

3M Science.
Applied to Life.™

EMEA Product guide

3M™ Thin Bonding

Index

Carriers	6
Liners	8
Product constructions	10
Surfaces and application instructions	12
Adhesive product families	16
Adhesive family performance comparison	24
Applications	26
Selection guides	27
Index based on product numbers and descriptions	68



From page 33

3M™ Acrylic Adhesive 100MP

- ▶ Exceptional shear strength even at elevated temperatures and higher peel strength than many other adhesive families
- ▶ Very high temperature resistance
- ▶ High solvent resistance
- ▶ Short-term temperature resistance of up to 260°C. Long-term up to 150°C



From page 33

3M™ Thin VHB™ Adhesive Tapes

- ▶ High initial adhesion and long-lasting bonds
- ▶ Made from 100% closed-cell acrylic adhesive
- ▶ High temperature, weather, UV and solvent resistance
- ▶ Excellent sealing function, vibration and shock absorption



From page 37

3M™ Acrylic Adhesive 200MP

- ▶ Outstanding adhesion to metal and high surface energy materials
- ▶ Anti-lifting properties and staying power on curved surfaces
- ▶ Solvent and weather resistance
- ▶ Short-term temperature resistance of up to 200°C. Long-term up to 150°C



From page 45

3M™ Acrylic Adhesive 300

- ▶ High adhesion to most material surfaces including low surface energy materials
- ▶ Very high initial adhesion and good shear strength
- ▶ Short-term temperature resistance of up to 120°C. Long-term up to 80°C



From page 45

3M™ Acrylic Adhesive 300LSE

- ▶ High initial adhesion and shear strength even for low surface energy materials
- ▶ Outstanding performance on lightly oiled and powder coated surfaces
- ▶ Good chemical and moisture resistance
- ▶ Short-term temperature resistance of up to 150°C. Long-term up to 95°C



From page 45

3M™ Acrylic Adhesive 300MP

- ▶ High initial adhesion and shear strength on textured or rough surfaces, such as foam and textiles
- ▶ Particularly soft and free-flowing pressure sensitive adhesive
- ▶ Short-term temperature resistance of up to 120°C. Long-term up to 70°C



From page 53

3M™ Acrylic Adhesive 350

- ▶ Suitable for a wide range of high and low surface energy substrates
- ▶ Excellent shear strength and very good solvent resistance
- ▶ High temperature and UV resistance
- ▶ Short-term temperature resistance of up to 230°C. Long-term up to 150°C



From page 53

3M™ Acrylic Adhesive 360

- ▶ Suitable for a wide range of high and low surface energy substrates
- ▶ Very strong initial adhesion
- ▶ Minimal oozing (bleed) and low odour
- ▶ Short-term temperature resistance of up to 175°C. Long-term up to 90°C



From page 57

3M™ Scotch® ATG System

- ▶ The 3M™ Scotch® ATG 700 Applicator is the proven tool for the quick application of adhesive transfer tapes
- ▶ Wide range of adhesive tapes to suit almost any application
- ▶ Simply press the trigger for the quick, precise, clean and easy application of adhesive tape



From page 62

3M™ Special Products

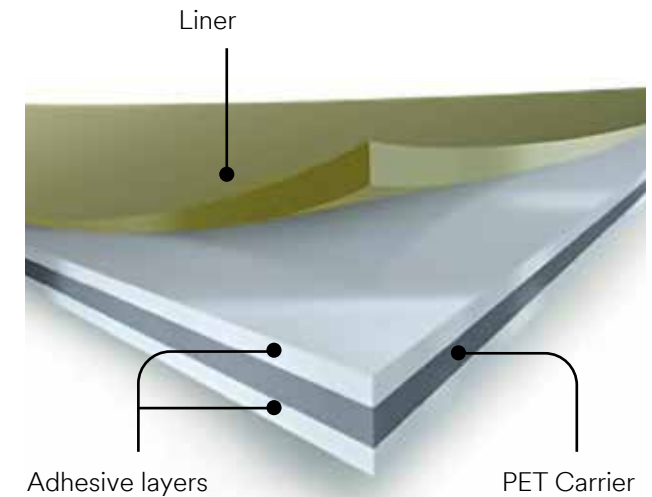
- ▶ Range of products for special applications
- ▶ Removable and repositionable products, products with a sticky note effect, silicone adhesive tapes, universal products and Low VOC adhesive solutions
- ▶ From simple paper application to demanding silicone application

