



Fastbond™ Water-based Adhesives

*Take to
the water for
productivity,
performance,
profitability,
compliance*



***For your
continued
success...
now is
the time to
get into water***

For compliance and productivity, now is the time to switch from solvent-based adhesives to water-based.

OSHA, EPA and many local and regional regulations are increasing the pressure to reduce solvent use. And fire insurance rates are increasing.

3M has the track record and powerful technologies for compliance plus productivity, bonding performance, and cost savings.

- **No nPB or methylene chloride solvents, eliminating the time and work of managing a controlled substance**
- **High solids content for cost-effective high coverage, bonding more square footage for less money**
- **Non-flammable in the wet state for easy storage without fireproof cabinets**
- **Dries fast without solvent odor, helping improve worker comfort and thus productivity**
- **Choice of formulations that bond fast and strong with a wide variety of substrates**
- **Choice of spray (including low maintenance gravity feed), roller, or brush application to meet production requirements**

3M™ Fastbond™ Contact Adhesive 30NF
The fast, high strength water-based pioneer



3M™ Fastbond™ Contact Adhesive 30NF complies with California South Coast Air Quality Management District Rule 1168 requirements for contact adhesives. For that reason and others, Fastbond™ Contact Adhesive 30NF has been chosen for more than 40 years as a fast, powerful replacement for solvent-based adhesives in a variety of applications:

- Bond particle board, plywood, plastic laminate and other rigid materials in cabinet and woodworking shops and elsewhere.
- Bond EPS insulation inside metal doors and refrigeration units
- Secure rubber flooring in buses and headliners in boats
- Bond fabric to drywall and felt to wood in speakers

For these and other applications, 30NF combines multiple advantages for productivity and end use reliability:

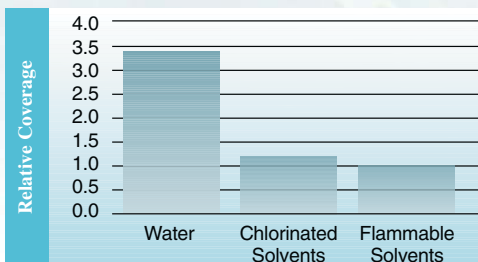
- Long bonding range of up to 4 hours for assembly at your own pace
- High immediate bond strength for fast throughput
- Ultimate shear strength of 480 psi for reliability exceeding many solvent-based adhesives
- High solids for more economical use of adhesive (up to 3.5x more coverage than a typical solvent-based product)
- Heat-activatable for fast post forming
- Heat resistance meets the test standards in the Manual of Millwork of the Woodwork Institute of California



Laminate stays put during post forming.

**Bottom line for all 3M™ Fastbond™
Water-based Adhesives –
more usable adhesive per gallon**

Carrier	Water	Chlorinated Solvents	Flammable Solvents
% Solids	50%	15%	20%
Density (lbs/gal)	9.1	10.8	6.7
lbs. of adhesive/gal	4.6	1.6	1.3
Relative coverage	3.4	1.2	1.0
Issues		Toxicity	Flammability



**Take to the water and take
solvents out of your business.**

**1-800-362-3550
www.3M.com/adhesives**

Solutions through service...

3M representatives are located throughout the United States, Canada, and 50 other countries for sales assistance.

For technical service, a highly trained team is ready to help you evaluate adhesives for specific applications.

A national authorized distributor network provides sales assistance and local product availability.

3M™ Fastbond™ Water-based Adhesives at a Glance

Contact Adhesives

Product/Color	Description	Solids Weight (Approx.)	Flash Point (Closed Cup)	Consistency	Application Method	Bonding Range	Overlap Shear Strength (PSI)		Peel Strength (PIW)	Packaging
							75°F (24°C)	180°F (82°C)	75°F (24°C)	
30NF/ Green and neutral	<ul style="list-style-type: none"> Long bonding range with high immediate bond strength Economical high coverage Meets MIL-A-24179A, Type I 	50%	None	Thin liquid	Spray, roller, brush	Up to 4 hours	480 ⁽¹⁾	60 ⁽¹⁾	5.9 ⁽²⁾	Quart, gallon, 5-gallon pail, drum, tote
30H/ Green	<ul style="list-style-type: none"> High viscosity version of 30NF for roll coating 	50%	None	Medium liquid	Spray, roller, brush, roll coat	Up to 4 hours	480 ⁽¹⁾	60 ⁽¹⁾	5.9 ⁽²⁾	Drum, tote
2000NF/ Black, blue light orange, and neutral	<ul style="list-style-type: none"> Water-dispersed, activated adhesive Immediate bonding and handling strength without forced drying 	49%	None	Thin liquid	Co-Spray	Up to 2 hours	350 ⁽¹⁾	50 ⁽¹⁾	4.1 ⁽²⁾	5-gallon box and pail, drum, tote
100/ Lavender and neutral	<ul style="list-style-type: none"> One-part, fast setting with neoprene base Bonds many porous substrates to porous or non-porous substrates 	47%	None	Very thin liquid	Spray	Up to 20 minutes	NA	NA	1.1 ⁽²⁾	5-gallon box and pail, drum, tote

(1) Birch plywood to birch plywood @ 0.1 inches/minute separation rate. (2) Canvas to cold rolled steel @ 2.0 inches/minute separation rate.

Insulation and Carpet Adhesives

Product/Color	Description	Solids Weight (Approx.)	Flash Point (Closed Cup)	Consistency	Application Method	Bonding Range	Peel Strength (PIW) 75°F (24°C)	Packaging
Insulation Adhesive 49/Clear	<ul style="list-style-type: none"> Fast tacking, high performance pressure sensitive adhesive for lightweight materials Low VOCs UL component recognition MAGW2 file MH 6288 	55%	None	Thin	Spray, brush, roller	30 days plus	3.0 ⁽¹⁾	5-gallon box and pail, drum, tote
Pressure Sensitive Adhesive 4224NF/Blue and clear	<ul style="list-style-type: none"> Permanently pressure sensitive with aggressive tack Plasticizer resistant Low VOC content 	40%	None	Thick liquid	Spray, brush, roller, trowel, coater	30 days plus	4.4 ⁽¹⁾	5-gallon pail, drum

(1) Primed polyester to steel @ 2.0 inches/minute separation rate.

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

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