

# 3M Scotch-Grip™ Industrial Adhesive 4475

Technical Data

August, 2002

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## 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.

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## 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.

|                                 |   |
|---------------------------------|---|
| <b>Viscosity</b>                | 6,500 - 10,500                          |
| <b>Brookfield Viscometer</b>    | RVF #5 sp. @ 20 rpm @ 80°F              |
| <b>Solids Content (approx.)</b> | 41-45% (by wt.)                         |
| <b>Base</b>                     | Synthetic Resin                         |
| <b>Color</b>                    | Clear                                   |
| <b>Net Weight</b>               | 8.3 lbs./gal.                           |
| <b>Flash Point</b>              | 20°F CC                                 |
| <b>Coverage</b>                 | 487 sq. ft. per gallon (1 Mil Dry Film) |
| <b>Solvent</b>                  | Methyl ethyl ketone (MEK)               |

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**Application Equipment  
Suggestions**

**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, 4<sup>1</sup>/<sub>4</sub>" diameter air motor minimum.

Pail cover to be used to reduce solvent loss.

**55-Gallon Drum Dispensing System**

Pump – 10:1 ration double acting ball check type pump, 11.0 cubic inches per cycle, 4<sup>1</sup>/<sub>4</sub>" 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 <sup>3</sup>/<sub>4</sub>-ID plus 10 ft. <sup>1</sup>/<sub>2</sub>-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 Teflon®\* coatings are suggested for packings and gaskets.

\*Teflon is a registered trademark of E.I. duPont deNemours and Co.

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**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 solvent such as MEK or 3M™ Scotch-Grip™ Solvent No. 3\*
- 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 solvent such as methyl ethyl ketone (MEK) or Scotch-Grip™ Solvent No. 3\*

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

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| 180° Peel Strength – Canvas/Steel |            |                        |
|-----------------------------------|------------|------------------------|
| Time @ 75°F                       | Test Temp. | Value (lbs./in. width) |
| 1 day                             | 75°F       | 13                     |
| 3 days                            | 75°F       | 24                     |
| 5 days                            | 75°F       | 27.5                   |
| 7 days                            | 75°F       | 32.5                   |
| 2 wk.                             | 75°F       | 35                     |
| 3 wk.                             | 75°F       | 44                     |
| after 3 wk.                       | -30°F      | 22                     |
| after 3 wk.                       | 150°F      | 17                     |
| after 3 wk.                       | 180°F      | 7                      |

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## Storage

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.

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## Shelf Life

When stored at the recommended temperature in the original, unopened container, this product has a shelf life of 15 months.

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## 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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## For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550 or visit [www.3M.com/adhesives](http://www.3M.com/adhesives). Address correspondence to: 3M Engineered Adhesives Division, 3M Center, Building 220-7E-01, St. Paul, MN 55144-1000. Our fax number is 651-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

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## Important Notice

3M MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which 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 of application.

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## Limitation of Remedies and Liability

If the 3M product is proved to be defective, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including, but not limited to, contract, negligence, warranty, or strict liability.

ISO 9002

This Engineered Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.



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