

March, 2015

## 3M™ Industrial Adhesive 4475

### Product Features

- Dries quickly to a firm bond.
- Excellent resistance to water, plasticizer migration, many detergent and soap solutions, oils and grease.
- A general purpose adhesive for bonding most vinyls, ceramics, glass, leather and cloth to a variety of substrates.



**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	Test Condition
Color	Clear		
Solids Content by Weight	41 to 45 %		
Flash Point	20 °F	Closed Cup	
Solvent Resistance	methyl ethyl ketone (MEK)		
Coverage	487 sq ft/gal	1 mil dry film	
Viscosity	6,500-10,500 cP	Brookfield Viscometer RVF #5 sp. @ 20 rpm	80°F(27°C)

**Typical Uncured Physical Properties**

Property	Values
Base	Synthetic Resin
Net Weight	8.3 lb/gal

**Typical Performance Characteristics**

180° Peel Adhesion	Dwell/Cure Time	Dwell Time Units	Temp C	Temp F
208 oz/in	24	hr	23C	72F
384 oz/in	72	hr	23C	72F
440 oz/in	120	hr	23C	72F
520 oz/in	168	hr	23C	72F
560 oz/in	2	wk	23C	72F
704 oz/in	3	wk	23C	72F
352 oz/in	3	wk	-34C	-29F
272 oz/in	3	wk	66C	150F
112 oz/in	3	wk	82C	180F

Property: 180° Peel Adhesion  
 Environmental Condition: 50%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

5-Gallon Pail Dispensing System

Pump – 9:1 ratio double acting ball check type pump, 11.0 cubic inches per cycle, 41/4" diameter air motor minimum.

Pail cover to be used to reduce solvent loss.

55-Gallon Drum Dispensing System

Pump – 10:1 ratio double acting ball check type pump, 11.0 cubic inches per cycle, 41/4" diameter air motor minimum, Bung mount type.

#### 2. Accessories

Hose – 1000 psi minimum working pressure, nylon lined. Flow rate at 40°F, 20 ft. of 3/4-ID plus 10 ft. 1/2-ID and a flow gun equals 1 pound/minute at pump air pressure of 75 psi.

#### 3. Chemical Resistance Requirements

Synthetic materials in contact with this product must be resistant to ketones and aromatic solvents. Compare, nylon or PTFE coatings are suggested for packings and gaskets.

### Directions for Use

1. Surface Preparation: Best results are achieved on clean, dry surfaces. Oil, grease and other contaminants can be removed by wiping with a solvent such as methyl ethyl ketone (MEK).\*

2. Application: Apply adhesive to one or both surfaces (best results are obtained by coating both surfaces) and bond immediately using firm pressure.

3. Drying Time: Allow to dry a minimum of 24 hours for maximum strength.

4. Cleanup: Remove unhardened or hardened material with cloth dampened with a solvent such as methyl ethyl ketone (MEK).\*

\*Note: When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

### Storage and Shelf Life

Best storage temperature is 60-80°F (16-27°C). 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 temperature in the original, unopened container, this product has a shelf life of 30 months from date of manufacture.

### Trademarks

3M is a trademark of 3M Company.

### References

Property	Values	Method
3m.com Product Page	<a href="https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-Industrial-Plastic-Adhesive-4475?N=5002385+3293193748&amp;rt=rud mil">https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-Industrial-Plastic-Adhesive-4475?N=5002385+3293193748&amp;rt=rud mil</a>	ASTM D3652
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=4475 in">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=4475 in</a>	ASTM D3652

### 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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