

3M

Scotch-Weld™

Hot Melt Adhesive

3798 LM

Technical Data

August, 2006

Product Description 3M™ Scotch-Weld™ Hot Melt Adhesive 3798 LM is a heat applied, 100% solids, removable, thermoplastic adhesive.

- Features**
- Easily removes from most substrates.
 - Easy to use and fast.
 - Obtains strength in seconds.
 - Made from components listed as indirect food additives under FDA regulations for adhesives (21 C.F.R. 175.105).
 - Tack free.
 - Solvent-free, 100% solids.
 - Stable release properties with accelerated aging at 120°F (49°).
 - Can be used on a wide variety of substrates including most coated substrates.

Typical Physical Properties

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

Color	Off White
Specific Gravity	0.91
Flash Point (COC)	474°F (246°C)
Viscosity @ 250°F⁽¹⁾ (121°C)	9,500 cps
Ball & Ring⁽²⁾	191°F (88°C)
Open Time⁽³⁾	30 Seconds

⁽¹⁾Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

⁽²⁾ASTM E-28-607.

⁽³⁾1/8" semicircular bead, cardboard to cardboard.

Application Ideas

Ideal for securing items in place while shrink-wrapping and can be used to attach business cards, coupons, inserts, credit cards, samples, etc. to brochures and mailings.

3M™ Scotch-Weld™ Hot Melt Adhesive 3798 LM

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- Application Techniques**
1. 3M™ Scotch-Weld™ Hot Melt Adhesive 3798 LM is designed for application using a 3M™ Scotch-Weld™ Hot Melt LT Applicator (5/8" x 2") at 265°F (129°C). This applicator is designed exclusively for low-melt adhesives.
 2. Apply to one surface. Make bond as soon as possible. Bond strength is maximized when open time is reduced.
 3. After the bond is made, there is immediate strength and no clamping is necessary.
 4. Optimum release on some substrates may require up to a 24 hour dwell time for clean removal.
 5. Adhesive may bleed onto porous surfaces or cause staining. It is advisable to evaluate the adhesive on a test substrate for undesirable effect.

Storage Store product below 120°F (49°C).

Shelf Life When stored at the recommended conditions, this product has a shelf life of 2 years from the 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 or (651) 737-6501.

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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.

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