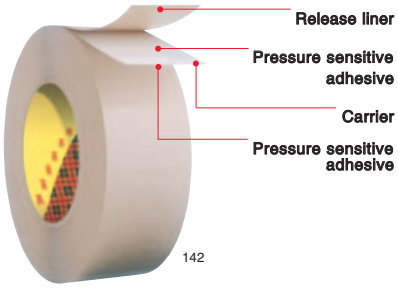
A variety of carriers for easy handling and dispensing

3M™ Double Coated Tapes are engineered with adhesive on both sides of paper, film or tissue. This increases the dimensional stability of the adhesive for easy handling and application.

Depending on your production volume, you can apply tape by hand or with automatic high-volume dispensers. Select paper, polyester film or other synthetic carriers to help meet your special needs. Different adhesives – rubber, silicone or acrylic – can be on opposite sides of the carrier to join different materials. Your choice of properties include high temperature resistance, conformability to irregular surfaces, high initial adhesion, high shear strength, and more.



142

143

3M™ Double Coated Tape 9731, features differential adhesive for silicone rubber keypad assembly. The silicone adhesive side adheres to the silicone rubber keypad. The acrylic adhesive side adheres to a plastic base.


144

3M™ Double Coated Tape 9495B bonds LED windows to cellular phone housings and endures severe environmental conditions.


145

With high tack and good shear strength, 3M™ Double Coated Tape 9420 splices plastic film quickly and securely. Red carrier identifies the splice for later removal.


146

For precise fit, 3M™ Double Coated Tape is pre-applied to foam gasketing materials and then die-cut to size. This helps increase dimensional stability of the part to facilitate assembly.


147

In a self-test strip for diabetes, 3M™ Double Coated Tape bonds the chemical reagent material to the plastic stick.


148

3M™ Double Coated Tape 410B is the quick, convenient way to bond golf club grips to shafts. Adhesive sets up fast and bonds firmly for long-lasting performance.


149

The silicone adhesive side of 3M™ Double Coated Tape 9731 bonds a silicone rubber insulator. The acrylic adhesive side adheres to the metal band. The band mounts to a wall bracket in industrial equipment.

