3M Science. Applied to Life.™



Solutions for your assembly challenges.

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3M Industrial Adhesives and Tapes

Design & Production Guide | June 2024

5,000+

adhesive and tape SKUs

Do it your way.

- 3M systems are built around *your* manufacturing processes, not the other way around.
- Whether it's structural or non-structural adhesives, bonding tapes or reclosable fasteners, 3M solutions ensure speed, convenience and ease of use.



88,667

employees

Do it together.

- No matter what you need to bond, you can count on 3M's expertise, technologies and 88,667 dedicated employees to help you find solutions.
- From wood, metal, foil, insulation, foam, fabric and panel lamination to specialty high performance and multipurpose materials of every kind, solutions are one call away.



Finding your 3M Adhesive & Tape Assembly Solutions

100,000

patents

Do it boldly.

- 3M has been a world leader in bonding technology for decades and we have the patents to prove it.
- Quality, consistency and reliability — the attributes you look for in a bonding solution — help drive our quest for new innovations.



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chance to do it right

Do it responsibly.

- Sustainability is a natural extension of 3M's corporate values.
- We developed the first water-based contact adhesive ever — more than 40 years ago.
- We have a wide selection of Low VOC products that help contribute to LEED® credits and are GREENGUARD Certified.

What can 3M™ Adhesives and Tapes do for your product and process?

Build strong, durable products:

- From repositionable to permanent, 3M has an adhesive or tape that can be readily matched to the substrate and stress characteristics needed in the joint.

Improve appearance and aesthetics:

- 3M adhesives and tapes are generally hidden between the bonded substrates, offering nearly invisible fastening.
- Surfaces stay smooth and clean for a more attractive appearance and less surface refinishing.

Lower production and material costs:

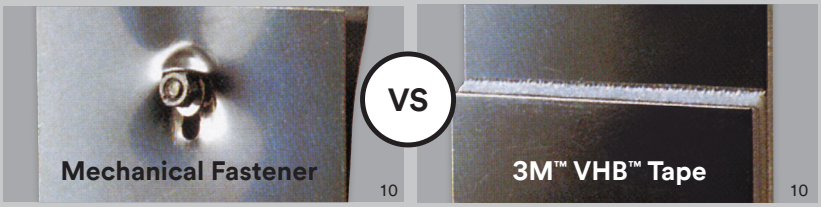
- Reduce process steps such as weld grinding and sealing individual penetrations from screws, nuts and bolts.
- Use thinner, lighter or less expensive materials that cannot be welded or fastened traditionally.
- Potentially lower capital investment. Many adhesives and tapes do not require major capital to use.
- Manage labor costs. Many tape and adhesive technologies require little operator training.

Build products with a continuous bond line:

- Adhesives and tapes uniformly distribute stress along the entire joint. Nuts, bolts and other fasteners concentrate stress at a point which can decrease physical properties of the substrates being assembled.
- Bond and seal simultaneously. Many 3M adhesives and tapes will provide a strong bond, but are also an effective seal against dirt, dust, water and other environmental conditions.
- Good fatigue resistance. If your parts are subject to vibration or other movement, the viscoelastic nature of 3M adhesives and tapes will impart flexibility to a joint or bonded area.

Wider material selection for assemblies:

- Lighter and thinner materials can be used. Welding and fastening weaken substrates and require a minimum thickness to retain integrity.
- Bond dissimilar materials. 3M adhesives and tapes bond to a wide range of substrates from metals, wood, glass, plastics and ceramics. This includes “hard to bond,” low surface energy materials.
- Prevent galvanic corrosion. 3M adhesives and tapes can provide a film barrier to reduce or prevent bimetallic corrosion that can occur when joining to different types of metals.



With uniform stress distribution of adhesives and tapes, lighter, thinner materials can be used without concerns about distortion, splitting, or crazing at the mechanically fastened site. Elimination of holes in metal also reduces the chances for rust and corrosion.