Carriers

Double Coated Tapes with PET Carrier

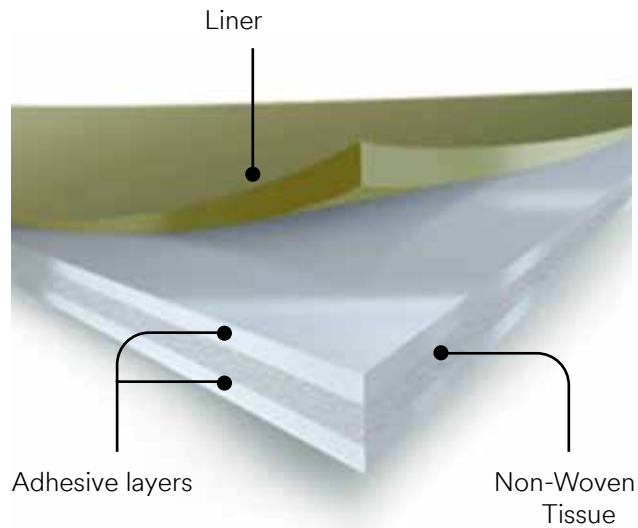
For extremely delicate die-cut shapes, double coated tapes provide the necessary stability during processing thanks to their carrier.

3M™ Double Coated Tapes with PET Carrier



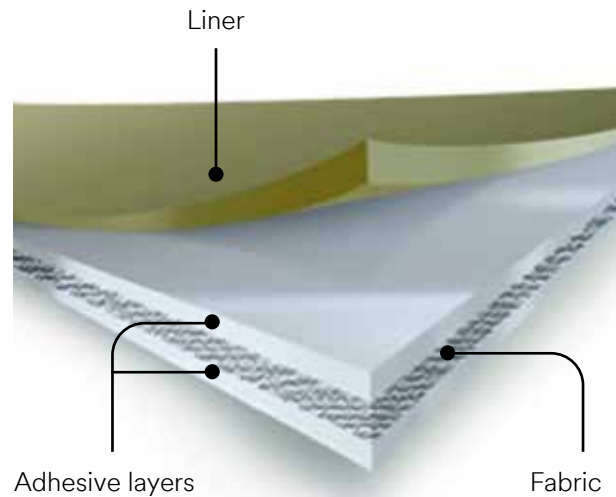
- ▶ Dimensional stability
- ▶ Tear resistant
- ▶ Carrier makes handling and processing easier
- ▶ Also suitable for narrow contours, edges and smaller, delicate die-cut shapes
- ▶ Electrical insulation properties (depending on the carrier thickness)

3M™ Double Coated Tapes with Non-Woven Tissue Carrier



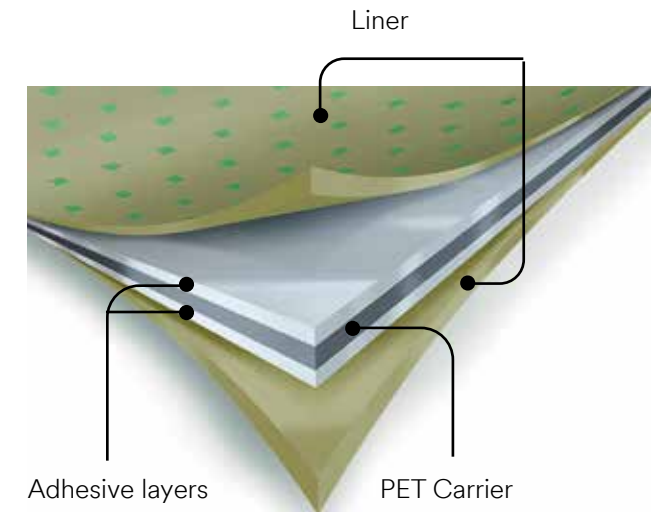
- ▶ Very thin carrier
- ▶ Conformable
- ▶ Hand tearable
- ▶ Carrier makes handling and processing easier
- ▶ Cheaper than PET adhesive tapes

