Onsite testing
To help you find the right product to meet your exact job specifications and work environment, 3M offers comprehensive onsite testing. 3M technicians will visit your factory or production facility—virtually anywhere in the world—to make sure you not only select the product that matches your job specs and work conditions, but also optimize your results through proper product use. In addition, the 3M national authorized distributor network can provide sales assistance and local product availability.

Color matching
If your application requires unique colors, 3M’s POWER Line products can be customized to match. Consult your local 3M sales representative for program specifics.

A commitment to sustainability
3M has made a long-term commitment to continuously improve the environmental, health and safety impact of our products and processes. 3M’s POWER Line already includes examples of this environmental leadership. Our non-isocyanate, low-VOC hybrid products are not only superior performing products, but can help you meet your organizational goals for a healthier and safer workplace and better environment.

For more information on 3M™ Polyurethane and Hybrid Adhesives & Sealants, go to www.3M.com/adhesives or call 1-800-362-3550.
A powerful line of high performance polyurethane and hybrid adhesives & sealants

Now, advanced chemistries from 3M, a world leader in adhesive technology, give you powerful alternatives for bonding, filling, sealing, waterproofing and more.

3M’s POWER Line products cure with atmospheric moisture to form durable, resilient, long-lasting bonds ideal for:

- Truck, trailer, bus and other vehicle panel mounting
- Marine OEM deck-to-hull joining, through-hull fastening, deck fitting and more
- Roof flashings, through-wall pipe and cable sealing and other construction applications

Easy to use. Tough to beat.

Some industries still rely on rivets, screws, bolts and welds for the majority of their fastening. But mechanical fasteners are often limited to heavier materials of similar construction, and create stress points and areas where corrosion can form. In addition, low-tech adhesives simply aren’t designed for tough industrial applications. 3M’s POWER Line adhesives and sealants can actually out-perform mechanical fasteners—with none of the drawbacks you may have experienced with other adhesives.

Introducing The POWER Line

A Superior, Flexible Bond

Polyurethane and Hybrid Adhesives & Sealants offer more versatile fastening and sealing solutions, greatly expanding your product or project design alternatives. Now you can:

- Match the bond strength to the job at hand
- Use thinner, lighter, even dissimilar materials as design and cost-saving solutions
- Produce bond lines that can bend and flex

The POWER Line design advantage

3M’s POWER Line adhesives and sealants offer a wide range of industries:

- Roof flashings, through-wall pipe and cable sealing and other construction applications
- Marine OEM deck-to-hull joining, through-hull fastening, deck fitting and more
- Marine and specialty vehicle window bonding and glazing
- Truck, trailer, bus and other vehicle panel mounting
- Concrete sealing and expansion joint filling
- Marine and specialty vehicle window bonding and glazing
- Many other applications in a wide range of industries
Now, advanced chemistries from 3M, a world leader in adhesive technology, give you powerful alternatives for bonding, filling, sealing, waterproofing and more.

3M™ Polyurethane and Hybrid Adhesives & Sealants are advanced, one-part formulations that require no mixing or special application tools. 3M’s POWER Line products cure with atmospheric moisture to form durable, resilient, long-lasting bonds ideal for:

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**A superior, flexible bond**

**Mechanical Fasteners**

- Match the bond strength to the job at hand
- Use thinner, lighter, even dissimilar materials as design and cost-saving solutions
- Produce bond lines that can bend and flex
- Assemble large, lower tolerance parts as well as bond complex parts to close tolerances
- Reduce vibration and noise
- Seal out corrosive elements; eliminate or minimize leaks

**Low-tech and General Adhesives**

- Produces bond lines that can bend and flex
- Easy to apply. Help increase productivity, simplify operations and cut costs.
- Bond can become brittle and jammed rigid
- Stay flexible after cure. Result in durable, low-tech bonds and help joints or bonded areas resist vibration fatigue
- Offer “invisible” fastening that fits gaps and recesses and contracts with heat and cold. Surfaces stay smooth and clean. Your product looks great with less surface refreshing.

**Bond and seal in one step.**

**A powerful line of high performance**

Polyurethane and hybrid adhesives & sealants

Introducing the **POWER Line**

**3M™ 5200 Polyurethane Adhesive Sealant**

- Multi-purpose adhesive
- Room-temperature cure
- Excellent for bonding, filling, and sealing
- Multi-surface adhesive
- Multi-surface bonding
- High strength
- 8-hour cure time
- 3-hour dry time

**3M™ 5200 OES Polyurethane Adhesive Sealant**

- Easy-to-use adhesive
- Excellent water resistance
- Crack bridging
- Crack sealing
- Light VOC
- 15-minute cure time

**3M™ 5600 Hybrid Adhesive Sealant**

- Easy-to-use adhesive
- Excellent water resistance
- Crack bridging
- Crack sealing
- Low VOC
- 15-minute cure time

**3M™ 2000 Hybrid Adhesive Sealant**

- Easy-to-use adhesive
- Excellent water resistance
- Crack bridging
- Crack sealing
- Low VOC
- 15-minute cure time
As a world leader in adhesive technologies and a pioneer of polyurethane chemistry in the 1960s, 3M is uniquely positioned to offer a comprehensive line of adhesives and sealants. These products are specifically designed for industrial markets and offer significant advantages over currently available products, including:

- Higher quality formulations that resist yellowing, cracking, chalking and UV degradation
- High performance hybrid products with superior environmental characteristics and other unique attributes
- Many of our products are certified to industry specifications (flame & smoke, marine, etc.)