3M™ Adhesives and Tapes Product Family



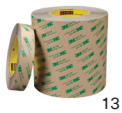
3M™ VHB™ Tapes



3M™ Scotch-Weld™ Structural Adhesives



3M™ Adhesive Sealants



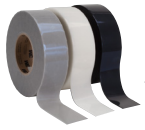
3M™ Adhesive Transfer Tapes



3M™ Contact and Spray Adhesives



3M™ Double Coated Tapes



3M™ Extreme Sealing Tapes



3M™ Hot Melt Adhesives



3M™ Reclosable Fasteners



3M™ Scotch-Weld™ Gasket Makers



3M™ Scotch-Weld™ Instant Adhesives



3M™ Scotch-Weld™ PUR Adhesives



3M™ Scotch-Weld™ Retaining Compound



3M™ Scotch-Weld™ Threadlockers

Considerations when selecting 3M™ Adhesives and Tapes for your product and process.

A + S + P + E + C

Assembly

What type of assembly is required? (Refer to 7 common assembly types in the right hand column.)

What are the overall performance needs of the assembly (flexibility, high peel strength, etc.)?

Substrate

What are the materials that are being bonded together? (Refer to the substrate selectors for each assembly type on pages 4–15.)

Consider the surface condition texture of each material.

Process

What is the current assembly and manufacturing process?

Does the solution need to fit into the current process/ equipment or can the process/equipment change?

What are the various process steps and how quickly will the assembly be moved to each step?

At any time, might the assembly bond need to be repositioned? If so, why and when?

Are there any environmental, regulatory or workplace safety restrictions?

End-Use

How and where is the final product used?

Will the assembly be exposed to harsh environmental conditions (UV, chemicals, high humidity, very high or low temperatures, etc.)?

Cost

Where can improvements be made in the assembly process (labor, reduction of process steps, materials, workflow, etc.)?

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Assembly Solutions are made up of these common applications:


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Panel to Frame/ Stiffener to Panel
pg 4


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Small Joint Assembly
pg 6


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Large Surface Lamination
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Mounting and Trim Attachment
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Gasket Attachment
pg 12


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Sealing
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Potting and Encapsulating
pg 14

Substrates and Adhesion — A Surface Phenomenon, So Know Surfaces Well.

Adhesive attaches to the surfaces of two substrates, unlike a process that fuses the substrates into a unified whole such as welding or solvent activation of plastics. When selecting a 3M adhesive or tape, surface condition must be considered: roughness, smoothness, porosity, coated, uncoated, cleanliness, flexibility size of part and surface energy of part.

Adhesive paste, for example, flows readily into a rough surface for improved effective adhesion. Flexible materials such as paper or thin gauge metal can be bonded with thin adhesive transfer tape. Large rigid parts with smooth clean surfaces can be bonded with a variety of 3M product ranging from double-coated foam tapes to two-part structural adhesives. Some plastics have plasticizers which migrate to the surface and degrade the bond over time, so plasticizer-resistant adhesive or tape is essential. If the surface has been powder coat painted, the coating is the bonding surface rather than the substrate, and you would want to consider a 3M tape or adhesive developed specifically for the surface.

Surface energy ranges from high to low. To illustrate the concept of surface energy, think of water on an unwaxed hood of a car. The unwaxed hood has high surface energy and the water on the hood flows into puddles. In comparison, a waxed hood has low surface energy and the water beads up rather than flow out. Similar to water, adhesive on a high surface energy flows and "wets out" the surface. "Wetting out" is required to form a strong bond.

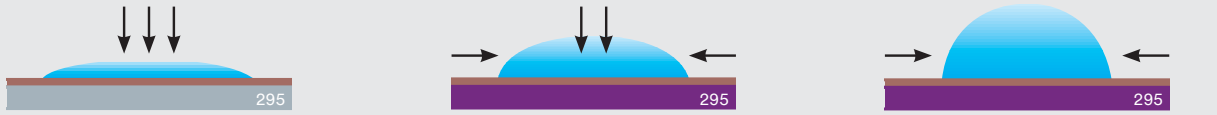
As a rule of thumb, the higher the surface energy, the greater the strength of the adhesion.

Specially formulated adhesives are available for low surface energy surfaces. The following illustrations and surface rankings give an idea of the relative surface energy.

Regardless of surface energy, the substrate must be unified, dry and clean to maximize adhesive contact.

