

Adhesive Properties & Formulas

Physical Properties and Performance Characteristics

Heat Resistance 2 lb load Viscosity at 375°F Centipoise Viscosity at 425°F Centipoise Shear Tensile Pine, P.S. 1 Bonding Time Range* Cross Reference Guide

3M Bostik Loctite

053 Amber	Fugitive glue: a tacky, removable adhesive for temporary bonds. Available in 'pillow' forms. 	—	10,800	—	—	Short	3791 LM		
067 Opaque Yellow	New generation Amorphous Polyolefin adhesive sets harder with high temperature resistance. Excellent bond strength on Polypropylene substrates. Available in pellets only. 	215°F (102°C)	11,000	7,000	453	Short			
230 Clear	A clear general purpose production quality hot melt capable of bonding plastics and porous substrates as well as some polyolefins. Provides medium working time of 30-40 seconds.	150°F (66°C)	15,000	7,000	660	Medium	3764		
235 Clear	General purpose, production-quality hot melt, capable of bonding plastics and porous substrates plus some polyolefins.	145°F (63°C)	7,625 33,000 at 280°F	4,500	377	Medium	3764	6374	232
236 Clear	Clear general purpose hot melt capable of bonding many plastics and wood products as well as some polyolefins. Provides a long working time and excellent bond.	130°F (54°C)	8,500	7,000	453	Long			
271 Clear	Excellent hot melt for bonding metals and most plastics. Has outstanding shock resistance even at low temperature. Versatile, with a working time of 35-50 seconds.	134°F (57°C)	6,125	4,000	580	Long	3755	6370	
280 Clear	An extended working time (60-80 seconds) hot melt capable of bonding plastics and porous substrates as well as some polyolefins.	145°F (63°C)	6,500	3,000	640	Long	3792		1238
296 Clear	A hot melt adhesive formulated for spray applications using bulk hot melt equipment. Combines long tack time—up to 9 minutes and high output for bonding large surfaces. Available in pillow form only.	120°F (49°C)	2,400	500	370	Long			
297 Clear	Excellent sprayable, delayed hot melt adhesive. Long open time allows repositioning. A tack time of up to 15 minutes allows bonding of surface areas up to 48 sq. feet. Available in pillow form only.	—	1,600	—	290	Long			
298 Clear	A hot melt adhesive formulated for spray applications using bulk hot melt equipment. Provides a one-minute tack time and high temperature resistance. Available in 4" x 4" blocks only. 	*215°F (102°C) tested with *50 gram load	2,000	800	—	Medium			
610 Tan	A superior adhesive for carton closing. High output, low viscosity adhesive features excellent wetting and rapid set under compression. Ideal for bonding paper and cardboard. 1-3 second compression set.	145°F (63°C)	2,600	800	680	Medium 1-3 Sec. under compression	3762	6368	6002 IX
630 Yellow	Another outstanding adhesive for carton closing. It is a high output, low viscosity adhesive with features similar to our 610 formula. Meets FDA CFR 175.105. 1 second compression set.	160°F (71°C)	1,000		725	Short	3762	8387 6332	QuikPak
650 Opaque Yellow	Medium setting, flexible adhesive formulated for wax-coated cartons. Withstands low temperatures. Meets FDA CFR 175.105 requirements for intermittent food contact. 1 3/4" x 1 3/4" slugs only. 	120°F (49°C)	2,100	800	300	Long			
660 Tan	Low application temp carton-sealing adhesive with superior hot tack and with a 5 second set under compression. In addition, meets the FDA CFR 175.105 requirements.	121°F (49°C)	1,000	9,000 at 225°F	529	Short	3762 LM		
670 Tan	Hot melt with a fast set time offering excellent tack. Meets FDA CFR 175.105. Recommended for packaging applications. Available in 1 3/4" x 1 3/4" slugs only. 	155°F (68°C)	6,800	3,000	780	Medium			342
700 Amber	Elastomeric, high performance polyamide hot melt offers excellent adhesion to many difficult-to-bond substrates. Shows excellent performance at a broad temperature range.	250°F (121°C)	2,800	2,000 at 410°F	210	Medium	3779	6240	7804
850 White	Fast-setting multipurpose edge-banding hot melt. High heat resistance and viscosity for high-speed application, straight-line & soft forming. Contains no VOCs. 	—	100,000 at 400°F	—	—	Short			
851 Yellow	Edge-banding adhesive with good flow is easy to work with and environmentally safe. Contains no toxic or flammable solvents or VOCs. #851 and #850 are available in pellets only. 	—	10,000 at 400°F	—	—	Short			
962 Amber	General purpose hot melt adhesive, specifically designed for woodworking applications. Its viscosity allows for high delivery rates and has a working time of 30-40 seconds.	130°F (54°C)	4,200	1,500	625	Medium	3759 3738	6363 6390	1942
2030 Clear	Patented low temp hot melt that is applied at 225°F and eliminates the risk of serious burns. Has higher bond strengths than typical general purpose clear hot melts.	144°F (62°C)	28,000 at 225°F	1,200 at 375°F	450	Medium	3792 LM		

*Bonding time range in seconds: Short = 5 to 30 seconds Medium = 31 to 45 seconds Long = 46 seconds and up

Appropriate for Your Industry

Chart Matches Your Industry's Needs & Substrates



There's a Right Adhesive Tech Formula for Your Industry

Industry Category:	Application:	Substrates:	Adhesive Needed
Appliances	HVAC:	EPS, Fiberglass, Aluminum, Glass, Rubber	271
Appliances	HVAC:	EPS, Fiberglass, Aluminum	271, 296
Automotive	Auto Seat Repair Interior Trim	U-Foam Polypropylene	298 067
Automotive	RV Conversion	Carpet, Wood, Metal	271, 296
Carpet	Binding	Fiber to Fiber	230, 962, 2030
Electrical	Potting, Rigidizing	Circuit Board, Electrical Components	067, 235, 271, 962 700, 2030
Furniture	Mattresses:	Urethane, Foam, Fabric	296, 297
Furniture	Cabinets,	Laminates, Wood	962, 700
Furniture	Upholstery	Material, Foam, Wood	067, 962
Furniture	Upholstery	Fabric to Fabric, Gimp	230, 235
Furniture	Caskets	Fabric, Wood	297, 610, 962
Furniture	Construction	Wood to Wood	962
Furniture	Edge Banding	ABS, HPL, PVC, Veneers, Natural Woods, Teak, Mahogany	271, 962 850, 851
Packaging	Carton Closing	Corrugated and Wax-coated Corrugated	610, 630, 650, 660
Packaging	P-O-P	Porous Materials	280, 610, 630, 660, 2030
Packaging	Foam Inserts	EPS, Ethafoam, Corrugated	296, 297, 962
Packaging	Credit Cards Promotional Sample	Temporary Tack Packaging Tack	053 053
Packaging	Carrying Cases	U-Foam, Plastic, Wood	296, 297, 298
Packaging	Foam Fabricating	EPS, Ethafoam, Corrugated	296, 297, 610
Shoe	Assembly	Leather to Leather	271, 296, 700