Product Information: 3M™ Double Coated Tapes

Adhesive Family	Product Number	Tape Thickness w/o liner Mils (mm)	Carrier Type*	Liner Type	Description	Temperature Resistance		Solvent Resistance	Relative Adhesion		Application Ideas
						Minutes Hours	Days Weeks		HSE	LSE	
200MP High Perf	9492B	2.5 (0.06)	Black PET	58# PCK	• Black 2.5 mil version of 9495MP	300°F (149°C)	250°F (121°C)	High	High	Low	Graphic attachment.
	9492MP	2.5 (0.06)	PET	58# PCK	• 2.5 mil version of 9495MP						Automotive decorative trim attachment.
	9492MPF	2.5 (0.06)	PET	PET	• High perf thin double coat						Graphic attachment.
	9495MP	5.7 (0.14)	PET	58# PCK	• Excellent peel strength on high surface energy plastics and metals						Graphic attachment. High-pressure laminate bonding.
	9495B	5.7 (0.14)	Black PET	58# PCK	• 9495MP with a 0.5 mil black polyester carrier						LED lens attachment for cellular phones and pagers.
	9495BF	5.7 (0.14)	Black PET	58# PET	• 9495B with a 2 mil polyester liner						Automotive decorative trim attachment.
	9495FL	5.7 (0.14)	PET	58# PCK/ HDPE	• 9495MP with two liners						Automotive decorative trim attachment.
	9495MPF	5.7 (0.14)	PET	PET	• Film linered version of 9495MP						LED lens attachment for cell phones.
	9598BF	7.5 (0.19)	Black PET	PET	• 7.5 mil version of 9495B with a 2 mil clear polyester liner						LED lens attachment for cell phones.
300 High Strength	444	3.8 (0.10)	PET	55# DK	• High tack acrylic adhesive with densified kraft liner	180˚F (82˚C)	150˚F (65˚C)	Low	High	High	Gasket attachment. Good adhesion to most plastics.
	444PC	3.8 (0.10)	PET	58# PCK	• High tack acrylic adhesive with polycoated kraft liner						Gasket attachment.
	9009	1.9 (0.05)	PET	55# DK	• Thin double coat for applications where thickness is critical	250°F (121°C)	180°F (82°C)	Low	Med.	Med.	Gasket attachment in hand-held devices and laptops.
	9019	1.1 (0.03)	PET	55# DK	• Ultra-thin double coat for applications where thickness is critical						Plastic film lamination/bonding.
	9019HL	1.1 (0.03)	PET	55# DK	• Same as 9019 except with a heavier liner						Plastic film lamination/bonding.
300LSE High Strength	9490LE	6.7 (0.17)	PET	58# PCK	• 300MP adhesive on face side, 300LSE adhesive on the other	300˚F (149˚C)	200˚F (93˚C)	Medium	High	High	Gasket attachment to low surface energy surfaces.
	9495LE	6.7 (0.17)	PET	58# PCK	• 300LSE adhesive on both sides for low surface energy surfaces						Plastic extrusion attachment.
300MP High Strength	9609	9.0 (0.23)	PET	83# PCK	• Thick double coat. Provided on 6" core only	300°F (149°C)	150°F (65°C)	Medium	High	Med.	Foam lamination.
	9687	12.0 (0.30)	Clear PET	Clear PET	• Thick double coat for bonding to foam						Gasket attachment.
	9690	5.6 (0.14)	PET	83# PCK	• Excellent adhesion to most plastics and foams						Foam lamination. Gasket attachment.
	9690B	5.6 (0.14)	Black PET	83# PCK	• 9690 with a 0.5 mil black polyester carrier						LED lens attachment for cellular phones and pagers.
	9786	5.5 (0.14)	Non-woven	58# PCK printed	• Thin non woven carrier for dimensional stability and improved handling						LED lens attachment for cell phones.
	9786NP	5.5 (0.14)	Non-woven	58# PCK unprinted	• Same as 9786 except an unprinted liner						LED lens attachment for cell phones.
	9832	4.8 (0.10)	PET	58# PCK	• Excellent adhesion to most foams						LED lens attachment for cell phones.
	9832HL	4.8 (0.10)	PET	83# PCK	• Same as 9832 except with a heavier liner						LED lens attachment for cell phones.
330	469	5.5 (0.14)	Tissue	72# DK	• High temp, high tack, light red	350˚F (177˚C)	200˚F (93˚C)	Medium	High	Med.	High speed flying splices.
340 High Strength	9456	5.0 (0.11)	Tissue	55# DK	• Tissue carrier with high tack adhesive	180˚F (82˚C)	150˚F (65˚C)	Medium	High	Med.	Bond fabric to window blind valances.

Note: The technical information and data provided here should be considered representative or typical only and should not be used for specification purposes. User should evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for user's method of application.

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

*PET is polyester, PP is polypropylene.

Product Information: 3M™ Double Coated Tapes (continued)

