magnets, ceramics, wood, ABS, PVC, & some vinyls.	Clear or Black / EVA	380	30 seconds	½" x 10" or 15" ⅝" x 10"
HMS711	Excellent hot tack, fast set packaging. Good adhesion to plain & some corrugated packaging.	Tan / EVA	380	5 - 10 seconds	½" x 10" or 15" ⅝" x 10" 1" x 3"
HMS735	High strength for metal, plastics, & non-porous substrates. Bonds leather, wood, ceramic, & non-porous materials.	Amber / EVA	325 - 380	25 seconds	½" x 10" or 15" ⅝" x 10" 1" x 3"
HMS739	High strength wood bonder & dent remover. Bonds metals, plastics, ceramics, & non-porous materials.	Amber / EVA	325 - 380	25 seconds	½" x 10" or 15"
HMS748	Polyamide bonder for most plastics & woods (high temperatures) & paper, fabric, & ribbons (low temperatures). Resistant to oils, transmission fluids, brake fluid, & fuels.	Amber or Black / Polyamide	275 - 380	15 seconds	½" x 10" or 15"
HMS800	General purpose with excellent hot tack for packaging. Strong bonds to most papers & other porous materials.	Translucent / EVA	350 - 400	25 - 35 seconds	½" x 10" or 15"
HMS900	General purpose for assembly of plastics & woods at high temperatures. Bonds to porous & non-porous materials at low temperatures.	Clear / EVA	250 - 380	60 seconds	½" x 10" or 15" ⅝" x 8" Quad 1" x 3"
HMS925	High performance acrylic with long open time. Makes flexible bonds on hard-to-bond substrates like concrete, metal, wood, vinyl, glass, and ceramic.	Clear / Acrylic	350 - 390	60 seconds	½" x 10"





Power Adhesives	Description & Application	Color / Chemistry	Appl. Temp (°F)	Open Time	Sizes
5	High delivery, low viscosity. Long open time for product assembly.	Light Brown / Synthetic Polymer	266 - 383	Long	½", 1 ¾"
14	High delivery, very fast setting packaging adhesive.	Pale Amber / Synthetic Polymer	320 - 383	Short	½", ⅝", 1 ¾"
1942	Product assembly adhesive for wood and many plastics	Amber / Synthetic Polymer	320 - 386	Long	½", ⅝", 1 ¾"
1X	Medium viscosity, wood working and packaging adhesive.	Light Brown / Synthetic Polymer	356 - 383	Medium	½", 1 ¾"
213	Economical, general purpose adhesive. Suitable for ceramics, rigid PVC, & polystyrene.	Pale Amber / Synthetic Polymer	383	Long	½", ⅝", 1 ¾"
214	Economical, fast setting packaging adhesive.	Pale Amber / Synthetic Polymer	383	Short	½", ⅝", 1 ¾"
23	Medium viscosity multi-purpose adhesive. For fabric, hard and soft wood, and plastics.	Pale Amber / Synthetic Polymer	383	Long	½", ⅝", 1 ¾"
232	Economical, high viscosity, general purpose adhesive. For fabrics, wood, cardboard, and plastics.	Clear / Transparent Synthetic Polymer	383	Medium	½", ⅝", 1 ¾"
240	Multi-temperature, long open time, multi-purpose. For many plastics and light gauge metals.	Clear & 12 Colors / Synthetic Polymer	380	Long	½", ⅝", 1 ¾"
246	High performance adhesive for painted, varnished, and other smooth surfaces.	Clear or Black / Synthetic Polymer	383	Medium	½"
248	Very high performance, acrylic based adhesive. Excellent adhesion to smooth and shiny surfaces.	Clear / Acrylic	383	Long	½", ⅝", 1 ¾"
260	High performance, long open time, tough, and flexible. For ceramics, plastics, and woods.	Light Brown / Synthetic Polymer	383	Long	½", ⅝", 1 ¾"