Surface Energy Chart

Metal Surfaces (High Surface Energy) | **High Surface Energy Plastics (HSE)** | **Low Surface Energy Plastics (LSE)**



mJ/m²	Surfaces
1103	Copper
840	Aluminum
753	Zinc
526	Tin
458	Lead
700–1100	Stainless Steel
250–500	Glass Porcelain

mJ/m²	Surfaces
50	Polyimide Industrial Film
47	Phenolic
46	Nylon
45	Alkyd Enamel
43	Polyester

mJ/m²	Surfaces
43	Epoxy Paint
43	Polyurethane Paint
42	ABS
42	Polycarbonate
39	PVC Rigid
38	Modified PPE Resin
38	Acrylic

mJ/m²	Surfaces
37	PVA
36	Polystyrene
36	Acetal
33	EVA
31	Polyethylene
29	Polypropylene
28	Polyvinyl Fluoride Film
18	PTFE
Broad Range	Powder Coated Paints

Note: These values are provided as a guide. Formulation modifications can substantially alter surface energies.

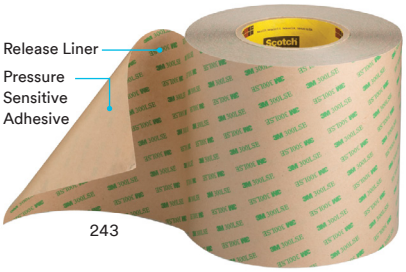
3M™ Adhesive Transfer Tapes

Neat, Precise Application and High Performance in a Variety of Applications

3M™ Adhesive Transfer Tapes are rolls of pressure sensitive adhesive pre-applied to a special release liner.

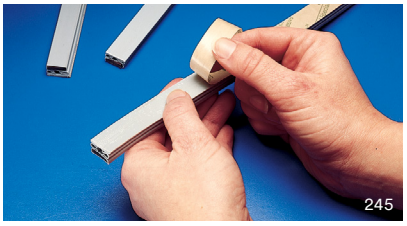
For application, the tape is simply pressed, adhesive side down, to a surface and the liner is peeled off.

A variety of adhesive properties and liners are available to meet requirements for applications such as nameplate attachment to high and low surface energy plastics, appliance graphic overlays that perform in high temperatures, foam gasketing, web splicing and more.

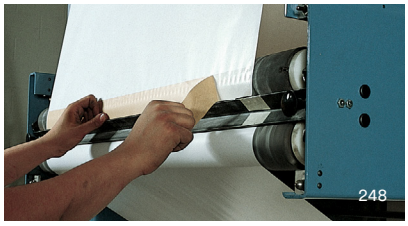




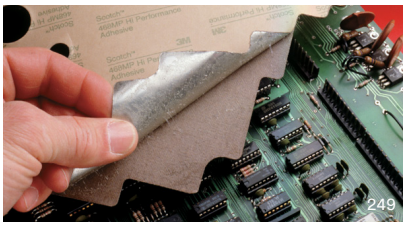
With high cohesive strength, 3M™ Adhesive 200MP bonds aggressively with excellent temperature resistance. Meets the non-fogging specifications of the automotive industry.



For bonding flexible vinyl in such applications as door gaskets, 3M™ Adhesive Transfer Tape F9465PC resists the effect of plasticizers that tend to migrate from the vinyl.



3M™ Adhesive Transfer Tape 465 has the grab strength for many printing splices, including flying splices, zero speed and manual overlap. Can be used with a variety of paper grades.



3M™ Adhesive Transfer Tape 467MP is used to laminate metal foil to a circuit board to reduce interference on electronic circuitry.



For graphic beauty, 3M™ Acrylic Adhesive 100 attaches graphics in closed environments. With low odor, reduced outgassing and low fogging, it is used extensively in the automotive, aerospace and appliance industries.