3M™ Double Coated Tapes with Fabric Carrier



- ▶ Material: cotton, rayon
- ▶ Good tensile strength
- ▶ Tearable in the direction of the fibre
- ▶ Conformable

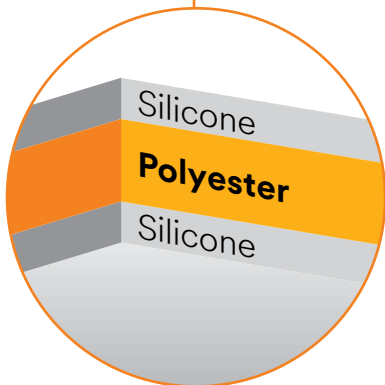
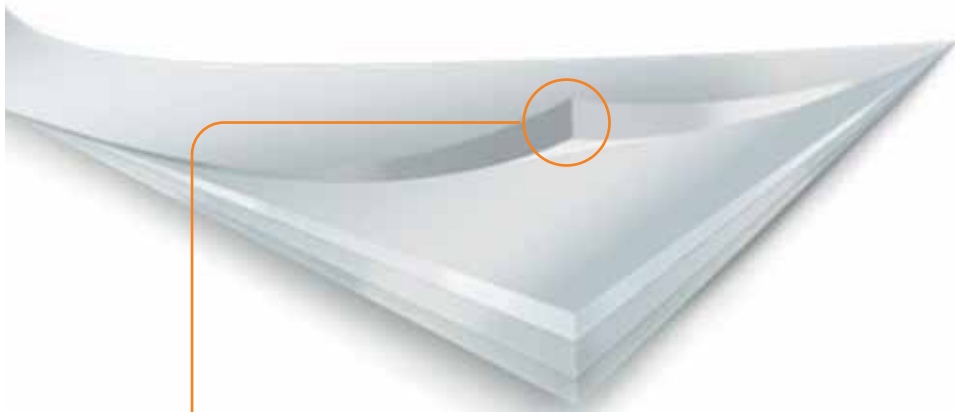
3M™ Spacers



- ▶ Thick PET carrier (0.05 mm – 0.175 mm)
- ▶ Liners on both sides
- ▶ For use in membrane keyboards (spacer function)
- ▶ Liner with excellent moisture stability for optimal lay-flat processing
- ▶ High dimensional stability
- ▶ High rigidity