### Advanced 3M hybrid technologies

3M's hybrid polyurethanes are the most recent development in elastomeric adhesive sealants. These exciting products offer all the advantages of 3M's polyurethane adhesives and sealants, PLUS:

- Faster skin time
- No isocyanates or solvents, for a better environmental profile
- Improved UV resistance—less “chalking” and staining over time
- Broader adhesion to a variety of substrates, with less need for primers
- No bubbling—even under high temperature or humidity
- Greater short-term heat resistance
- Excellent color stability
- Paintable, even when wet

### Innovative packaging

For 3M hybrid adhesives and sealants:

- cosmetic skinning on boats, buses, trailers
- any application where Environmental Health and Safety (EHS) is critical
- bonding high performance applications, such as marine windshields
- waterproofing joints without primers in concrete, glass, marble, granite and brick
- bonding and waterproofing modular building panels or aluminum units
- structural bonding in industrial bodywork
- domestic appliances and electrical equipment

For 3M polyurethane adhesives and sealants:

- concrete expansion gaps
- waterproofing joints and seams without primers
- weathersealing applications
- panel bonding
- gasket sealing
- household appliances
- electrical equipment
- industrial bodywork
- outdoor meadow
- shipbuilding

### Applications

For 3M hybrids and polyurethanes resist bleeding and staining

3M’s POWER Line Products

- 3M’s proprietary formulations can eliminate bleeding
- Lower grade adhesives/sealants can create yellow and turn chalky over time

Competitive Products

- Competitive adhesives can heat and create messy expansion problems
- Competitive sealant formulations can compromise performance and cause bubbling or cracking

Competitive products can bleed into porous substrates, staining the finish

A formulation for virtually every application

No two industrial bonding or sealing applications are exactly the same. That’s why 3M has a complete range of options from which to choose, including products with slow to rapid cure rates and skin times; a wide variety of packaging choices and sizes, from traditional cartridges and economical sausage packs to drums; and several color choices. A 3M adhesive/sealant technical specialist can help you select the right products for your specific applications.
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### Innovative packaging

For 3M hybrid adhesives and sealants:

- cosmetic skimming on boats, buses, trailers
- any application where Environmental Health and Safety (EHS) is critical
- bonding high-performance applications, such as marine windshields
- waterproofing joints without primers in concrete, glass, marble, granite and brick
- bonding and waterproofing modular building panels or bathroom units
- structural bonding in industrial bodywork
- domestic appliances and electrical equipment

For 3M polyurethane adhesives and sealants:

- concrete expansion gaps
- waterproofing joints and seams without primers
- unvented applications
- panel bonding
- gutter sealing
- household appliances
- electrical equipment
- industrial hygiene
- outdoor needs
- shipbuilding

### Applications

**For 3M hybrid adhesives and sealants**

- cosmetic skimming on boats, buses, trailers
- any application where Environmental Health and Safety (EHS) is critical
- bonding high-performance applications, such as marine windshields
- waterproofing joints without primers in concrete, glass, marble, granite and brick
- bonding and waterproofing modular building panels or bathroom units
- structural bonding in industrial bodywork
- domestic appliances and electrical equipment

**For 3M polyurethane adhesives and sealants**

- concrete expansion gaps
- waterproofing joints and seams without primers
- unvented applications
- panel bonding
- gutter sealing
- household appliances
- electrical equipment
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- outdoor needs
- shipbuilding

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Marine

Applications

Exceptional flexibility in the harshest environments

Extreme flexibility and toughness are key for both marine repair and OEM construction. Constant pounding by waves, salt spray, intense sunlight and potential exposure to fuels and oils all require exceptionally strong, flexible bonds and seals. 3M set the performance standards 40 years ago with industry leading 3M™ 5200 Polyurethane Adhesive & Sealant. Now 3M’s POWER Line offers marine OEM and repair professionals a complete selection of innovative bonding and sealing formulations. Count on 3M™ Polyurethane and Hybrid Adhesives & Sealants to help you withstand whatever nature throws at you.

### POWER Line Products for Marine—Application Summary

<table>
<thead>
<tr>
<th>Chemical Base</th>
<th>Below Water</th>
<th>Above Water</th>
<th>Skin Time</th>
<th>Cure Time</th>
<th>Chemical Property</th>
<th>Applications</th>
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<tbody>
<tr>
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<td>5</td>
<td>4000uV</td>
<td>80 mm</td>
<td>24 hr</td>
<td>24 hr</td>
<td>Bonding Wood to Wood</td>
</tr>
<tr>
<td>Hybrid</td>
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<td>1,7</td>
<td>550</td>
<td>24 hr</td>
<td>24 hr</td>
<td>Bonding Fiberglass to Fiberglass</td>
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<tr>
<td>Polyurethane and Hybrid</td>
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<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>24 hr</td>
<td>Bonding/Polycarbonate Window Glazing**</td>
</tr>
<tr>
<td>Polyurethane and Hybrid</td>
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<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>24 hr</td>
<td>Bonding Fritted Glass Window</td>
</tr>
<tr>
<td>Polyurethane and Hybrid</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>24 hr</td>
<td>General Interior Sealing</td>
</tr>
<tr>
<td>Polyurethane and Hybrid</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>24 hr</td>
<td>Keel Bonding</td>
</tr>
<tr>
<td>Polyurethane and Hybrid</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>24 hr</td>
<td>Deck-to-Hull Bonding</td>
</tr>
<tr>
<td>Polyurethane and Hybrid</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>24 hr</td>
<td>Bonding Through Hull</td>
</tr>
<tr>
<td>Polyurethane and Hybrid</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>24 hr</td>
<td>Bonding Floor Fitting</td>
</tr>
<tr>
<td>Polyurethane and Hybrid</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>24 hr</td>
<td>Bonding Ring/In Fitting</td>
</tr>
<tr>
<td>Polyurethane and Hybrid</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>24 hr</td>
<td>Bonding Wizard to Wizard</td>
</tr>
</tbody>
</table>