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3M™ Adhesive Transfer Tapes



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Product	Description/Application Ideas	Adhesive Caliper (mils)	Liner		Master Size	Specs	Adhesion				Chem. Resist.	Temp. Range	
			Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
100MP* (High Performance Acrylic)													
F9460PC	High performance industrial joining and metal fabrication.	2	58# PCK	4.2	60 in. x 180 yd.	UL	10	7	1	2	10	-40	500
F9469PC	High performance industrial joining and metal fabrication.	5	58# PCK	4.2	60 in. x 180 yd.	UL	10	7	1	2	10	-40	500
F9473PC	High performance industrial joining and metal fabrication.	10	58# PCK	4.2	60 in. x 180 yd.	UL	10	7	1	2	10	-40	500
200MP (High Performance Acrylic)													
467MC	Same as 467MP with a paper MicroChannel liner to aid in bubble and wrinkle free graphic attachment.	2	58# PCK	4.2	54 in. x 180 yd.	–	10	9	1	3	9	-40	400
467MCF	Same as 467MP with a polyester MicroChannel liner to aid in bubble and wrinkle free graphic attachment.	2	PET	4.2	54 in. x 180 yd.	–	10	9	1	3	9	-40	400
467MP	Graphic attachment and general industrial joining. Industry standard. 60 in. width master also available.	2	58# PCK	4.2	48 in. x 180 yd.	UL MH	10	9	1	3	9	-40	400
467MPF	Polyester liner for rotary processing of graphic and die cut parts.	2	PET	2.0	54 in. x 180 yd.	UL	10	9	1	3	9	-40	400
468MC	Same as 468MP with a paper MicroChannel liner to aid in bubble and wrinkle free graphic attachment.	5	58# PCK	4.0	54 in. x 180 yd.	–	10	9	1	3	9	-40	400
468MCF	Same as 468MP with a polyester MicroChannel liner to aid in bubble and wrinkle free graphic attachment.	5	PET	4.0	54 in. x 180 yd.	–	10	9	1	3	9	-40	400
468MP	Industry standard for graphic attachment and die cut parts. 60 in. width master also available.	5	58# PCK	4.2	48 in. x 180 yd.	UL MH	10	9	1	3	9	-40	400
468MPF	Thicker version of 467MPF.	5	PET	2.0	54 in. x 180 yd.	UL	10	9	1	3	9	-40	400
9667MP	Same as 467MP on heavy, lay-flat liner for kiss-cutting. 48 in. width master also available.	2	83# PCK	6.2	54 in. x 180 yd.	UL	10	9	1	3	9	-40	400
9668MP	Same as 468MP on heavy, lay-flat liner. 48 in. width master also available.	5	83# PCK	6.2	54 in. x 180 yd.	UL MH	10	9	1	3	9	-40	400
9668MPL	Better lay-flat properties.	5	94# PCK	7.0	60 in. x 180 yd.	–	10	9	1	3	9	-40	400
220 (Industrial Acrylic)													
9502	Economical attachment of graphics and industrial joining. 60 in. width master also available.	2	58# PCK	4.2	48 in. x 180 yd.	UL	8	7	1	2	8	-40	350
9505	Thicker version of 9502 for textured surfaces. 60 in. width master also available.	5	58# PCK	4.2	48 in. x 180 yd.	UL	8	7	1	2	8	-40	350
9552	Double-lineredlaminating adhesive version of 9502.	2.3	58/58# PCK	4.2	48 in. x 360 yd.	UL	8	7	1	2	8	-40	350
9555	Double-lineredlaminating adhesive version of 9505.	4.9	58/58# PCK	4.2	48 in. x 360 yd.	UL	8	7	1	2	8	-40	350

*Products in this platform are 3M™ VHB™ Tapes offering our highest strength.
MH meets Mil-P-19834B Type I.

Values: 1 = Lowest Performance; 10 = Highest Performance

Rankings are a general guide. Adhesives should be tested with actual components to ensure acceptable performance.

