



Hybrid Adhesive Sealant 750

Product Data Sheet

July 2009

Supersedes: March 2009

Product Description

3M™ Hybrid Adhesive Sealant 750 is a one component adhesive / sealant without isocyanates which forms permanent elastic bonds. It cures rapidly under the effect of atmospheric humidity to form a flexible and resistant joint with very good adhesion on most materials.

Is suitable for coach building and car repairing (under body protection, chassis, spoilers, boots...)

Key Features

Features	Advantages
One component/moisture curing	<ul style="list-style-type: none">No MixingSimplifies production
Neutral product	<ul style="list-style-type: none">no isocyanates
Seals dissimilar materials	<ul style="list-style-type: none">Gives design flexibility
Adheres to a wide variety of materials	<ul style="list-style-type: none">Multiple uses and design flexibility
Permanently elastic	<ul style="list-style-type: none">Provides long lasting bonds
Fast curing	<ul style="list-style-type: none">Speeds production
Paint-able	<ul style="list-style-type: none">yes

Technical Data

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.	
Properties	3M Hybrid Adhesive / Sealant 750
Tack-Free Time @ 23° C and 50% Relative Humidity	30 à 60 minutes
Rate of Cure @ 23° C and 50% Relative Humidity	> 3 mm per 24 hours
Shore A Hardness (ISO 868-3 seconds)	40 to 60
Density at 20° C	1,44 ± 0,05
Elongation at Break (ISO 37)	>100%
100% Modulus (ISO 37)	± 0,6 MPa (± 87 psi)
Sagging (ISO 7390)	none
Service Temperature	-40°C to + 90°C
Colours	Grey, beige , yellow
Application temperature	5°C to + 35°C
Consistency	paste

Resistance to dilute acids and bases	good
Water and salt spray resistance	Excellent
UV resistance	Excellent
Compatibility with paints	Water based : yes Solvent based : testing required

UV Properties The product has good resistance to UV aging and will retain strength and flexibility over long-term exposure to UV light. The white product may show some yellowing with long-term exposure to UV light.

Direction for use **Surface Preparation:**

Surfaces to be sealed should be clean and dry. Surfaces should be free from grease, mould release, oil, water/condensation and other contaminants that may affect the adhesion of the sealant. Abrading with 180 to 220 grit abrasive followed by a solvent wipe will improve the bond strength. Suitable solvents include 3M™ Citrus Based Adhesive Remover, 3M™ Scotch-Weld™ Solvent No. 2 or methyl ethyl ketone (MEK).*

***When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe product directions for use and precautionary measures. Refer to product label and MSDS for further precautions. Always pre-test solvent to ensure it is compatible with substrates.**

Application:

Puncture seal in nozzle and knock out the thin seal at cartridge bottom before placing in a pneumatic caulking gun. (For flex packs cut off the small crimp at the end and then place in caulking gun barrel with the open end up). Assemble tip and retaining ring on gun, cut tip to desired size. Product should be used within 24 hours after seal is punctured and should be pressed firmly into the joint to ensure adequate contact of the sealant with the substrate. Apply product when temperatures are between 5° C and 35° C. In cold weather, store the product at about 20 °C before use. Do not apply on frozen surfaces or wet surfaces. Do not apply over silicones or in the presence of curing silicones. Avoid contact with alcohol and solvents during curing. Sealant can be tooled immediately after applying to give desired appearance, such as using a putty knife to smooth the joint with soapy water. Avoid any contact with non-cured hybrid sealant during curing.

Cleanup:

While sealant is still soft cleaning can be done with the same solvents used for surface preparation. If sealant is already cured, removal is done mechanically with razor knife, piano wire, sanding or 3M™ Scotch-Brite™ Moulding Adhesive and Stripe Removal Disc. This disc is available from 3M Automotive Aftermarket Division.

Application Equipment Suggestions **Cartridge, Flex Pack, Bulk dispensing**
Please contact your local 3M representative

Storage	3M Hybrid Adhesive / Sealant 750 must be stored in the original, un-opened packaging between 5 and 25 °C for maximum shelf life. Rotate stock on a "first in-first out" basis.
Shelf Life	When stored at the recommended conditions in original un-opened packaging, 3M Hybrid Adhesive / Sealant 750 has a shelf life of 12 months after date of manufacture.
Precautionary Information	Refer to product label and Material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. www.3M.se
For Additional Information	To request additional product information or to arrange for sales assistance, call: 08-92 22 50 Address correspondence to: 3M Svenska AB, Industri, 191 89 Sollentuna

Important Notice

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method or application.

All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law

Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations

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