

3M™ Nitrile High Performance Plastic Adhesive 1099

Last Revision Date: May, 2022



Product Features

- 3M™ Nitrile High Performance Plastic Adhesive 1099 is a medium viscosity grade for most brush or flow applications.
- Fast drying.
- Provides strong, flexible bonds.
- Resists weathering, water, fuels, oil and plasticizers.
- Bonds vinyl extrusions and sheeting. (May stain light colored vinyls).
- Also bonds fabrics, foams and many plastics. (Not recommended for polyolefin plastic bonding).
- May be heat cured to obtain superior physical properties.

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 Physical Properties

Property	Values	Additional Information
Solids Content by Weight	31 to 37 %	
Color	Light Tan (wet and dry)	
Flash Point	0 °F	View
Notes: Closed Cup		
Flash Point	-18 °C	View
Notes: Closed Cup		
Solvent Resistance	Acetone	
Coverage	456 sq ft/gal	View
Notes: @ 2.5 g/ft ² dry wt.		
Viscosity	2000 to 4000 cP	View

Notes: Brookfield RVF #3 sp @ 10 rpm

Bonding Range

Up to 40 min






View 

Notes: 10 mil wet film 2 surfaces

Typical Uncured Physical Properties

Property	Values	Additional Information
Base	Nitrile Rubber	
Net Weight	7.3 to 7.5 lb/gal	

Typical Performance Characteristics

Property	Values	Additional Information
180° Peel Adhesion	264 oz/in	View 
Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	416 oz/in	View 
Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	376 oz/in	View 
Dwell/Cure Time: 120.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	440 oz/in	View 
Dwell/Cure Time: 168.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	496 oz/in	View 
Dwell/Cure Time: 2.0 Dwell Time Units: week Temp C: 23C Temp F: 72F Environmental Condition: 50%RH		

Substrate: Canvas to Steel

180° Peel Adhesion

480 oz/in

View 

Dwell/Cure Time: 3.0
 Dwell Time Units: week
 Temp C: 23C
 Temp F: 72F
 Environmental Condition: 50%RH
 Substrate: Canvas to Steel

180° Peel Adhesion


280 oz/in

View 

Dwell/Cure Time: 3.0
 Dwell Time Units: week
 Temp C: -34C
 Temp F: -29F
 Environmental Condition: 50%RH
 Substrate: Canvas to Steel

180° Peel Adhesion

112 oz/in

View 

Dwell/Cure Time: 3.0
 Dwell Time Units: week
 Temp C: 66C
 Temp F: 150F
 Environmental Condition: 50%RH
 Substrate: Canvas to Steel


180° Peel Adhesion

56 oz/in

View 

Dwell/Cure Time: 3.0
 Dwell Time Units: week
 Temp C: 82C
 Temp F: 180F
 Environmental Condition: 50%RH
 Substrate: Canvas to Steel

Overlap Shear Strength

2989 lb/in²View 

Dwell/Cure Time: 30.0
 Dwell Time Units: min
 Temp C: 177C
 Temp F: 300F
 Environmental Condition: +100 psi
 Substrate: Aluminum to Aluminum

Overlap Shear Strength

2409 lb/in²View 

Dwell/Cure Time: 30.0
 Dwell Time Units: min
 Temp C: 177C
 Temp F: 300F
 Environmental Condition: +100 psi
 Substrate: Aluminum to Aluminum

Overlap Shear Strength

1306 lb/in²View 

Dwell/Cure Time: 30.0
 Dwell Time Units: min
 Temp C: 177C
 Temp F: 300F
 Environmental Condition: +100 psi
 Substrate: Aluminum to Aluminum

Overlap Shear Strength

897 lb/in²View 

Dwell/Cure Time: 30.0
 Dwell Time Units: min
 Temp C: 177C
 Temp F: 300F
 Environmental Condition: +100 psi
 Substrate: Aluminum to Aluminum

Overlap Shear Strength

643 lb/in²View 

Dwell/Cure Time: 30.0
 Dwell Time Units: min
 Temp C: 177C
 Temp F: 300F
 Environmental Condition: +100 psi
 Substrate: Aluminum to Aluminum

Overlap Shear Strength

607 lb/in²View 

Dwell/Cure Time: 30.0
 Dwell Time Units: min
 Temp C: 177C
 Temp F: 300F
 Environmental Condition: +100 psi
 Substrate: Aluminum to Aluminum

Overlap Shear Strength

467 lb/in²View 

Dwell/Cure Time: 30.0
 Dwell Time Units: min
 Temp C: 177C
 Temp F: 300F
 Environmental Condition: +100 psi
 Substrate: Aluminum to Aluminum

Storage and Shelf Life

Store product at 60-80°F (16-27°C) for maximum storage life. Higher temperatures can reduce normal storage life. Lower temperatures can cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis.