### Applications

- **Duck to Hull Bonding**
- **Keel Bonding**
- **General Interior Sealing**
- **Glass Window Bonding**
- **Fritted Glass Window Bonding**
- **Plastic (PMMA) Window Bonding/Polycarbonate**
- **Wireless Glazing**
- **Sealing Exterior (Strong UV Radiation Zones)**
- **Bonding Deck Fills**
- **Bonding Through Hull**
- **Bonding Floor Fitting**
- **Bonding Ring or In Fitting**
- **Bonding Wizard to Wizard**

### Cure Time

- **540**: 20 min
- **550**: 50 min
- **555**: 90 min
- **560**: 20 min
- **590**: 30 min
- **595**: 550 min
- **5200FC**: 740 min
- **740**: 590 min
- **760**: 740 min
- **750**: 560 min

### Skin Time

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### Chemical Base

- **PU**: Polyurethane
- **Hybrid**: Polyurethane and Hybrid

### Chemical Property

- **Chemical resistant**
- **Salt water resistant**
- **Non-yellowing**
- **UV resistant**
- **Above and below the waterline**
- **Varying open times**

### Drive to perform

Light weight, Flexible. Bonding power with dissimilar materials (metal to glass, fiberglass to metal). Ability to seal out water, dust and noise. Smoke and flame resistance. Sound absorption. These are some of the key characteristics specialty vehicle manufacturers need from a bonding and sealing system. 3M™ Polyurethane and Hybrid Adhesives & Sealants deliver. They allow you to structurally bond and seal a wide range of materials, both similar and dissimilar—often replacing rivets, screws, bolts or even welds. The results? Quieter, lighter weight products with superior performance characteristics, often at lower costs.

### POWER Line Products for Specialty Vehicle Manufacturing—Application Summary

<table>
<thead>
<tr>
<th>Chemical Base</th>
<th>Bonding</th>
<th>Skin Time</th>
<th>Cure Time</th>
<th>Chemical Property</th>
<th>Applications</th>
</tr>
</thead>
<tbody>
<tr>
<td>PU</td>
<td>1</td>
<td>1,2,3,4,6</td>
<td>540</td>
<td>20 min</td>
<td>Bonding Wood to Wood</td>
</tr>
<tr>
<td>PU</td>
<td>3</td>
<td>1,7</td>
<td>550</td>
<td>24 hr</td>
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</tr>
<tr>
<td>PU</td>
<td>2</td>
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<td>551</td>
<td>24 hr</td>
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</tr>
<tr>
<td>PU</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
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</tr>
<tr>
<td>PU</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>General Interior Sealing</td>
</tr>
<tr>
<td>PU</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>Keel Bonding</td>
</tr>
<tr>
<td>PU</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>Deck-to-Hull Bonding</td>
</tr>
<tr>
<td>PU</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>Bonding Through Hull</td>
</tr>
<tr>
<td>PU</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>Bonding Floor Fitting</td>
</tr>
<tr>
<td>PU</td>
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<td>551</td>
<td>24 hr</td>
<td>Bonding Ring/In Fitting</td>
</tr>
<tr>
<td>PU</td>
<td>2</td>
<td>1,2,3,4,6</td>
<td>551</td>
<td>24 hr</td>
<td>Bonding Wizard to Wizard</td>
</tr>
</tbody>
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### Chemical Property

- **Chemical resistant**
- **Salt water resistant**
- **Non-yellowing**
- **UV resistant**
- **Above and below the waterline**
- **Varying open times**

### A powerful combination

Easy-to-use, instant-bonding 3M™ VHB™ Tapes and 3M™ Polyurethane and Hybrid Adhesives & Sealants can make the ideal combination for many vehicle applications. 3M™ VHB™ Tapes bond on contact and feature advantageous properties that dampen noise and vibration, resulting in a quieter ride.
**Power Specs**

- Non-yellowing
- UV resistant
- Above and below the waterline
- Varying open times
- Chemical resistant
- Salt water resistant
- Flexible
- A powerful combination