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3M™ Adhesive Transfer Tapes



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Product	Description/Application Ideas	Adhesive Caliper (mils)	Liner		Master Size	Specs	Adhesion				Chem. Resist.	Temp. Range	
			Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
290 (Low Outgassing Acrylic)													
501FL	Ultra-clean adhesive for low outgassing applications.	1	PET	2.0	54 in. x 180 yd.	–	9	7	1	2	9	-40	450
502FL	Ultra-clean adhesive for low outgassing applications.	2	PET	2.0	54 in. x 180 yd.	–	9	7	1	2	9	-40	450
300 (High Strength Acrylic)													
927	Attach gaskets and a variety of industrial foam materials.	2	60# DK	3.5	48 in. x 180 yd.	–	7	9	9	9	6	-40	250
950	Thicker version of 927.	5	60# DK	3.5	48 in. x 180 yd.	UL	7	9	9	9	6	-40	250
950EK	Thicker version of 927 with extensible Kraft liner.	5	78# EK	6.0	48 in. x 180 yd.	–	7	9	9	9	6	-40	250
992U	For performance-engineered labels. UV indicator in adhesive.	2	55# DK	3.2	48 in. x 180 yd.	UL	7	9	9	9	6	-40	250
9458	Thin, high tack adhesive for rotary processing HSE and LSE parts.	1	55# DK	3.2	54 in. x 360 yd.	UL	7	9	9	9	6	-40	250
9459W	White version of laminating adhesive 9459S.	1.5	55# DK	3.2	48 in. x 360 yd.	UL	7	9	9	9	6	-40	250
9471	For smooth LSE plastics.	2	60# DK	3.5	48 in. x 180 yd.	UL MH	7	9	9	9	6	-40	250
9472	5.0 mil version of 9471; for textured surfaces.	5	60# DK	3.5	48 in. x 180 yd.	UL MH	7	9	9	9	6	-40	250
9653	A 3.5 mil version of 9471 on a heavy, lay-flat liner for kiss-cutting.	3.5	83# PCK	6.2	48 in. x 180 yd.	UL	7	9	9	9	6	-40	250
9671	Heavier linered version of 9471 for easy handling, lay-flat properties.	2	83# PCK	6.2	48 in. x 180 yd.	UL MH	7	9	9	9	6	-40	250
9672	Heavier linered version of 9472 for easy handling, lay-flat properties.	5	83# PCK	6.2	48 in. x 180 yd.	UL	7	9	9	9	6	-40	250
9673	Same as 9671 with unprinted liner.	2	83# PCK	6.2	48 in. x 180 yd.	UL MH	7	9	9	9	6	-40	250
300FR (Flame Retardant)													
9372W	Flame retardant. Moisture stable liner.	2	83# PCK	6.2	60 in. x 180 yd.	UL	8	9	9	9	6	-40	250
9372DKW	Flame retardant. Rotary diecuttable liner.	2	55# DK	3.2	60 in. x 180 yd.	UL	8	9	9	9	6	-40	250
9375W	Flame retardant. Moisture stable liner.	5	83# PCK	6.2	60 in. x 180 yd.	UL	8	9	9	9	6	-40	250

*Products in this platform are 3M™ VHB™ Tapes offering our highest strength.
MH meets Mil-P-19834B Type I.

