

3M

Polyester Tape

8402

Technical Data

July, 2007

Product Description 3M™ Polyester Tape 8402 is a film tape with a silicone adhesive for composite bonding and splicing of many silicone coated papers and films.

| Product Construction | Backing | Adhesive | Color | Standard Roll Length |
|----------------------|----------------|----------|-------------------|----------------------|
| | Polyester film | Silicone | Translucent green | 72 yds. (66 m) |

Typical Physical Properties **Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.**

| | | ASTM Test Method |
|----------------------------|--|------------------|
| Adhesion to Steel: | 24 oz./in. width (26 N/100 mm) | D-3330 |
| Tensile Strength at Break: | 25 lbs./in. width (438 N/100 mm) | D-3759 |
| Elongation at Break: | 100% | D-3759 |
| Backing Thickness: | 0.9 mils (0.02 mm) | D-3652 |
| Total Tape Thickness: | 1.9 mils (0.05 mm) | D-3652 |
| Temperature Use Range: | Removes cleanly and remains flexible after 3 hours, 350°F (177°C), in autoclave. | |

Features

- Abrasion, chemical and thermal resistant.
- Retains flexibility from -60° to 350°F (-50° to 177°C).
- Higher heat resistance as compared with acrylics.
- Easy and clean removability.

Application Ideas

- Masking edges of overlap seams in metal bonding process where the excess epoxy (“flash”) flows onto the tape. Clean-up is complete when the tape is removed.
- Protective overall mask on panels subject to mild caustic or acid bath etching and to prevent scratches during handling prior to bonding operations.
- Holding of parts or vacuum bags during bonding operation.
- Mask for metal in acid or caustic chemical milling baths.
- Paint mask for areas subject to high temperature bake cycles.
- Splicing of silicone liners and papers.
- Splicing of films subject to high temperatures.

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Storage Store under normal conditions of 70°F (21°C) and 50% R.H. in the original carton.

Shelf Life To obtain best performance, use this product within one year from date of manufacture.

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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.

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