

January, 2014

## 3M™ Loop Fastener Tape SJ60L

### Product Description

3M™ Hook and Loop Fasteners offer advanced closure alternatives to zippers, screws, snaps, hooks and more. They offer greater design flexibility, faster product assembly, smoother and cleaner exterior surfaces and improved product performance in many applications. 3M hook and loop fasteners consist of hooks and loops which engage to form a quick fastening attachment. Simply pull the strips apart by hand to disengage.

### Product Features

The woven nylon hook has flexible, self-supporting inverted j-hooks protruding up from the backing with approximately 300 hooks per square inch (46 hooks/square cm). The woven nylon loop has thousands of soft, pliable napped loops protruding above the backing, providing for thousands of openings and closings (cycles). Both the hook and loop are preshrunk to insure maximum dimensional stability and flatness. Standard colors available are black, white.

Coated on the backside with an acrylic pressure sensitive providing good temperature resistance.

Commonly paired with 3M™ Hook Fastener SJ60H, this loop fastener can also engage with other 3M™ Hook Fasteners.



# 3M™ Loop Fastener Tape SJ60L

## Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

## Typical Physical Properties

Thickness		Test Condition
2.29 mm	90 mil	Unmated without liner
3.2 mm	125 mil	Mated without liner

Property: Thickness

notes: Using 1/2" pressure foot with 34 gram weight

Property	Values	
Material	Loop Woven Nylon	
Adhesive	Acrylic PSA	
Liner	Polyolefin with embossed 3M logo	
Liner Thickness	0.1 mm	4 mil
Liner Color	Clear	
Weight (Without liner)	0.057 g/cm <sup>2</sup>	0.013 oz/in <sup>2</sup>

## Typical Performance Characteristics

Property	Values		Substrate	Notes
Dynamic Tensile	7.6 N/cm <sup>2</sup>	11 lb/in <sup>2</sup>	Nylon Hook to Nylon Loop	Run at 12 inches per minute
Dynamic Shear	15.2 N/cm <sup>2</sup>	22 lb/in <sup>2</sup>	Nylon Hook to Nylon Loop	Run at 12 inches per minute
Cleavage Strength	13.1 g/cm width	7.5 lb/in width	Nylon Hook to Nylon Loop	
T-Peel Adhesion	3.5 g/cm width	2 lb/in width	Nylon Hook to Nylon Loop	Run at 12 inches per minute
90° Peel Adhesion	3.9 g/cm width	2.2 lb/in width	Nylon Hook to Nylon Loop	Run at 12 inches per minute
Cycle Life	5000		Nylon Hook to Nylon Loop	Number of closures before losing 50% of original strength

**Typical Performance Characteristics (continued)**

**Product Performance:**

Material Dynes mJ/m <sup>2</sup>	Polypropylene	Polyethylene	EVA	Acrylic	PC	ABS	Aluminum	Stainless Steel	Typical Temperature Resistance °F
	29	31	33	38	42	42	840	700-1100	
	Low Surface Energy Plastics			Medium Surface Energy Plastics			High Surface Energy Materials		
SJ30H SJ30L	X	X	X	X	X	X	X	X	100
SJ60H SJ60L				X	X	X	X	X	180

**Additional Information**

notes: This guide should assist you in determining which product will adhere best to your substrate for.

**Handling/Application Information**

**Directions for Use**

**Attachment Techniques**

The following information is intended to assist the designer considering the use of 3M hook and loop fasteners. System product performance depends upon a number of factors, including the fastener (material, adhesive and area), application method, surface characteristics (material, texture and cleanliness), environmental conditions (moisture, ultraviolet and temperature exposure) and the time it is expected to support a given load. Because many of these factors are uniquely within the user's knowledge and control, it is required that the user evaluate 3M products to determine whether they are fit for a particular purpose and are suitable for the user's substrates, method of application and desired end use.