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			Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
300LSE (Low Surface Energy Acrylic)													
9453FL	Film linered version of 9453LE for rotary processing.	3.5	PET	2.0	54 in. x 180 yd.	UL	9	10	10	1	7	-40	300
9453LE	A 3.5 mil version of 9471LE for application to rough surfaces. 48 in. master width available.	3.5	58# PCK	4.2	54 in. x 180 yd.	UL	9	10	10	1	7	-40	300
9471FL	Film linered version of 9471LE for rotary processing.	2.3	PET	2.0	54 in. x 180 yd.	UL	9	10	10	1	7	-40	300
9471LE	Bonds graphics to powder coatings, LSE plastics and oily materials.	2.3	58# PCK	4.2	54 in. x 180 yd.	UL	9	10	10	1	7	-40	300
9472FL	A 5 mil version of 9471LE with film liner for textured surfaces.	5.2	PET	2.0	54 in. x 180 yd.	UL	9	10	10	1	7	-40	300
9472LE	Thicker adhesive for textured LSE plastics and powder coatings.	5.2	58# PCK	4.2	54 in. x 180 yd.	UL	9	10	10	1	7	-40	300
9653LE	Heavy linered 9453LE for easy handling and lay-flat properties.	3.5	83# PCK	6.2	54 in. x 180 yd.	UL	9	10	10	1	7	-40	300
9671LE	Heavy linered 9471LE for easy handling and lay-flat properties.	2.3	83# PCK	6.2	54 in. x 180 yd.	UL	9	10	10	1	7	-40	300
9672LE	Heavy linered 9472LE for easy handling and lay-flat properties.	5.2	83# PCK	6.2	54 in. x 180 yd.	UL	9	10	10	1	7	-40	300
300MP+ (High Tack Acrylic)													
9772WL+	Provides excellent bond to various fabricated foams, fabrics and substrates.	2	96# PCK	7.0	60 in. x 360 yd.	–	7	7	4	9	–	-40 (-40)	–
9773WL+	Provides excellent bond to various fabricated foams, fabrics and substrates.	3	96# PCK	7.0	60 in. x 360 yd.	–	7	7	4	9	–	-40 (-40)	–
9774WL+	Provides excellent bond to various fabricated foams, fabrics and substrates.	4	96# PCK	7.0	60 in. x 360 yd.	–	7	7	4	9	–	-40 (-40)	–
9775WL+	Provides excellent bond to various fabricated foams, fabrics and substrates.	5	96# PCK	7.0	60 in. x 360 yd.	–	7	7	4	9	–	-40 (-40)	–
320 (High Tenacity Acrylic)													
9447	Designed for use with 3M™ Label Component Systems.	1	55# DK	3.2	54 in. x 360 yd.	–	5	5	1	1	5	-60	250
350 (High Performance Acrylic)													
9442	Excellent temperature and solvent resistance; high bond to low surface energy substrates.	2	55# DK	3.2	48 in. x 180 yd.	UL	9	10	10	9	8	-40	450
9445	Thicker version of 9442.	5	55# DK	3.2	48 in. x 180 yd.	UL	9	10	10	9	8	-40	450
9482PC	High tack and shear strength; excellent adhesion to plastics and foams.	2	58# PCK	4.2	48 in. x 180 yd.	UL	9	10	10	9	8	-40	450
9485EK	Thicker version of 9482PC with an extensible Kraft liner.	5	78# EK	6.0	48 in. x 180 yd.	–	9	10	10	9	8	-40	450
9485PC	A 5 mil version of 9482PC.	5	58# PCK	4.2	48 in. x 180 yd.	UL	9	10	10	9	8	-40	450
9675	Heavy linered version of 9485PC for easy handling, lay-flat properties.	5	83# PCK	6.2	48 in. x 180 yd.	–	9	10	10	9	8	-40	450

*Manufactured using a solventless adhesive coating process.

Values: 1 = Lowest Performance; 10 = Highest Performance

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3M™ Adhesive Transfer Tapes

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			Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
400 (Acrylic Adhesive)													
463	High tack and excellent adhesion to most paper stocks. For automatic dispensing.	2	60# DK	3.5	48 in. x 180 yd.	–	5	5	5	4	5	-60	250
465	Same as 463, but with easy liner release for manual or hand application.	2	60# DK	3.5	48 in. x 180 yd.	–	5	5	5	4	5	-60	250
9457	Adhesive with long term stability, excellent outdoor performance and UV resistance. Adhesive 400 is best if necessary to apply at cooler temperatures.	1	55# DK	3.2	54 in. x 360 yd.	UL	5	5	5	4	5	-60	250
9665	Thicker version of 9457.	2	58# PCK	4.2	48 in. x 180 yd.	–	5	5	5	4	5	-60	250
420 (Acrylic Adhesive)													
F9752PC	High tack; can be applied in temperatures as low as 32°F (0°C).	2	58# PCK	4.2	54 in. x 360 yd.	–	7	7	8	4	6	-40	300
F9755PC	Thicker version of F9752PC for textured surfaces.	5	58# PCK	4.2	54 in. x 360 yd.	–	7	7	8	4	6	-40	300
430 (Acrylic Adhesive)													
9497	Pink tinted high temperature splicing tape.	2	60# DK	3.5	48 in. x 360 yd.	–	6	6	5	4	5	-40	350
9499	Transparent version of 9497.	2	60# DK	3.5	48 in. x 360 yd.	–	6	6	5	4	5	-40	350
Specialty Acrylic													
9379	Jet fuel and hydraulic fluid resistant adhesive transfer tape.	2	PET	2	48 in. x 200 yd.	MH*	9	8	1	2	9	-40	350
9380	Thicker version of 9379.	5	PET	2	48 in. x 200 yd.	MH*	9	8	1	2	9	-40	350
F9465PC	Vinyl plasticizer resistant adhesive.	5	58# PCK	4.2	54 in. x 360 yd.	–	10	10	7	5	5	-40	200
F9467U	Vinyl plasticizer resistant adhesive.	3.5	58# PCK	4.2	54 in. x 180 yd.	–	10	10	7	5	5	-40	200
Silicone													
91022	Silicone attachment. Silicone linered for easier processing.	2	White PET	2	48 in. x 180 yd.	–	9	8	7	6	10	-40	500

*MH meets Mil-P-19834B Type I.