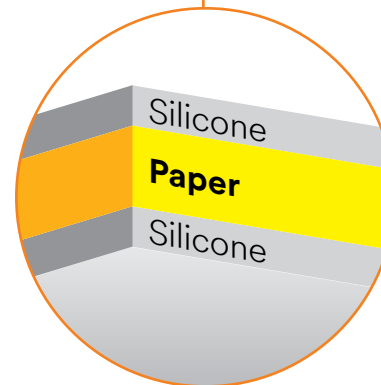
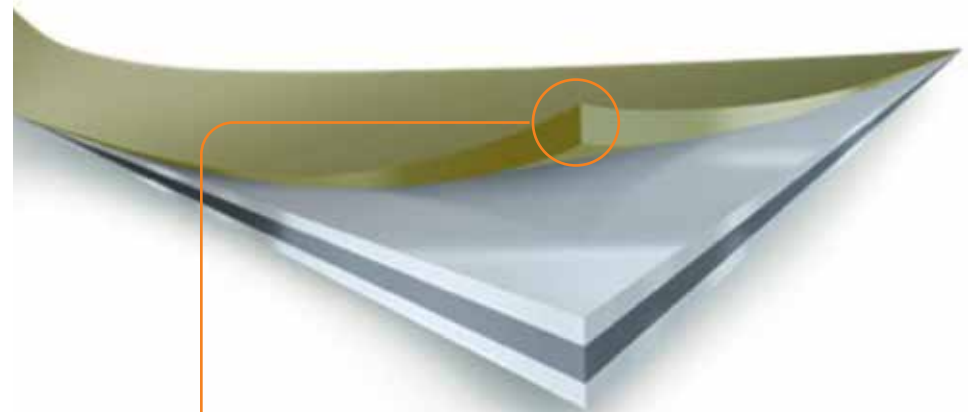
3M™ Liners

Liners – Polyester (PET)



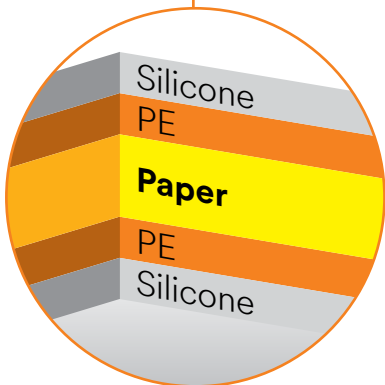
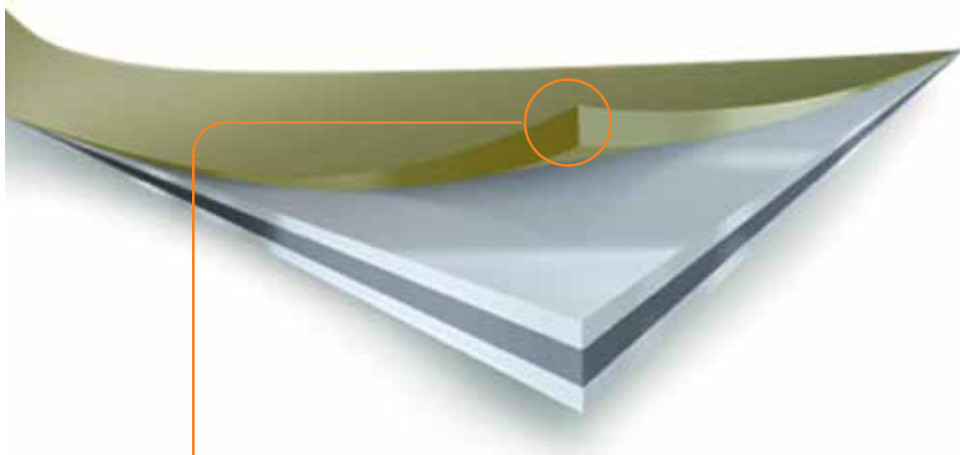
- ▶ Silicone treated on both sides
- ▶ Transparent (allows visual inspection)
- ▶ Well suited for rotary die-cutting
- ▶ Excellent moisture stability
- ▶ Suitable for clean rooms (no paper fibres)