**Power Line Products for Marine—Application Summary**

```
<table>
<thead>
<tr>
<th>Cure Time</th>
<th>Skin Time</th>
<th>Ratings, Certifications</th>
</tr>
</thead>
<tbody>
<tr>
<td>Above Water</td>
<td>Removable</td>
<td>Bonding</td>
</tr>
<tr>
<td>Bonding Wood to Wood</td>
<td>Fiberglass</td>
<td>Bonding Through Hull</td>
</tr>
<tr>
<td>Fritted Glass Window Bonding</td>
<td>Glass Window Bonding</td>
<td>Glass Window Bonding</td>
</tr>
<tr>
<td>Marine Sealing Form</td>
<td>Marine Sealing Form</td>
<td>Marine Sealing Form</td>
</tr>
<tr>
<td>Sealing</td>
<td>Sealing</td>
<td>Sealing</td>
</tr>
<tr>
<td>24 hr</td>
<td>24 hr</td>
<td>24-48 hr</td>
</tr>
<tr>
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<td>24 hr</td>
<td>24-48 hr</td>
</tr>
<tr>
<td>24 hr</td>
<td>24 hr</td>
<td>24-48 hr</td>
</tr>
</tbody>
</table>

**Applications**

- Bonding Wood to Wood
- Bonding Through Hull
- Bonding Floor Fittings
- Bonding PVC
- Bonding to Wood

**Marine Applications**

Exceptional flexibility in the harshest environments

Extreme flexibility and toughness are key for both marine repair and OEM construction. Constant pounding by waves, salt spray, intense sunlight and potential exposure to fuels and oils all require exceptionally strong, flexible bonds and seals.

3M set the performance standards 40 years ago with industry leading 3M™ 5200 Polyurethane Adhesive & Sealant. Now, 3M’s POWER Line offers marine OEM and repair professionals a complete selection of innovative bonding and sealing formulations. Count on 3M™ Polyurethane and Hybrid Adhesives & Sealants to help you withstand whatever nature throws at you.

**POWER Line Products for Marine**

- **Polyurethane Adhesive & Sealant.**
- **Now 3M’s POWER Line offers marine exposure to fuels and oils all require exceptionally strong, flexible bonds and seals.**
- **Constant pounding by waves, salt spray, intense sunlight and potential exposure to fuels and oils all require exceptionally strong, flexible bonds and seals.**
- **Extreme flexibility and toughness are key for both marine repair and OEM construction.**

**Polyurethane and Hybrid Adhesives & Sealants to help you withstand whatever nature throws at you.**

**Power Line Products for Specialty Vehicle Manufacturing—Application Summary**

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<thead>
<tr>
<th>Cure Time</th>
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<tbody>
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<td>Above Water</td>
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<tr>
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<td>Fiberglass</td>
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<tr>
<td>Fritted Glass Window Bonding</td>
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</tr>
<tr>
<td>Marine Sealing Form</td>
<td>Marine Sealing Form</td>
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<td>Sealing</td>
<td>Sealing</td>
<td>Sealing</td>
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<tr>
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<td>24-48 hr</td>
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<tr>
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<td>24-48 hr</td>
</tr>
<tr>
<td>24 hr</td>
<td>24 hr</td>
<td>24-48 hr</td>
</tr>
</tbody>
</table>

**Applications**

- Interior Sealing
- Exterior Sealing
- Panel Attaching
- Floor/Sub Floor Bonding
- Roof Bonding
- Superior Long Term UV Resistance
- Glass Installation
- Through-Wall Fireproofing

**Specialty Vehicles**

Driven to perform

Light weight. Flexibility. Bonding power with dissimilar materials (metal to glass, fiberglass to metal). Ability to seal out water, dust and noise. Smoke and flame resistance. Sound absorption. These are some of the key characteristics specialty vehicle manufacturers need from a bonding and sealing system. 3M™ Polyurethane and Hybrid Adhesives & Sealants deliver. They allow you to structurally bond and seal a wide range of materials, both similar and dissimilar—often replacing rivets, screws, bolts or even welds. The results? Quieter, lighter weight products with superior performance characteristics, often at lower costs.
A difference you can see

Glass Bonding and Glazing

**Power Line Products for Glass Bonding and Sealing—Application Summary**

<table>
<thead>
<tr>
<th>Glass Applications</th>
<th>Bonding</th>
<th>Sealing</th>
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<tbody>
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<td>Tinted Glass Bonding</td>
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<td>Through-Wall Fire Proofing</td>
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<tr>
<td>Mineral Wool</td>
<td>x</td>
<td></td>
</tr>
<tr>
<td>Roof Tile</td>
<td>x</td>
<td></td>
</tr>
<tr>
<td>Concrete/Stone/Brick</td>
<td>x</td>
<td></td>
</tr>
<tr>
<td>PVC</td>
<td>x</td>
<td></td>
</tr>
<tr>
<td>ABS</td>
<td>x</td>
<td></td>
</tr>
<tr>
<td>Galvanized Metal</td>
<td>x</td>
<td></td>
</tr>
<tr>
<td>Steel, Anodized Aluminum, Fiberglass</td>
<td>x</td>
<td></td>
</tr>
</tbody>
</table>

**Chemical Base**

- Primer/Cleaner

**Priming Suggestions**

- PMMA