Values: 1 = Lowest Performance; 10 = Highest Performance

Rankings are a general guide. Adhesives should be tested with actual components to ensure acceptable performance.

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

Scotch® ATG Adhesive Transfer Tapes

Finger Touch Application of Pressure Sensitive Adhesive

Versatility, convenience and speed. That's what you get with Scotch® ATG Adhesive Transfer Tapes for assembly operations in businesses ranging from appliance and printing to P.O.P. and electronics. Readily bond, join, mount, or laminate materials such as paper, plastics, metal, foam and more.

With Scotch® ATG Applicators, a touch of the finger triggers a quick, controlled application of Scotch® ATG Adhesive Transfer Tape at the same time as the liner rewinds into the applicator. There is no mess and no cleanup. 3M advanced acrylic adhesive bonds on contact and is formulated with a choice of properties such as high temperature resistance, differential tack, adhesion to low surface energy plastic and more.



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Save time and effort with Scotch® ATG Adhesive Transfer Tapes and Applicators. You apply a precise strip of adhesive at the same time as the liner rewinds into the applicator.



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Scotch® ATG Applicator 700 with Scotch® ATG Adhesive Transfer Tape 924 makes fast work of folder assembly. Pressure sensitive adhesive bonds immediately and the folder pocket is ready to hold contents.



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Scotch® ATG Applicator 700 for 3/4" and 1/2" wide tape



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Scotch® ATG Applicator 714 for 1/4" wide tape



255

Scotch® ATG Applicator 752C for 3/4", 1/2" and 1/4" wide tape (1/4" adapter purchased separately)


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Scotch® ATG Applicator 3662 for 2" wide tape

Product	Tape Thickness w/o Liner mils (mm)	Description	Temperature Resistance		Solvent Resistance	Relative Adhesion		Application Ideas	Adhesive Transfer Tape Equivalent
			Min Hr	Days Weeks		HSE	LSE		
350 (Firm Acrylic)									
926	5 (0.13)	High adhesion, excellent shear holding power to a variety of substrates. UV resistant.	450°F (232°C)	300°F (149°C)	Very Good	High	Med-High	Nameplates on award plaques, bonding foam insulation.	—
300 (Soft Acrylic)									
969	5 (0.13)	Very high initial adhesion, good shear holding power to a variety of materials including plastics.	250°F (121°C)	180°F (82°C)	Med	High	Med-High	Assemble point of purchase displays, attach fabric swatches in sample books.	—
300 (High Tack Acrylic)									
976	2 (0.05)	High tack. Excellent adhesion to most plastics.	250°F (121°C)	150°F (65°C)	Med	High	High	Attach fabric swatches in sample books.	927
400 (General Purpose Adhesive)									
924	2 (0.05)	General purpose. Excellent adhesion to most paper stocks.	250°F (121°C)	180°F (82°C)	Med	Med	Low	Seal pocket in folders. Bond mat board in picture frames. Splice paper, films, foils. General purpose bindery attaching.	465
987*	1.7 (0.040)	General purpose. Excellent adhesion to most paper stocks.	250°F (121°C)	180°F (82°C)	Med	Med	Low	Seal pocket in folders. Bond mat board in picture frames. Splice paper, films, foils. General purpose bindery attaching.	9498

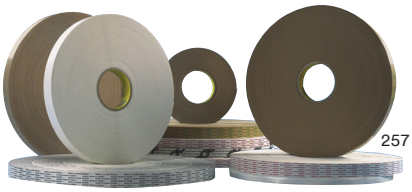
*3M Brand. **Relative Adhesion: HSE** – High Surface Energy; LSE – Low Surface Energy