Liners – Densified Kraft/Glassine



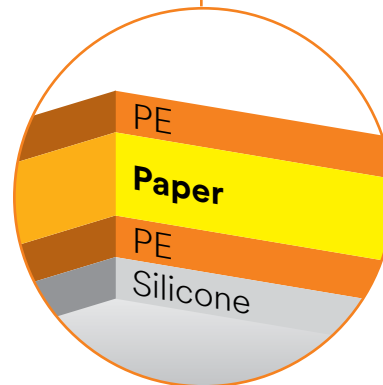
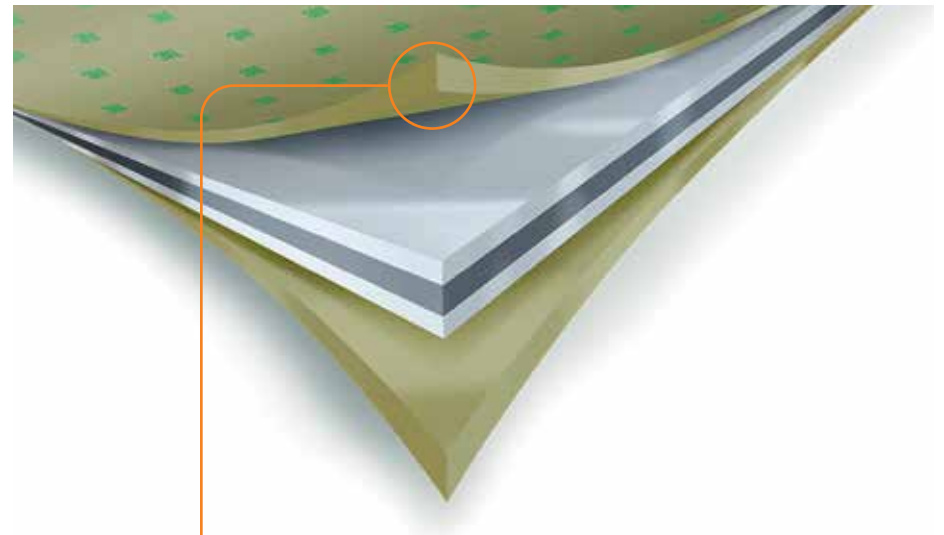
- ▶ Silicone treated on both sides
- ▶ Well suited for rotary die-cutting
- ▶ No moisture stability

Liners – Polycoated Kraft



- ▶ Silicone treated on both sides
- ▶ Processing with flat-bed die-cutting or steel rule die-cutting
- ▶ Excellent moisture stability (PE coating prevents curling of the liner due to penetration of moisture)

Liners – Polycoated Kraft



- ▶ Silicone treated on one side
- ▶ Processing with flat-bed die-cutting/flat-bed laser
- ▶ Excellent moisture stability (PE coating prevents curling of the liner due to penetration of moisture)

Product constructions

General information on product constructions

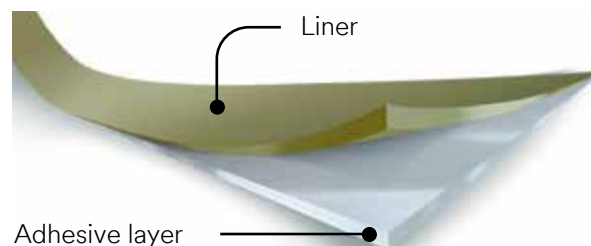
When choosing a suitable adhesive tape, the adhesive is not the only important consideration. For rough and textured surfaces in particular, the thickness of the adhesive layer can be a decisive factor. Transfer tape is therefore generally a better choice than a double coated tape for highly textured surfaces.

Because double coated tape has a carrier between two adhesive layers, the adhesive layers are thinner than those of adhesive transfer tape consisting entirely of adhesive.

The convertibility and stability of double coated products is an advantage, however, as the carrier ensures additional stability within the product. This makes it possible to produce more delicate die-cut shapes.

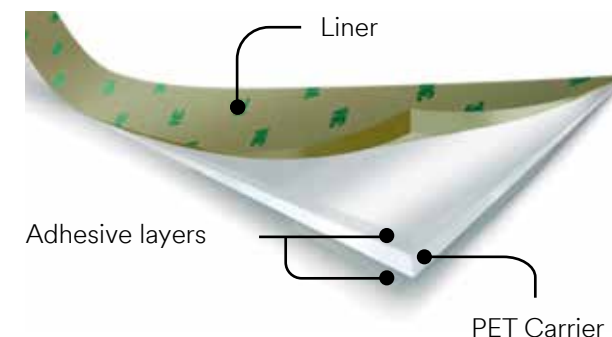
Spacers are a special type of double coated tape. They have a thicker carrier and therefore offer a spacer function.