Power Adhesives	Description & Application	Color / Chemistry	Appl. Temp (°F)	Open Time	Sizes
261	High performance, tough, and flexible. For use with ceramics and plastics (PP/PE), and woods.	Pale Amber / Synthetic Polymer	380	Long	½", 1 ¾"
263	Polypropylene bonding with high heat resistance.	Light Brown / Synthetic Polymer	374 - 392	Short	½"
341	Medium viscosity, fast setting with instant grab. Suitable for packaging and woodworking.	White / Synthetic Polymer	380	Short	½", ⅝", 1 ¾"
342	High viscosity, fast setting with instant grab. Suitable for heavy duty carton board & cable attachment.	White / Synthetic Polymer	383	Very Short	½", 1 ¾"
LM44	Low melt, fast setting, high performance. Ideal for expanded polystyrene, thin films, and balloons.	White / Synthetic Polymer	266 - 320	Short	½", 1 ¾"
410	Pallet stabilization spray adhesive, also used for expanded polystyrene assembly and position fixing.	Off-White / Synthetic Polymer	380	Up to 1 minute	1 ¾"
420	General purpose, extended open time spray adhesive. Used for bonding packaging foams, bubble film, vacuum foamed moldings, upholstery foams, cotton backed vinyl, and many other fabrics.	Off-White / Synthetic Polymer	380	Up to 3 minutes	1 ¾"
425	High performance, extended open time adhesive. Used for bonding wood, fabrics, most plastics, some metals, and concrete with a good delivery rate.	Dark Amber / Synthetic Polymer	380	Up to 3 minutes	1 ¾"
430	Very long open time spray adhesive. Aggressive to produce tough resilient bonds. Suitable for use on plastics, foams, wood, and cardboard.	Amber / Synthetic Polymer	380	Up to 6 minutes	1 ¾"

# LOCTITE



Loctite	Description & Application	Color / Chemistry	Appl. Temp (°F)	Open Time	Sizes
PA 7460	Formulated for spray applications. High heat resistance, fast set time. Suitable for bonding foams, fabrics, wood, and more.	Pale Amber / Polyamide	350 - 400	30 seconds	1 3/4" Polyshot
PA 7804	Tough, elastomeric high performance adhesive with excellent impact at low temperatures. Bonds to metals, wood, plastics, leather, fabric, non-woven fabric, and foils. Good for gap filling.	Amber / Polyamide	350	35 seconds	1/2" x 10" Supersticks 1 3/4" Polyshot
PA 7809FR	Tough, high performance adhesive modified with FR materials. Bonds many difficult substrates like metals, plastics, wood, leather, fabric, non-woven fabric, films, and foils. UL 94-V0.	Amber / Polyamide	400 - 450	35 seconds	1/2" x 10" Supersticks 1 3/4" Polyshot
0430	Spray adhesive for bonding expanded polystyrene, polyethylene, or urethane foams. Good for replacing aerosols.	Cream or Red / EVA	350	3.5 minutes	1 3/4" Polyshot
0450	Spray adhesive with aggressive bond for expanded polystyrene or urethane foams, corrugated, wood, fabrics, and plastics.	Natural or Red/ Polyolefin	350	5 to 8 minutes	1 3/4" Polyshot
1942	General purpose for bonding wood, nylon, polycarbonate, PVC, polystyrene, ABS, and acrylic.	Tan / EVA	350	30 seconds	1/2" x 10" Supersticks 1 3/4" Polyshot
232	Medium setting adhesive recommended where clear, tough, flexible materials are required. Suitable for plastic, porous surfaces such as paper, plastic, and wood.	Clear / EVA	350	15 seconds	1/2" x 10" Supersticks 1 3/4" Polyshot
1X	Medium to fast setting adhesive recommended for porous substrates such as paper, wood, fabric, non-wovens, and foam.	Yellow / EVA	350	15 seconds	1/2" x 10" Supersticks 1 3/4" Polyshot
740LV	Fast setting adhesive for packaging and fabric reinforcing applications.	Yellow / EVA	350	10 seconds	1 3/4" Polyshot



# Stick & Applicator Reference Chart

Hot Melts	Applicators				
<p>½" x 10" or 15"</p> 	<p>Ellsworth Adhesives EA100-12</p> 	<p>Power Adhesives 806-12</p> 	<p>Fastenmaster HB220</p> 	<p>Surebonder Pro9700A</p> 	<p>Surebonder MGG-450</p> 
	<p>Bostik TG-4</p> 	<p>Bostik Thermogrip TG-560</p> 	<p>3MAE II</p> 	<p>Ad-Tech Pro 200</p> 	
<p>⅝" x 10" or 15"</p> 	<p>Ellsworth Adhesives EA100-58</p> 	<p>Surebonder Pro2-500</p> 	<p>Power Adhesives 806-15</p> 	<p>Power Adhesives 820-15</p> 	<p>Surebonder MGG-500</p> 
<p>1" x 3"</p> 	<p>3M PG II Applicator</p> 				
<p>1¾" x 1¾"</p> 	<p>Power Adhesives Tec 3400 Extrude</p> 	<p>Power Adhesives Tec 6100 Extrude</p> 	<p>Power Adhesives Tec 7100 Extrude</p> 	<p>Power Adhesives Tec 6300 Spray</p> 	<p>Power Adhesives Tec 7300 Spray</p> 
<p>⅝" x 8" Quad</p> 	<p>3M EC Applicator</p> 	<p>3M TC w/Quadrack</p> 			