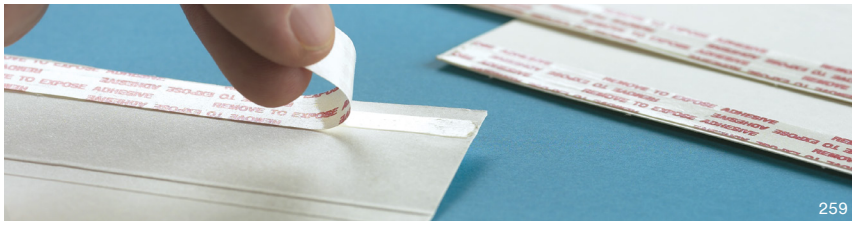
Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Extended Liner Tapes

Versatile Pressure Sensitive Adhesive on Easy-to-Remove Liners

3M™ Extended Liner Tapes offer the adhesive versatility of 3M tapes but with liners wider than the adhesive. This leaves an easy-to-lift edge for convenient and easy liner removal. With the variety of adhesives, you have a selection of performance characteristics such as high tack for coated papers and plastics, low tack for temporary attachment, high temperature resistance and more. Apply manually or with equipment matched to your production volume requirements.


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3M™ Extended Liner Tapes are available with a release liner wider than the adhesive. This provides an easy-to-grab edge for convenient liner removal.

Depending on adhesive type, 3M™ Extended Liner Tapes are applied to envelopes, polybags, boxes or tubes. User simply peels off liner to expose the adhesive for an immediate, secure closure.


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3M™ Extended Liner Tapes 450XL, 450EK and 465XL immediately bond product information "outserts" to polyethylene bottles. Holds tightly but can be cleanly removed.

Product	Tape Thickness w/o liner mils (mm)	Liner Type	Description	Temperature Resistance		Solvent Resistance	Relative Adhesion		Application Ideas
				Min Hr	Days Weeks		HSE	LSE	
340									
466XL	2 (0.05)	62# DK White with Black Print	High tack; Permanent	180°F (82°C)	150°F (65°C)	Med	High	High	Coated papers and low surface energy (LSE) plastics. Overnight envelopes. Features an end-of-roll indicator tab for automated dispensing.
400									
465XL	2 (0.05)	60# DK Tan with Green Print	General purpose	250°F (121°C)	180°F (82°C)	Med	Med	Low	Seal flaps on overnight envelopes. Pressure sensitive edging on business forms. General commercial joining applications. For attaching materials that require more adhesive thickness. Larger outsert attachments.
450EK	1 (0.025)	78# Extensible Kraft White without Print	General purpose	250°F (121°C)	180°F (82°C)	Med	Med	Low	Pharmaceutical outsert attachment. For applications requiring a more tear resistant liner.
450XL	1 (0.025)	60# DK Tan with Green Print	General purpose	250°F (121°C)	180°F (82°C)	Med	Med	Low	Pharmaceutical outsert attachment. General paper attachment.
920XL	1 (0.025)	40# DK White with Red Print	General purpose	250°F (121°C)	180°F (82°C)	Med	Med	Low	Seal flaps on polybags and envelopes. Pressure sensitive edging on business forms, literature, photos, posters and labels.
9926XL	1 (0.025)	40# DK White with Red Print	General purpose	180°F (82°C)	150°F (65°C)	Med	Med	Low	Economical alternative for general paper-to-paper applications.
600									
9934XL	4 (0.10)	60# DK tan without Print	High tack to LSE materials	150°F (65°C)	120°F 49°C)	Med	High	High	P.O.P. displays. Difficult splicing applications, shelf talkers, price tags, polyethylene foam bonding. Indirect food-contact applications. High tack to LSE materials.
760									
476XL	6 (0.16)	62# DK White with Red Print	High tack, double coated film	150°F (65°C)	120°F 49°C)	Med	High	High	Heavy-duty sealing. Mounting of promotional items. Core starting. Closure of overnight boxes, tubes and envelopes. Indirect food-contact applications.
770									
9925XL*	2.5 (0.065)	43# DK White with Black Print	Tissue reinforced; High initial adhesion to a wide variety of materials	150°F (65°C)	100°F 41°C)	Low	Med	Med	General mounting. P.O.P. items. Attaching tags and labels. Core starting. Permanent bonding paper-to-paper, business forms, traffic tickets, novelty items and literature. Indirect food-contact applications.

*Non-liner side is adhesive coated full width.

Relative Adhesion:
HSE – High Surface Energy
LSE – Low Surface Energy

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