3M™ Adhesive Transfer Tapes



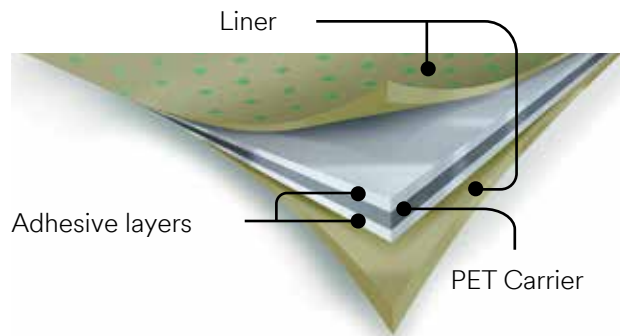
- ▶ **Thickness: 25 – 250 µm**
- ▶ **Without (intermediate) carrier**
- ▶ High flexibility and conformability
- ▶ Compensates for surface roughness very effectively
- ▶ Higher temperature resistance than double coated tapes
- ▶ Automated processing recommended for large areas
- ▶ More difficult to handle and to die-cut (edge picking) than double coated tapes (thread reinforced adhesive transfer tapes available for easier handling)

3M™ Double Coated Tapes



- ▶ **Thickness: 50 – 250 µm**
- ▶ **With (intermediate) carrier**
- ▶ Lower flexibility and conformability than adhesive transfer tape
- ▶ Compensates for surface roughness less effectively than adhesive transfer tape
- ▶ Carrier limits temperature resistance
- ▶ Increased internal stability thanks to carrier
- ▶ Easier to handle and to die-cut
- ▶ Better dispensability
- ▶ Different adhesives on both sides possible
- ▶ Levelwound rolls possible

3M™ Spacers

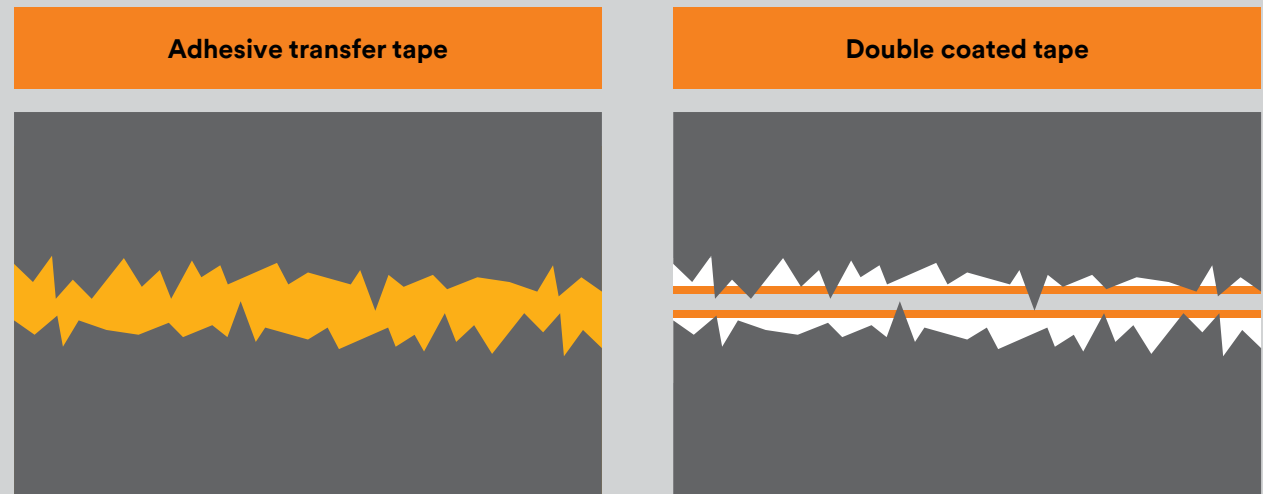


- ▶ **Thickness: 80 µm – 350 µm**
- ▶ **With (intermediate) carrier**
- ▶ Primarily as sheetstock, but also available as rollstock
- ▶ Liners on both sides
- ▶ Different liner thicknesses available
- ▶ For use in membrane keyboards (spacer function)
- ▶ High dimensional stability and rigidity
- ▶ Good die-cutting and processing properties