Rounding the corners, slightly recessing the product into the substrate, or providing raised edges around the Reclosable fastener can reduce the possibility of edge lifting and improve the overall appearance of the fastener on the finished product. Mechanically securing the corners of the fastener with rivets, staples, screws, etc. may also reduce the possibility of edge lifting, but may reduce the closure performance.

The two most common techniques for attaching these 3M hook and loop fasteners to various surfaces are summarized below.

**Pressure Sensitive Adhesive Attachment:** The use of pressure sensitive adhesives eliminates or reduces the need for sewing, solvent activation, dielectric or ultrasonic bonding or bulk adhesive bonding. This can result in simplicity, improved safety and lower installation costs. Pressure sensitive adhesive products can be applied manually or automatically using a variety of equipment choices. Contact your 3M Sales Representative to discuss automated equipment options.

**Surface Preparation:** Highly textured surfaces may reduce the ultimate adhesion levels and care should be given to minimize the surface texture or roughness.

Adhesive backed fasteners should be applied to surfaces that are clean, dry and free of oil, grease, dust, mold release agents or surface contaminants that could reduce the adhesion. It is recommended to remove any surface contaminants that may reduce adhesion by using a method suited for the type and quantity of surface contaminants present. Isopropyl alcohol is a good general use solvent for cleaning contaminants from surfaces for example.

In exceptional cases, especially when removing silicone mold release agents or on rough, porous surfaces, it may be necessary to lightly abrade the surface, use an adhesion promoter, or surface sealer to optimize the adhesive bond to the substrate. The selection of abrasion, priming or sealing methods will depend upon the substrates and the environmental conditions the product will be exposed to during use.

**Attachment Procedure:** To obtain optimum bond to any surface, both the fasteners and the target surfaces should have equilibrated for a minimum of one hour at temperatures between 68°F (20°C) to 100°F (38°C) before application. The liner protecting the adhesive is removed and preferably without touching the adhesive, the fastener is applied to the substrate. Exposure of the adhesive to ambient conditions without the protective liner, before applying to the surface, should be minimized as initial adhesive tack may decrease. Flexible materials should be lying on a hard flat surface so as to permit uniform adhesive contact with the surface. Use of a rubber hand roller, press platen or similar device is recommended to ensure full adhesive contact or wet- out with the substrate surface. Approximately 4.5 pounds of force per square inch, (310 grams per square centimeter) is recommended to increase adhesive contact, improving bond strength. For all adhesive applications, it is important to ensure that the edges are rolled down to reduce the chance of edge lifting.

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## Storage and Shelf Life

Shelf Life when stored in original packaging at 72°F (22°C) and 50% RH is 24 months.

## Family Group

	SJ30H	SJ30L	SJ60H	SJ60L
Thickness (mm) Test Condition: Unmated without liner	2.03	2.54	2.03	2.29
Thickness (mm) Test Condition: Mated without liner	3.3	3.3	3.2	3.2
Material	Hook Woven Nylon	Loop Woven Nylon	Hook Woven Nylon	Loop Woven Nylon
Adhesive	Rubber Based PSA	Rubber Based PSA	Acrylic PSA	Acrylic PSA
Liner	Polyolefin	Polyolefin	Polyolefin with embossed 3M logo	Polyolefin with embossed 3M logo
Liner Thickness (mm)	0.08	0.08	0.1	0.1
Liner Color	White	White	Clear	Clear

## References

1. 3m.com Product Page  
Url: [https://www.3m.com/3M/en\\_US/company-us/all-3m-products/~-/3M-High-Temperature-Loop-Fastener-Tape-SJ60L?N=5002385+3293241146&rt=rud](https://www.3m.com/3M/en_US/company-us/all-3m-products/~-/3M-High-Temperature-Loop-Fastener-Tape-SJ60L?N=5002385+3293241146&rt=rud)
2. Safety Data Sheet  
Url: [https://www.3m.com/3M/en\\_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en\\_US&co=ptn&q=SJ60L](https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=SJ60L)

## ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001: 2000 and ISO/TS 16949:2002 standards.

## Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

## Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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