- Tinted Glass Bonding
- Fritted Glass Bonding

**Ratings, Certifications**

- 5=Crash Tested (FMVSS 212)
- 1=IMO; 2=Surface Flame Spread (ASTM E 162); 3=Smoke Generation (ASTM E 662); 4=Bombardier Toxic Gas (SP 800-C)

**Porosity Sealing**

- Wood/Teak
- Polyester
- PVC
- Galvanized Metal

**Bonding**

- Steel, Anodized Aluminum, Fiberglass
- Concrete/Stone/Brick
- PMMA
- Tinted Glass Bonding
- Fritted Glass Bonding

**Sealing**

- General Industrial
- Through-Wall Fire Proofing
- EPS
- Expansion Joints
- PVC/Aluminum Flashing
- Mineral Wool
- Roof Tile
- Concrete/Stone/Brick
- PVC
- ABS
- Galvanized Metal
- Steel, Anodized Aluminum, Fiberglass

**Industrial Applications**

- Concrete, metal, lacquer, and products that need to be termically sealed as well as products that need to work in totally submerged environments.
- High humidity and wet environments.
- Industrial applications include pipe, valves, fittings, and pump systems, as well as products that need to work in totally submerged environments.
- Fast curing and UV resistant.

**Properties**

- Formulated for the ideal combination of polyurethane and high performance Hybrid Adhesives & Sealants and 3M™ Primers and Cleaners.
- A difference you can see.
- A difference you can feel.
- Superior Long Term UV Resistance
- Permanent flexibility
- Minimal shrinkage
- Non-bubbling/
- Non-staining
- High weatherability
- 3M Scotchcast™
- 3M Scotchcast™
- 3M Scotchcast™
- 3M Scotchcast™
- 3M Scotchcast™
- 3M Scotchcast™
- 3M Scotchcast™

**Power Line**

- Better bonds
- Better performance
- Better durability

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

**Porosity Sealing**

- Wood/Teak
- Polyester
- PVC
- Galvanized Metal

**General Industrial**

- Through-Wall Fire Proofing
- EPS
- Expansion Joints
- PVC/Aluminum Flashing
- Mineral Wool
- Roof Tile
- Concrete/Stone/Brick
- PVC
- ABS
- Galvanized Metal
- Steel, Anodized Aluminum, Fiberglass

**Sealing**

- General Industrial
- Through-Wall Fire Proofing
- EPS
- Expansion Joints
- PVC/Aluminum Flashing
- Mineral Wool
- Roof Tile
- Concrete/Stone/Brick
- PVC
- ABS
- Galvanized Metal
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- 3M Scotchcast™

**Power Line**

- Better bonds
- Better performance
- Better durability

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Glass Bonding and Glazing

A difference you can see

It takes a special polyurethane to form the bonds and seals around windows and glass. Moisture must be sealed out completely; yet flexibility is paramount to ensure a seal that won’t dry out, withstands pounding and vibrations, and protects the glass. 3M™ Polyurethane and Hybrid Adhesives & Sealants and 3M™ Primers and Cleaners for windows and glass are specifically formulated for the unique characteristics and requirements of structural glass bonding and window glazing. Strong yet flexible. Crack resistant. They’re ideal for structural windshield installations, PMMA windshield applications, hard-to-bond polycarbonates and acrylics, and flash-mounted glass for both marine and automotive use.

POWER Line Products for Glass Bonding and Sealing—Application Summary

<table>
<thead>
<tr>
<th>SEALS</th>
<th>PRIMERS/CLEANERS</th>
</tr>
</thead>
<tbody>
<tr>
<td>580°C</td>
<td>400000*</td>
</tr>
<tr>
<td>580</td>
<td>589</td>
</tr>
<tr>
<td>Sealing</td>
<td>xx</td>
</tr>
<tr>
<td>Bonding</td>
<td>xx</td>
</tr>
<tr>
<td>Primer/Cleaner</td>
<td>N/C</td>
</tr>
<tr>
<td>Chemical Base</td>
<td>PU</td>
</tr>
<tr>
<td>Skin Time</td>
<td>25 sec</td>
</tr>
</tbody>
</table>

GLASS APPLICATIONS

- Tinted Glass Bonding
- Fritted Glass Bonding
- Polycarbonate
- PMMA
- Mineral Sealing

PRIMER SUGGESTIONS

- Concrete/Stone/Brick/Brick
- Steel, Anodized Aluminum, Galvanized Metal
- Glass
- PVC
- N/A
- N/A
- Wood/Tile
- N/A

Porosity Sealing

N/A

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

Properties are measured at 20°C and 50% humidity. Cure time can vary greatly on the substrates bonded. 3M™ Certifications: 5=Crash Tested (FMVSS 212); 6=C920; 7=NSF R2

Building better bonds

From sealing the sedimentation tanks of sewage treatment plants to filling expansion gaps in concrete, 3M™ POWER Line has the ideal product for sealing and bonding. Besides a broad selection of polyurethane and high performance hybrid adhesives and sealants, there are primers, boosters, cleaners and applicator guns to help cut your costs, improve productivity and get the job done right. Construction applications include expansions, paver and slab control joints; cast-in-place, prefab and stamped concrete; brickwork, marble and granite; parking ramps, seismic sealing, flashing and roof assembly; gap-filling on facades; and HVAC ductwork. Industrial applications include spas, appliances and anywhere else high humidity is a concern; metal fabrication and products that need to be hermetically sealed; as well as products that need to work in totally submerged environments.

POWER Line Products for General Industry and Construction—Application Summary

<table>
<thead>
<tr>
<th>$25</th>
<th>$35</th>
<th>$50</th>
<th>$560</th>
<th>$100</th>
<th>740</th>
<th>760</th>