Adhesive transfer tape vs double coated tape

Property	Adhesive transfer tape (without carrier)	Double coated tape (with carrier)
Flexibility	+	-
Compensation for surface roughness	+	-
Temperature resistance	+	-
Processability and handling	-	+
Different adhesive sides	-	+
Levelwound rolls	-	+
Electrical insulation	-	○

Compensation for surface roughness



Surfaces and application instructions

The materials to be bonded must be inherently strong, as the strength of a bond is only as good as the internal strength of the materials to be bonded.

To determine how good a surface is for bonding, the surface energy can be measured by means of contact angle measurement or suitable test inks.

Once the surface energy has been determined, the selection can be narrowed down to the most suitable adhesive family. Within the product families there are also different constructions and product numbers.

Water Drop Test



The liquid spreads on the material.

Adhesives for high surface energy substrates

Pure acrylic

3M™ Adhesive Series:

100MP, VHB 59 series, 200MP, 220, 400

Surfaces:

Anodised aluminium, aluminium, stainless steel, ABS, polyester, polycarbonate, PVC, glass

Fig. 1: Water drop test



Round drops form on the material.

Adhesives for low surface energy substrates & substrates that are difficult to bond

Modified acrylic

3M™ Adhesive Series:

300, 300LSE, 300MP, 350, 360, 375, 420, silicone

Surfaces:

PE, PP, EPDM, PTFE*, EVA, silicone, broad range of powder coatings

* Check in each individual case (silicone adhesive tape)

Adhesive Comparison

	Pure acrylic	Modified acrylic
High initial adhesion	Poor	Good
High temperature performance	Good	Poor
Solvent resistance	Good	Poor
Shear strength	Good	Poor
Adhesion to low surface energy substrates	Poor	Good
UV light resistance	Good	Poor

Fig. 2: Adhesive comparison

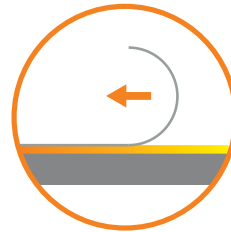
Application instructions

3M™ Adhesive Tapes are used in many sectors of industry on account of their excellent performance. They offer the unique advantage of economical, fast and clean processing compared with other mounting systems – both manual and automated. To ensure that the performance potential of our adhesive tapes is fully utilised, please follow the processing instructions listed below.



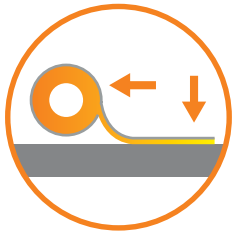
1. Clean/dry:

- ▶ Clean the surfaces using suitable cleaning agents i.e 3M™ VHB™ cleaner
- ▶ For glass surfaces, use 3M™ Silane Glass Primer



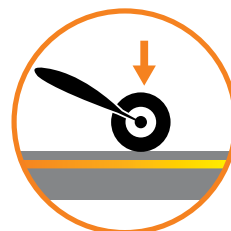
4. Remove the liner:

- ▶ Remove the liner in one piece (avoid “stop marks”)
- ▶ Do not touch the adhesive surface



2. Apply:

- ▶ Apply the tape on the surface to be bonded. Pull the tape tight, but do not overstretch
- ▶ Avoid air bubbles
- ▶ Do not touch the adhesive and adhesive surface
- ▶ Optimal application temperature: 15 to 25°C



