

March, 2015

## 3M™ Industrial Adhesive 4799

### Product Description

3M™ Industrial Adhesive 4799 can be used to bond most EPDM rubber, sponge rubber, rubber sheeting, felt, canvas, linoleum and other lightweight materials to many metals, woods, concrete and plastics.

### Product Features

- Quick drying adhesive with fast strength buildup.
- Provides low soak-in on most porous substrate.
- Dries to a flexible, water resistant bond.



**Technical Information Note**

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

**Typical Physical Properties**

Property	Values		Notes
Color	Black		
Solids Content by Weight	28 to 35 %		
Flash Point	-14 °F	-26 °C	Closed Cup
Solvent Resistance	Petroleum Distillate, n-hexane and toluene		

**Typical Uncured Physical Properties**

Property	Values	Notes
Viscosity	7,500-18,000 cP	Brookfield Viscometer spindle #6 at 20 rpm
Base	SBR	
Net Weight	6.6 to 7 lb/gal	

**Typical Performance Characteristics**

180° Peel Adhesion	Dwell/Cure Time	Dwell Time Units	Temp C	Temp F
248 oz/in	24	hr	22C	72F
352 oz/in	72	hr	22C	72F
400 oz/in	120	hr	22C	72F
408 oz/in	168	hr	22C	72F
440 oz/in	2	wk	22C	72F
448 oz/in	3	wk	22C	72F
224 oz/in	3	wk	-34C	-29F
136 oz/in	3	wk	66C	150F
80 oz/in	3	wk	82C	180F

Property: 180° Peel Adhesion  
 Environmental Condition: 52%RH  
 Substrate: Canvas to Steel

## Handling/Application Information

### Application Equipment

Note: Appropriate application equipment can enhance adhesive performance. The user is responsible for evaluating application equipment in light of the user's particular purpose and method of application.

1. Pumping: Use a 5:1 ratio double acting, ball check pump with a 3 inch diameter air motor. All packings and glands in contact with the adhesive should be PTFE coated.
2. Hoses: Material hoses should be nylon lined with a working pressure of 500 psi or greater.
3. Brushes: Brushes designed for use with oil based paint may be used.

### Directions for Use

1. Surface Preparation: Surfaces to be bonded must be clean, dry and dust free. Wiping with a solvent such as methyl ethyl ketone (MEK)\* will aid in removing oil and dirt.
  2. Application Temperature: For best results the temperature of the adhesive and the surfaces being bonded must be at least 65°F (18°C).
  3. Application: Stir or agitate well before using.  
Porous Surface(s): Brush a uniform, generous coat of adhesive on the least porous surface to be bonded. Assemble the materials immediately with sufficient pressure to ensure contact.  
Non-Porous Surface(s): Apply a uniform coat of adhesive to each surface. Allow adhesive to dry until it is tacky, but does not transfer. Assemble materials with sufficient pressure to ensure contact.
  4. Cleanup: Excess adhesive may be removed with a solvent such as methyl ethyl ketone (MEK).\*
- \*Note: When using solvents, extinguish all sources of ignition in the area and follow the manufacturer's precautions and directions for use when handling such materials.

### Storage and Shelf Life

Store product at 60-80°F (16-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a "first in-first out" basis.  
When stored at the recommended conditions and kept in the original, unopened container, this product has a shelf life of 24 months from date of manufacture.

### Trademarks

3M is a trademark of 3M Company.

### References

Property	Values
3m.com Product Page	<a href="https://www.3m.com/3M/en_US/company-us/all-3m-products/-/3M-Industrial-Adhesive-4799?N=5002385+3293242409&amp;rt=rud">https://www.3m.com/3M/en_US/company-us/all-3m-products/-/3M-Industrial-Adhesive-4799?N=5002385+3293242409&amp;rt=rud</a>
Safety Data Sheet (SDS)	<a href="https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=4799">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=4799</a>

### ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

### Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

## Information

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