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<td>xx</td>
<td>xx</td>
<td>xx</td>
<td>xx</td>
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<tr>
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<td>xx</td>
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<td>xx</td>
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<tr>
<td>Chemical Base</td>
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<td>PU</td>
<td>PU</td>
<td>PU</td>
<td>PU</td>
<td>Hybrid</td>
</tr>
<tr>
<td>Ratings, Certification</td>
<td>7</td>
<td>6</td>
<td>1.2.4.6</td>
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<td>1.2.4.6</td>
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</tr>
<tr>
<td>Skin Time</td>
<td>24 hr</td>
<td>24 hr</td>
<td>24 hr</td>
<td>24 hr</td>
<td>24 hr</td>
<td>24 hr</td>
</tr>
<tr>
<td>Cove Time</td>
<td>24 hr</td>
<td>24 hr</td>
<td>24 hr</td>
<td>24 hr</td>
<td>24 hr</td>
<td>24 hr</td>
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<tr>
<td>Paintable</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
</tbody>
</table>

APPLICATIONS

- Superior Long Term UV Resistance
- Steel
- Glass
- Phenolic
- Steel, Anodized Aluminum, Galvanized Metal
- ABS
- PVC
- Concrete/Stone/Brick/Brick
- Roof Tile
- Mineral Wool
- PVC/Aluminum Flashing
- Sealing
- Expansion Joints
- EIFS
- Through-Wall Fire Proofing
- Thin Bond Lines, Fast Setting

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

Properties are measured at 20°C and 50% humidity. Cure time can vary greatly on the substrates bonded. 3M™ Certifications: 1=IMO; 2=Surface Flame Spread (ASTM E 162); 3=Smoke Generation (ASTM E 662); 4=Bombardier Toxic Gas (SP 800-C); 6=C920; 7=NSF R2

Power Specs

- UV resistant
- Crack resistant
- Crash tested
- Permanent flexibility
- Hybrid technology for glass bonding and sealing
- Minimum shrinkage
- Non-bubbling/ non-staining
- Fast curing
- Superior weatherability

Power Line Products for Glass Bonding and Sealing—Application Summary

<table>
<thead>
<tr>
<th>SEALS</th>
<th>PRIMERS/CLEANERS</th>
</tr>
</thead>
<tbody>
<tr>
<td>580°C</td>
<td>400000*</td>
</tr>
<tr>
<td>580</td>
<td>589</td>
</tr>
<tr>
<td>Sealing</td>
<td>xx</td>
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<tr>
<td>Bonding</td>
<td>xx</td>
</tr>
<tr>
<td>Primer/Cleaner</td>
<td>N/C</td>
</tr>
<tr>
<td>Chemical Base</td>
<td>PU</td>
</tr>
<tr>
<td>Skin Time</td>
<td>25 sec</td>
</tr>
</tbody>
</table>

GLASS APPLICATIONS

- Tinted Glass Bonding
- Fritted Glass Bonding
- Polycarbonate
- PMMA
- Mineral Sealing

PRIMER SUGGESTIONS

- Concrete/Stone/Brick/Brick
- Steel, Anodized Aluminum, Galvanized Metal
- Glass
- PVC
- N/A
- N/A
- Wood/Tile
- N/A

Porosity Sealing

N/A

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Properties are measured at 20°C and 50% humidity. Cure time can vary greatly on the substrates bonded. 3M™ Certifications: 5=Crash Tested (FMVSS 212);

$25 | $35 | $50 | $560 | $100 | 740 | 760

Sealing | xx | xx | xx | xx | xx | xx | xx
Bonding | xx | xx | xx | xx | xx | xx | xx
Chemical Base | PU | PU | PU | PU | PU | Hybrid | Hybrid
Ratings, Certification | 7 | 6 | 1.2.4.6 | 1.2 | 1.2.4.6 | 1.2 | 1.2.4.6
Skin Time | 24 hr | 24 hr | 24 hr | 24 hr | 24 hr | 24 hr | 24 hr
Cove Time | 24 hr | 24 hr | 24 hr | 24 hr | 24 hr | 24 hr | 24 hr
Paintable | Yes | Yes | Yes | Yes | Yes | Yes | Yes

APPLICATIONS

- Superior Long Term UV Resistance
- Steel
- Glass
- Phenolic
- Steel, Anodized Aluminum, Galvanized Metal
- ABS
- PVC
- Concrete/Stone/Brick/Brick
- Roof Tile
- Mineral Wool
- PVC/Aluminum Flashing
- Sealing
- Expansion Joints
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- Crack resistant
- Crash tested
- Permanent flexibility
- Hybrid technology for glass bonding and sealing
- Minimum shrinkage
- Non-bubbling/ non-staining
- Fast curing
- Superior weatherability

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<table>
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<th>SEALS</th>
<th>PRIMERS/CLEANERS</th>
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<td>400000*</td>
</tr>
<tr>
<td>580</td>
<td>589</td>
</tr>
<tr>
<td>Sealing</td>
<td>xx</td>
</tr>
<tr>
<td>Bonding</td>
<td>xx</td>
</tr>
<tr>
<td>Primer/Cleaner</td>
<td>N/C</td>
</tr>
<tr>
<td>Chemical Base</td>
<td>PU</td>
</tr>
<tr>
<td>Skin Time</td>
<td>25 sec</td>
</tr>
</tbody>
</table>

GLASS APPLICATIONS

- Tinted Glass Bonding
- Fritted Glass Bonding
- Polycarbonate
- PMMA
- Mineral Sealing

PRIMER SUGGESTIONS

- Concrete/Stone/Brick/Brick
- Steel, Anodized Aluminum, Galvanized Metal
- Glass
- PVC
- N/A
- N/A
- Wood/Tile
- N/A

Porosity Sealing

N/A

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Properties are measured at 20°C and 50% humidity. Cure time can vary greatly on the substrates bonded. 3M™ Certifications: 5=Crash Tested (FMVSS 212);
**3M™ Polyurethane and Hybrid Adhesives & Sealants**

**Product Selector**

* Refer to technical data sheets for typical properties.

---

