



3M™ Industrial Adhesive 4475

Last Revision Date: June, 2022

Product 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.

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	41 to 45 %	

Color	Clear	
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Flash Point	20 °F	View 
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Notes: Closed Cup

Coverage	487 sq ft/gal	View 
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Notes: 1 mil dry film

Viscosity	6,500-10,500 cP	View 
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Notes: Brookfield Viscometer RVF #5 sp. @ 20 rpm

Typical Uncured Physical Properties

Property	Values	Additional Information
Base	Synthetic Resin	

Net Weight	8.3 lb/gal	
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Typical Performance Characteristics

Property	Values	Additional Information
180° Peel Adhesion	208 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	384 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	440 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	520 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	560 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	704 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	352 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	272 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

112 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

Storage and Shelf Life

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.

When stored at the recommended temperature in the original, unopened container, this product has a shelf life of 30 months from date of manufacture.

Bottom Matter

3M

Industrial Adhesives and Tapes Division

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Handling/Application Information

Application Equipment

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, 41/4" diameter air motor minimum.

Pail cover to be used to reduce solvent loss.

55-Gallon Drum Dispensing System

Pump – 10:1 ratio double acting ball check type pump, 11.0 cubic inches per cycle, 41/4" 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 3/4-ID plus 10 ft. 1/2-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 PTFE coatings are suggested for packings and gaskets.

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 a solvent such as methyl ethyl ketone (MEK).*

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 a solvent such as methyl ethyl ketone (MEK).*

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

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/p/d/b40067945/
Safety Data Sheet SDS	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=4475

Family Group

Link Tags:

• [4475](#)

Products	Solids Content by Weight	Color
4475	41 to 45 %	Clear

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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