Adhesive Family	Product Number	Tape Thickness w/o liner Mils (mm)	Carrier Type*	Liner Type	Description	Temperature Resistance Minutes Hours	Temperature Resistance Days Weeks	Solvent Resistance	Relative Adhesion HSE	Relative Adhesion LSE	Application Ideas
340 High Strength (cont.)	9824	3.1 (0.08)	PET	55# DK	• High tack, general purpose acrylic adhesive	150˚F (65˚C)	120˚F (49˚C)	Medium	High	Med.	General purpose laminating. Foam lamination. Gasket attachment.
	9828	4.0 (0.10)	PET	55# DK	• High tack, acrylic adhesive with good adhesion to many foams						
	9828HL	4.0 (.10)	PET	132# Kraft	• Same as 9828 with different liner	180°F (82°C)	150°F (65°C)				Foam lamination. Gasket attachment.
	9828PC	4.0 (.10)	PET	74# PCK	• Same as 9828 with PCK liner						
350 High Holding	9500PC	5.6 (0.14)	PET	58# PCK	• High performance on a wide array of surfaces	350˚F (177˚C)	250˚F (121˚C)	High	High	High	LED lens attachment for cellular phones and pagers.
400 Acrylic	415	4.0 (0.1)	PET	55# DK	• High tack adhesion to paper and many other surfaces	180˚F (82˚C)	150˚F (65˚C)	Medium	Med.	Low	Splice papers, films and foils.
	9420	4.0 (0.1)	Red PET	60# DK	• 415 with a 0.5 mil red carrier						
	9576	4.0 (0.1)	PP	60# DK	• Transparent carrier	165˚F (75˚C)	125˚F (52˚C)	Medium	Med.	Low	Splicing, core starting, miscellaneous joint and bonding, hand tearable.
	9576B	4.0 (0.1)	Black PP	60# DK	• Black carrier						
	9576R	4.0 (0.1)	Red PP	60# DK	• Red carrier						
	9576Y	4.0 (0.1)	Yellow PP	60# DK	• Yellow carrier						
	9578	4.0 (0.1)	PP	60# DK	• Transparent carrier						
420 Acrylic	9795	5.6 (0.14)	PET	83# PCK	• Double coated version of 3M Tape 9695 for foam lamination and graphic attachment	300˚F (149˚C)	250˚F (121˚C)	Medium	Med.	Low	LED lens attachment for cell phones.
	9795B	5.6 (0.14)	Black PET	83# PCK	•Thin polyester film carrier for improved handling, die-cutting and laminating			Medium	Med.	Low	LED lens attachment for cell phones.
	9799	9.0 (0.23)	PET	83# PCK	• Thick double coat for cell phone lens attachment			Medium	Med.	Low	LED lens attachment with higher strength for cell phones.
700 Synthetic Rubber 700	919	5.0 (0.13)	Tissue	58# PCK	• Tissue carrier	180˚F (82˚C)	150˚F (65˚C)	Medium	High	High	General purpose laminating adhesives. Bonding plastic surfaces.
745	443PC	5.0 (0.1)	PET	62# PCK	• High tack with good adhesion to most plastics						Photopolymer printing plates.
760	9443NP	6.0 (0.15)	HDPE	62# DK	• High tack with good adhesion to most plastics						Assemble computer ink cartridges. Bonding polyethylene.
760	9579	9.0 (0.23)	HDPE	62# DK	• General purpose, high tack, hand-tearable film tape	150˚F (65˚C)	120˚F (49˚C)	Medium	High	High	Core starting on metal cores.
760	9589	9.0 (0.23)	HDPE	62# DK	• Aggressive adhesive with high initial tack						Carpet attachment.
800 Natural Rubber 860	401B	9.0 (0.23)	Paper	54# DK	• Thick flatstock paper carrier	180˚F (82˚C)	150˚F (65˚C)	Medium	High	Med.	Mount printing plates.
850	410B	5.0 (0.13)	Paper	54# DK	• Smooth adhesive on both sides	200˚F (93˚C)	150˚F (65˚C)	Medium	High	Med.	Core starting/end tabbing of papers, films and foils.
830	442F	4.0 (0.1)	PET	3 mil PET	• Same as 442KW with film liner	180°F (82°C)	150°F (65°C)	Med.	High	Med.	Mount polishing pads.
	442KW	4.0 (0.1)	PET	72# PCK	• Rubber adhesive removes from metals						
	456CR	4.0 (0.1)	PET	3 mil PET	• Easy release blue rubber adhesive						
900 Misc.	9851	3.5 (0.09)	PET	60# DK	• Moderate performance rubber adhesive	150˚F (65˚C)	100˚F (41˚C)	Low	High	High	Foam lamination.
Silicone	9731	5.5 (0.14)	PET	4.0/5.0 PET/PCK	• High performance acrylic adhesive/ silicone adhesive, double linered	350˚F (177˚C)	250˚F (121˚C)	Medium	High	High	Silicone keypad attachment. Printer toner cartridge refurbishing.

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

*PET is polyester, PP is polypropylene.