When stored at the recommended conditions in the original, unopened container this product has a shelf life of 24 months from date of manufacture.

Bottom Matter

3M

Industrial Adhesives and Tapes Division

3M Center, Building 225-3S-06 St. Paul, MN 55144-1000

800-362-3550 • 877-369-2923 (Fax)

www.3M.com

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Handling/Application Information

Application Equipment

Note: Appropriate application equipment can enhance adhesive performance. We suggest the following application equipment for the user's evaluation in light of the user's particular purpose and method of application.

1. Pumping:

3M™ Nitrile High Performance Plastic Adhesive 1099, 1099-L*

5 Gallon or less dispensing system:

Pressure pot 100 psi operating pressure. Fluid hose should be nylon lined.

55 Gallon dispensing system:

Pump – 2:1 ratio, double acting, ball type checks, bung mounting, divorced design.

*Synthetic materials such as packings, seals and hose lines must be resistant to the solvent in these adhesives. nylon, compar, and PTFE lined or coated parts are suggested.

2. Spray:

Plastic Adhesive 1099-L: Production

Type Spray Equipment

Note: This adhesive is not recommended for airless spraying.

12-3 H.P. Compressor for intermittent use.

4 H.P. Compressor for continuous use.

2To Measure Fluid Flow: Pressurize fluid source only; pull trigger; flow material into measuring device for 60 seconds, increase or decrease fluid source pressure to obtain desired fluid flow.

All material hoses should be nylon or PVA lined.

3. Brush/Roller: Typical brushes designed for oil based paints may be used.

Directions for Use

1. Surface Preparation: Remove all dust, dirt, oil, grease, wax, loose paint, etc.

Wiping with methyl ethyl ketone (MEK)* or 3M™ Citrus Base Cleaner* will aid in preparing the surface for bonding.

2. Application Temperature: For best results, the temperature of the adhesive and surfaces should be at least 65°F (18°C).

3. Application: Stir well before using.

Porous Surface(s): Brush, flow or spray a thin, even coat of adhesive to one or both surfaces. Coating both surfaces is preferred since it gives greater strength and permits longer open time before bonding. Very absorbent materials may require more than one coat. Bond while adhesive is still wet or aggressively tacky. Join surfaces with firm pressure.

Non-Porous Surface(s): Brush, flow or spray a thin, even coat of adhesive to both surfaces. Allow adhesive to dry until tacky. Join surfaces with firm pressure.

4. Drying Time: Drying time depends on temperature, humidity, air movement, and porosity of the materials bonded. Greater immediate strength may be obtained by heat or solvent reactivation. See Reactivation below.

5. Reactivation: To solvent reactivate, coat both surfaces with adhesive. Allow to dry tack-free. Lightly wipe one surface with a solvent such as methyl ethyl ketone (MEK).* Complete bond within 30 seconds.

To heat reactivate, coat both surfaces with adhesive. Allow adhesive to dry completely. Reactivate by heating one or both surfaces to a minimum of 180°F (82°C). Assemble immediately (while hot), using firm pressure to ensure contact.

6. Curing: 3M™ Nitrile High Performance Plastic Adhesive 1099 and 1099-L may be heat cured to obtain superior properties. Cure assembled parts at time and temperature listed using 100 psi pressure on the bond line.

Temperature of Bondline Time for Minimum Cure

200°F (93°C) 120 minutes

240°F (116°C) 40 minutes

280°F (138°C) 12 minutes

320°F (160°C) 8 minutes

360°F (182°C) 5 minutes

400°F (204°C) 2 minutes

7. Cleanup: Excess adhesive may be removed with methyl ethyl ketone (MEK)* or acetone,* preferably while adhesive is still wet.

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

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/p/d/b40069663/
Safety Data Sheet SDS	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=1099

Family Group

Link Tags:

- [1099](#)
- [1099-L](#)

Products	Solids Content by Weight	Color
1099	31 to 37 %	Light Tan (we and dry)
1099-L	22 to 26 %	Light Tan (we and dry)

ISO Statement

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

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.

Information

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