**The Importance of “Shore A Hardness”**

The Shore A Hardness number of a polyurethane adhesive or sealant can be the predictor of many properties. Products with lower Shore A Numbers are more pliable and elastic, with good recovery properties. This makes them excellent sealers. Products with higher Shore A Numbers are firmer; this makes them better suited for creating permanent, secure bonds. Generally speaking, products with higher Shore A Numbers have shorter skin times and cure faster.

However, our technical expertise and years of adhesive experience have allowed 3M to develop products with high Shore As and long open times for the assembly of complex parts. Please consult with your 3M representative to help you choose the best products for your needs.

---

**Product Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Industry</th>
<th>Skin Time (mins)</th>
<th>Cure Rate</th>
<th>Shore A Hardness</th>
<th>Elongation %</th>
<th>Modulus at 100% (psi)</th>
<th>Tensile Strength (psi)</th>
<th>Density</th>
<th>VOC g/L</th>
<th>Paintability</th>
</tr>
</thead>
<tbody>
<tr>
<td>255 C</td>
<td>C</td>
<td>90 - 150</td>
<td>3mm/24hr</td>
<td>35</td>
<td>60%</td>
<td>70%</td>
<td>87</td>
<td>300</td>
<td>N/A</td>
<td>1.17</td>
</tr>
<tr>
<td>535 C</td>
<td>C</td>
<td>60 - 90</td>
<td>3mm/24hr</td>
<td>40</td>
<td>60%</td>
<td>70%</td>
<td>87</td>
<td>300</td>
<td>N/A</td>
<td>1.17</td>
</tr>
<tr>
<td>5010</td>
<td>GI, CWW, C</td>
<td>3 - 5</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>1.05</td>
<td>2.1</td>
<td></td>
</tr>
<tr>
<td>540 G</td>
<td>GI, C, SV, M</td>
<td>60 - 90</td>
<td>3mm/24hr</td>
<td>40</td>
<td>60%</td>
<td>70%</td>
<td>87</td>
<td>300</td>
<td>N/A</td>
<td>1.17</td>
</tr>
<tr>
<td>550 G</td>
<td>GI, C, SV, M</td>
<td>60 - 90</td>
<td>4mm/24hr</td>
<td>45</td>
<td>&gt;600%</td>
<td>90%</td>
<td>105.7</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>550 + 8550 Booster</td>
<td>GI, C, SV, M</td>
<td>10 - 20</td>
<td>less than 24 hr</td>
<td>45</td>
<td>&gt;250%</td>
<td>58</td>
<td>N/A</td>
<td>1.2</td>
<td>N/A</td>
<td></td>
</tr>
<tr>
<td>551 M</td>
<td>SV</td>
<td>120 - 180</td>
<td>4mm/24hr</td>
<td>45</td>
<td>&gt;600%</td>
<td>90%</td>
<td>105.7</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>560 M</td>
<td>SV, M</td>
<td>50 - 60</td>
<td>4mm/24hr</td>
<td>55</td>
<td>&gt;300%</td>
<td>145</td>
<td>580</td>
<td>73.0</td>
<td></td>
<td></td>
</tr>
<tr>
<td>590 OEM Glass</td>
<td>M, SW, W</td>
<td>25 - 40</td>
<td>&gt;3.5mm/24hr</td>
<td>60 - 65</td>
<td>&gt;700%</td>
<td>&gt;870</td>
<td>1000</td>
<td>1.00</td>
<td>32</td>
<td></td>
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<tr>
<td>4200 M</td>
<td>M</td>
<td>60 - 90</td>
<td>4mm/24hr</td>
<td>45</td>
<td>&gt;600%</td>
<td>90%</td>
<td>105.7</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5200 M</td>
<td>M</td>
<td>&gt;48 hrs</td>
<td>&lt;1mm/24hr</td>
<td>68</td>
<td>&gt;800%</td>
<td>145</td>
<td>550</td>
<td>1.00</td>
<td>46</td>
<td></td>
</tr>
<tr>
<td>5200FC M</td>
<td>M</td>
<td>120 - 180</td>
<td>3mm/24hr</td>
<td>60</td>
<td>925%</td>
<td>N/A</td>
<td>600</td>
<td>1.17</td>
<td>36</td>
<td></td>
</tr>
<tr>
<td>140 M, GI, C, SV</td>
<td>40-60</td>
<td>&gt;3mm/24hr</td>
<td>55 &gt;100% &gt;145%</td>
<td>N/A</td>
<td>1.15</td>
<td>22.0</td>
<td></td>
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<tr>
<td>760 M</td>
<td>GI, C, SV</td>
<td>10-30</td>
<td>&gt;3mm/24hr</td>
<td>55</td>
<td>&gt;100%</td>
<td>&gt;145%</td>
<td>N/A</td>
<td>1.11</td>
<td>28.1</td>
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<tr>
<td>4000UV M</td>
<td>M, SW, W</td>
<td>20-60</td>
<td>45</td>
<td>800%</td>
<td>N/A</td>
<td>300</td>
<td>144</td>
<td>1.00</td>
<td>16</td>
<td></td>
</tr>
</tbody>
</table>

---

**Cleaners, primers, applicators**

Besides a complete selection of polyurethane and high performance hybrid adhesives and sealants as well as primers, boosters and cleaners, 3M’s POWER Line also includes a wide range of applicator guns—both powered and manual—designed to handle the most common cartridge and sausage pack sizes. Your 3M representative can help you select the right guns for your products and applications.

---

* Refer to technical data sheets for typical properties.

---

* 3M technicians can help you find the best combinations for your needs. So to achieve the results you’re looking for, you can either change the adhesive or the ambient conditions. In addition, as temperature and relative humidity increase, polyurethanes develop stronger holding power faster.

The chart graphically shows the depth and breadth of 3M™ Polyurethane and Hybrid Adhesives & Sealants. An important note to remember is that higher temperature and humidity will accelerate the cure rate of most adhesives and sealants. Because of this, 3M’s POWER Line includes similar products with varying skin times—to help you maintain your production processes whatever the climate in your area.

---

Please consult with your 3M representative to help you choose the best products for your needs.
**Product Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Industry</th>
<th>Skin Time (min)</th>
<th>Cure Rate</th>
<th>Shore A Hardness</th>
<th>Modulus at 100% (psi)</th>
<th>Tensile Strength (psi)</th>
<th>Density</th>
<th>VOC g/L</th>
<th>Paintability</th>
</tr>
</thead>
