



Technical Data Sheet

3M™ Industrial Adhesive 4475



Product Details



Regulatory Info/SDS

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 Uncured Physical Properties

Attribute Name	Value
Net Weight	8.3 lb/gal
Base	Synthetic Resin

Typical Physical Properties

Attribute Name	Temperature	Value
Color		Clear
Solids Content by Weight		41 — 45 %
Carrier Solvent		methyl ethyl ketone (MEK)
Coverage		487 ft ² /gal ¹
Flash Point		20 °F ²
Viscosity	27 °C (80 °F)	6,500-10,500 cP ³

¹ 1 mil dry film

² Closed Cup

³ Brookfield Viscometer RVF #5 sp. @ 20 rpm

Typical Performance Characteristics

180° Peel Adhesion

Substrate: Canvas to Steel

Dwell Time	Temperature	Value
24 h	23 °C (73 °F)	208 oz/in
72 h	23 °C (73 °F)	384 oz/in
120 h	23 °C (73 °F)	440 oz/in
168 h	23 °C (73 °F)	520 oz/in
2 week	23 °C (73 °F)	560 oz/in
3 week	23 °C (73 °F)	704 oz/in
3 week	-34 °C (-29 °F)	352 oz/in
3 week	66 °C (150 °F)	272 oz/in
3 week	82 °C (180 °F)	112 oz/in

Handling/Application Information

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.

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.

Storage and Shelf Life

Store under normal conditions of 16° to 27°C (60° to 80°F) and 40 to 60% relative humidity in the original, unopened packaging, out of direct sunlight. Lower temperatures cause increased viscosity of a temporary nature. For best performance, use this product within 30 months from date of manufacture.

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

Automotive Disclaimer

Select Automotive Applications:

This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

Information

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