

Adhesives Characteristics and Suggested Coverage

	6111/6111 Green	6111 HT/6111 HT Blue	6114	
Adhesive Characteristics	Description	Standard product	Higher heat resistance	Long open time
	Color	Tan/Green	Tan/Blue	Tan
	Open Time ⁽¹⁾ One surface (Foam/PVC)	1 minute	3 minutes	3 minutes
	Open Time ⁽¹⁾ Two surface (Foam/Foam)	6 minutes	8 minutes	14 minutes
	Heat Resistance ⁽²⁾	145°F (63°C)	175°F (79°C)	140°F (60°C)
	Peel Adhesion PIW ⁽³⁾			
	Fir	34.4	25.6	20.4
ABS	12.1	16.5	24.9	
Polypropylene	46.3	14.4	32.7	
PVC	9.9	16.3	8.8	
Cold Rolled Steel	16.5	29.9	11.4	
High Density Polyethylene	8.2	2.3	3.5	
Coverage		Smooth Surface	Textured Surface	
	2 Surface Application	1-2 grams per square foot	2-3 grams per square foot	
	1 Surface Application	3-5 grams per square foot	5-7 grams per square foot	

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

(1) Bonds were made by spraying adhesive onto 3/4 in. thick, 2 lb. density polyester urethane foam. Open time will vary depending on substrate.

(2) Tested per 3M AdhD test method C-3093 using 2 lb. dead load.

(3) According to 3M AdhD test method C-3012, 180° peel strength was determined at a cross head speed of 2 inches/minute at 73°F (23°C).