# Compatible Nozzle Chart

Nozzle	Nozzle Diameter / Outlet mm/inch (ID)	Nozzle Length mm/inch	Thread Size (inch)	Description
Power Adhesives ADJ012 	6.0 / 2.3 wide	30 / 1.2	7/16 UNF	Ball Valve Steel / Ribbon Extension Copper Nozzle
Power Adhesives ADJ013 	3.0 / .11 orifice	30 / 1.2	7/16 UNF	Ball Valve Steel / Angled Extension Copper Nozzle
Power Adhesives ADJ014 	1.25 / .049 orifice	30 / 1.2	7/16 UNF	Ball Valve Steel / Precision Extension Copper Nozzle
Power Adhesives ADJ023 	3.5 / .13 orifice	15 / .60	7/16 UNF	Ball Valve Steel Hub / Standard Aluminum Nozzle
Power Adhesives ANZ016 	2.0 / .13 orifice	15 / .60	7/16 UNF	Ball Valve Steel Hub / Standard Aluminum Nozzle
Power Adhesives ADJ010 	2.0 / .08 orifice	12 / .47	7/16 UNF	Ball Valve / Standard Aluminum Nozzle
Power Adhesives MDJ016 	2.0 / .08 orifice	12 / .47	7/16 UNF	Oiler Valve / Standard Aluminum Nozzle
Power Adhesives MDJ018 	1.25 / .05 orifice	5 / .20	7/16 UNF	Oiler Valve / Standard Aluminum Nozzle with Copper Tip
Power Adhesives MDJ019 	5.0 / .08 width	12 / .47	7/16 UNF	Oiler Valve / Short Aluminum Nozzle with Copper Ribbon Tip
Power Adhesives MDJ021 	2.0 / .08 orifice	19 / .74	7/16 UNF	Ball Valve / Standard Aluminum Extension Nozzle

# Compatible Nozzle Chart

Nozzle	Nozzle Diameter / Outlet mm/inch (ID)	Nozzle Length mm/inch	Thread Size (inch)	Description
 <p>FastenMaster PA-10-SPN28</p>	2.0 / .07 orifice	57 / 2.2	7/16 UNF	Ball Valve Steel Hub / Angled Injection Steel Nozzle
 <p>Surebonder MNR-23</p>	3.0 / .11 orifice	45 / 1.7	7/16 UNF	Ball Valve Steel / Standard Extended Steel Nozzle
 <p>Surebonder MNR-21</p>	3.0 / .11 orifice	38 / 1.5	7/16 UNF	Ball Valve Steel / Standard Short Steel Nozzle
 <p>Surebonder I01 Valve</p>	N/A	N/A	7/16 UNF	Brass Check Valve (Required for I03N, I03R, & I03F Nozzles)
 <p>Surebonder I03N</p>	2.0 / .08 orifice	36 / 1.4	5/16 - 24 UNF	Aluminum Hub / Brass Blunt Extension Nozzle (Requires I01 Valve)
 <p>Surebonder I03R</p>	3.1 / .125 orifice	45 / 1.7	5/16 - 24 UNF	Steel Hub / Brass Angled Extension Nozzle (Requires I01 Valve)
 <p>Surebonder I03F</p>	1.3 / .05 width	45 / 1.7	5/16 - 24 UNF	Steel Hub / Brass Ribbon Extension Nozzle (Requires I01 Valve)
 <p>3M 9234 KIT w/ 9921</p>	9921 Nozzle / 2.2 / .09 orifice	Nozzle 18.5 / .73 Nozzle w/Valve 33 / 1.3	7/16 UNF/ 7/16 UNF	Aluminum Check Valve w/ Steel Fluted Nozzle (For use with 3M EC & TC applicators)
 <p>3M 9729 KIT w/ 9940</p>	9940 Nozzle / 3.1 / .125 orifice	Nozzle 18.5 / .73 Nozzle w/Valve 66 / 2.6	7/16 UNF / 33/64 - 20 UNF	Brass / Aluminum Check Valve w/ Steel Fluted Nozzle (For use with 3M PG II applicator)
 <p>3M 9785</p>	1.7 / .07 orifice	32.5 / 1.27	7/16 UNF	Tapered Aluminum Nozzle
 <p>3M 9946</p>	1.8 / .072 orifice	44.5 / 1.7	7/16 UNF	Brass Nozzle

**3M**



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**LOCTITE**<sup>®</sup>



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