Polyester Tape
8402 • 8403

Technical Data

Product Description

3M™ Polyester Tape 8402 and 8403 are film tapes with a silicone adhesive for holding down bagging materials and parts during composite and metal bonding operations. Ideal for splicing applications on surfaces that are difficult to adhere too, such as silicone coated papers and films.

Product Construction

<table>
<thead>
<tr>
<th>Backing</th>
<th>Adhesive</th>
<th>Color</th>
<th>Standard Roll</th>
</tr>
</thead>
<tbody>
<tr>
<td>Polyester</td>
<td>Silicone</td>
<td>Translucent green</td>
<td>72 yds. (66 m)</td>
</tr>
</tbody>
</table>

Typical Physical Properties

<table>
<thead>
<tr>
<th>3M tape 8402</th>
<th>3M tape 8403</th>
</tr>
</thead>
<tbody>
<tr>
<td>Adhesion to Steel: 23 oz./in. width (25 N/100 mm)</td>
<td>Adhesion to Steel: 25 oz./in. width (27 N/100 mm)</td>
</tr>
<tr>
<td>Tensile Strength at Break: 25 lbs./in. width (438 N/100 mm)</td>
<td>Tensile Strength at Break: 41 lbs./in. width (718 N/100 mm)</td>
</tr>
<tr>
<td>Elongation at Break: 125%</td>
<td>Elongation at Break: 140%</td>
</tr>
<tr>
<td>Backing Thickness: 0.92 mils (0.02 mm)</td>
<td>Backing Thickness: 1.4 mils (0.04 mm)</td>
</tr>
<tr>
<td>Total Tape Thickness: 1.9 mils (0.05 mm)</td>
<td>Total Tape Thickness: 2.4 mils (0.06 mm)</td>
</tr>
<tr>
<td>Short Term Temperature Use Range: -60°F to 425°F (-50°C to 218°C)</td>
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</tr>
</tbody>
</table>

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

- D-3330
- D-3759
- D-3652

Features

- Works in demanding conditions and retains flexibility in autoclave conditions in temperatures ranging from -60°F (-50°C) to 350°F (176°C)
- Higher heat resistance as compared with acrylics
- Silicone adhesive provides clean removal from a variety of surfaces
- Translucent green backing is easily identifiable for splicing applications
- Chemical resistant adhesive and backing provides durability in difficult environments
### Application Ideas
- Flash breaker in metal bonding processes where the excess epoxy (flash) flows on the tape.
- Holding of bagging materials and parts during metal or composite bonding operations.
- Masking metal surfaces in acid or caustic chemical milling, etching, or anodization baths.
- Protective tape reduces scratches during handling and shipping.
- Paint mask for areas subject to higher temperature bake cycles.
- Splicing applications on surfaces that are difficult to adhere too, such as silicone coated papers and films.
- Splicing of films subject to high temperatures or chemicals.

### Storage
Store under normal conditions of 60° to 80°F (16° to 27°C) and 40 to 60% R.H. in the original packaging.

### Shelf Life
To obtain best performance, use this product within 24 months from date of manufacture.

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ISO 9001

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