**3M Application Profile #10**

**Market:** Web Processing in Paper Mills and Paper Converters  
**Application Description:** Simple Overlap Splice at the Winder

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**Key Application Requirements**

Simple overlap splices are recommended for splices which will not see additional coating operations

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**Advantages/Benefits to Customer**

*High shear strength:* 3M™ Repulpable Double Coated Splicing Tape 900 uses a firm adhesive that leaves no exposed adhesive, which may be caused by web slippage at high web tensions. This helps reduce web breakage caused by adhesive "blocking."

*Versatile:* Ideal for most simple overlap splices as well as core starting and roll closing.

*Easily identifiable:* Light blue adhesive color helps save time and increase productivity.

*Heat resistant:* Withstands high oven temperatures typically associated with web printing, which helps reduce down time due to splice failure.

*Repulpable:* Both 3M tape and liner pass TAPPI method UM-213. No need to separate splice from waste.

*FDA compliant adhesive:* Tape can be used on most food grade papers.

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**Process**

3M™ Repulpable Double Coated Splicing Tape 900 is pressed into place across the trailing edge of paper. The leading edge of paper from the next roll of paper is then pressed on top of the 3M tape, forming an overlap splice.

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**Application Method**

By hand.

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**Alternative Application Description**

If splices will see additional coating or customer printing operations, a 3M single coated tape could be used as a cover tape to tape down the trailing and/or leading edge forming a safety splice.

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**Key Decision Makers**

Production Managers and Supervisors  
Paper Machine Superintendents  
Finishing Superintendents  
Purchasing
Splicing Tape Comparison

<table>
<thead>
<tr>
<th>Related Products</th>
<th>Paper Grade</th>
<th>FDA* Compliant</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ Repulpable Double Coated Splicing Tape 900</td>
<td>Coated and uncoated</td>
<td>yes</td>
</tr>
<tr>
<td>3M™ Repulpable Double Coated Splicing Tape 405</td>
<td>Uncoated</td>
<td>no</td>
</tr>
</tbody>
</table>

Cover Tape Comparison

<table>
<thead>
<tr>
<th>Related Products</th>
<th>Paper Type</th>
<th>Caliper (mils/mm)</th>
<th>Color</th>
<th>FDA* Compliant</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ Printable Repulpable Single Coated Splicing Tape 9103</td>
<td>Coated or uncoated</td>
<td>4.5 (0.11)</td>
<td>Blue</td>
<td>yes</td>
</tr>
<tr>
<td>3M™ Thin Printable Repulpable Single Coated Splicing Tape 9960</td>
<td>Coated or uncoated</td>
<td>2.2 (0.06)</td>
<td>Blue</td>
<td>yes</td>
</tr>
<tr>
<td>3M™ Thin Printable Repulpable Single Coated Splicing Tape 9969</td>
<td>Coated or uncoated</td>
<td>2.2 (0.06)</td>
<td>Blue or white</td>
<td>yes</td>
</tr>
<tr>
<td>3M™ Repulpable Single Coated Splicing Tape 901</td>
<td>Uncoated</td>
<td>4.0 (0.10)</td>
<td>White paper green adhesive</td>
<td>no</td>
</tr>
</tbody>
</table>

* All components of the adhesive and backing meet the requirements of indirect food additive regulations as described under CFR 21 176.170 (Components of paper and paperboards in contact with aqueous and fatty food) and 21 CFR 176.180 (Components of paper and paperboards in contact with dry foods).

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