<tbody>
<tr>
<td>225</td>
<td>C</td>
<td>90 - 150</td>
<td>3mm/24hr</td>
<td>26</td>
<td>600%</td>
<td>44</td>
<td>N/A</td>
<td>1.17</td>
<td>82.6</td>
</tr>
<tr>
<td>235</td>
<td>C</td>
<td>60 - 90</td>
<td>3mm/24hr</td>
<td>40</td>
<td>600%</td>
<td>58</td>
<td>250</td>
<td>1.17</td>
<td>94.3</td>
</tr>
<tr>
<td>500</td>
<td>Gl, CWW, C</td>
<td>3 - 5</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>1.05</td>
<td>2.1</td>
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<tr>
<td>540</td>
<td>Gl, C, SV, M</td>
<td>60 - 90</td>
<td>3mm/24hr</td>
<td>40</td>
<td>600%</td>
<td>58</td>
<td>250</td>
<td>1.17</td>
<td>94.3</td>
</tr>
<tr>
<td>550</td>
<td>Gl, C, SV, M</td>
<td>60 - 90</td>
<td>4mm/24hr</td>
<td>45</td>
<td>&gt;600%</td>
<td>87</td>
<td>300</td>
<td>1.17</td>
<td>105.7</td>
</tr>
<tr>
<td>550 + B550 Booster</td>
<td>Gl, C, SV, M</td>
<td>10 - 20</td>
<td>less than 24 hr for total cure</td>
<td>45</td>
<td>&gt;250%</td>
<td>58</td>
<td>N/A</td>
<td>1.2</td>
<td>N/A</td>
</tr>
<tr>
<td>251</td>
<td>M, SV</td>
<td>120 - 180</td>
<td>4mm/24hr</td>
<td>45</td>
<td>&gt;600%</td>
<td>1.7</td>
<td>N/A</td>
<td>1.22</td>
<td>92.2</td>
</tr>
<tr>
<td>560</td>
<td>M, SV, M</td>
<td>50 - 60</td>
<td>4mm/24hr</td>
<td>55</td>
<td>&gt;300%</td>
<td>145</td>
<td>580</td>
<td>1.78</td>
<td>73.0</td>
</tr>
<tr>
<td>590 Glass</td>
<td>M, W, W</td>
<td>25 - 40</td>
<td>&gt;3.5mm/24hr</td>
<td>60 - 65</td>
<td>&gt;700%</td>
<td>&gt;870</td>
<td>1000</td>
<td>1.02</td>
<td>34.7</td>
</tr>
<tr>
<td>4200</td>
<td>M</td>
<td>60 - 90</td>
<td>4mm/24hr</td>
<td>45</td>
<td>&gt;600%</td>
<td>87</td>
<td>300</td>
<td>1.17</td>
<td>32.0</td>
</tr>
<tr>
<td>5200</td>
<td>M</td>
<td>&gt;48 hrs</td>
<td>&lt;1mm/24hr</td>
<td>68</td>
<td>&gt;800%</td>
<td>N/A</td>
<td>700</td>
<td>1.36</td>
<td>39.8</td>
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<tr>
<td>5200FC</td>
<td>M</td>
<td>60 - 120</td>
<td>3mm/24hr</td>
<td>60</td>
<td>925%</td>
<td>N/A</td>
<td>605</td>
<td>1.21</td>
<td>38.4</td>
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<tr>
<td>430</td>
<td>M, GI, C, SV</td>
<td>40 - 50</td>
<td>&gt;3.5mm/24hr</td>
<td>&gt;30</td>
<td>&gt;300%</td>
<td>&gt;140</td>
<td>N/A</td>
<td>1.65</td>
<td>22.0</td>
</tr>
<tr>
<td>540</td>
<td>M, GI, C, SV</td>
<td>10 - 30</td>
<td>&gt;3.5mm/24hr</td>
<td>55</td>
<td>&gt;100%</td>
<td>&gt;140</td>
<td>N/A</td>
<td>1.61</td>
<td>29.1</td>
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<tr>
<td>4000UV</td>
<td>M, SV, W</td>
<td>20 - 60</td>
<td>4mm/24hr</td>
<td>45</td>
<td>800%</td>
<td>N/A</td>
<td>300</td>
<td>1.4</td>
<td>16</td>
</tr>
</tbody>
</table>

**Cleaners, primers, applicators**

Besides a complete selection of polyurethane and high performance hybrid adhesives and sealants as well as primers, boosters and cleaners, 3M’s POWER Line also includes a wide range of applicator guns—both powered and manual—designed to handle the most common cartridge and sausage pack sizes. Your 3M representative can help you select the right guns for your products and applications.

**3M™ Polyurethane and Hybrid Adhesives & Sealants**

**The Importance of “Shore A Hardness”**

The Shore A Hardness number of a polyurethane adhesive or sealant can be the predictor of many properties. Products with lower Shore A numbers are more pliable and elastic, with good recovery properties. This makes them excellent sealers. Products with higher Shore A numbers are firmer; this makes them better suited for creating permanent, secure bonds. Generally speaking, products with higher Shore A numbers have shorter skin times and cure faster. However, our technical expertise and years of adhesive experience have allowed 3M to develop products with high Shore A’s and long open times for the assembly of complex parts. Please consult with your 3M representative to help you choose the best products for your needs.
Onsite testing
To help you find the right product to meet your exact job specifications and work environment, 3M offers comprehensive onsite testing. 3M technicians will visit your factory or production facility—virtually anywhere in the world—to make sure you not only select the product that matches your job specs and work conditions, but also optimize your results through proper product use. In addition, the 3M national authorized distributor network can provide sales assistance and local product availability.

Color matching
If your application requires unique colors, 3M’s POWER Line products can be customized to match. Consult your local 3M sales representative for program specifics.

A commitment to sustainability
3M has made a long-term commitment to continuously improve the environmental, health and safety impact of our products and processes. 3M’s POWER Line already includes examples of this environmental leadership. Our non-isocyanate, low-VOC hybrid products are not only superior performing products, but can help you meet your organizational goals for a healthier and safer workplace and better environment.

For more information on 3M™ Polyurethane and Hybrid Adhesives & Sealants, go to www.3M.com/adhesives or call 1-800-362-3550.