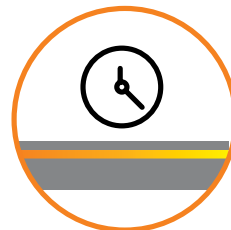
5. Mate, apply pressure:

- ▶ Apply the mating part
- ▶ Avoid air bubbles
- ▶ Apply pressure (approx. 2 kg/cm²)



3. Apply pressure:

- ▶ Press the adhesive tape down firmly or roll over it with a pressure of approx. 2 kg/cm²



6. Wait for final adhesion:

- ▶ Wait for the required amount of time
- ▶ Final adhesion is achieved after 72 hours at 20°C
- ▶ The process can be accelerated by heat (e.g. final adhesion after one hour at 65°C)

For detailed information on the application of adhesive tapes, please refer to the application instructions for 3M™ Industrial Tapes.



Information on adhesives

Why choose adhesive tape?

3M™ Thin Double Coated Tapes offer significant advantages compared with other bonding methods (e.g. liquid adhesives, mechanical connections, etc.)

Design

- ▶ Bond without destroying/damaging the surface of the material
- ▶ Thin – for almost invisible bonds
- ▶ Even join thickness
- ▶ Reduced weight compared with mechanical joining methods (e.g. rivets and screws)
- ▶ Possibility of combining two different pressure sensitive adhesives in a single product (e.g. silicone/acrylic adhesive)

Cost, productivity and process

- ▶ Easy to tear and die-cut into special shapes
- ▶ Prefabrication of adhesive surface possible
- ▶ Application can be automated
- ▶ Minimal cleaning/rework
- ▶ No curing time
- ▶ No pot life limit
- ▶ No drying out or hardening when in storage

Adhesive product families

Adhesive tapes for high surface energy substrates

3M™ Acrylic Adhesive 100MP – for high temperature applications

- ▶ Higher peel strength than other acrylic adhesives
- ▶ Exceptional shear strength even at elevated temperatures
- ▶ Very high adhesion to high surface energy substrates
- ▶ High solvent resistance
- ▶ Very high short-term temperature resistance of up to 260°C. Long-term up to 150°C



Exceptional performance
in challenging applications



Plastic adheres to metal

Thin 3M™ VHB™ 59 Series – for extremely strong bonding

- ▶ Long-lasting bonds on high surface energy substrates
- ▶ High initial adhesion, high temperature, weather, UV and solvent resistance
- ▶ Made from 100% closed-cell acrylic adhesive
- ▶ Excellent sealing function, vibration and shock absorption
- ▶ Thin VHB™ Adhesive Tapes in the 150 µm – 300 µm range



Perfect form and
functionality

Chrome adheres to metal

3M™ Acrylic Adhesive 200MP – for high surface energy substrates

- ▶ Outstanding adhesion to metal and high surface energy materials
- ▶ Anti-lifting properties and staying power on curved surfaces
- ▶ Solvent and weather resistance, good die-cutting properties even after a long period of storage
- ▶ Adhesive does not flow in warm environments, short term repositionability
- ▶ Short-term temperature resistance of up to 200°C. Long-term up to 150°C

Adhesive tapes for high surface energy substrates

3M™ Acrylic Adhesive 400 – for graphic applications

- ▶ Good adhesion to high surface energy substrates
- ▶ Good shear strength and chemical resistance
- ▶ Suitable for a wide range of industrial applications
- ▶ High transparency and good UV resistance



Plastic adheres to plastic

3M™ Acrylic Adhesive 375 – universal double coated tapes

- ▶ Very good adhesion to low and high surface energy substrates
- ▶ Good plasticiser resistance
- ▶ Very good UV and weather resistance





3M™ Acrylic Adhesive 400 – for applications in the paper industry

- ▶ For the high speed splicing of films and paper webs
- ▶ Good shear strength
- ▶ High initial adhesion, very good UV resistance
- ▶ Mounting and assembly of promotional materials



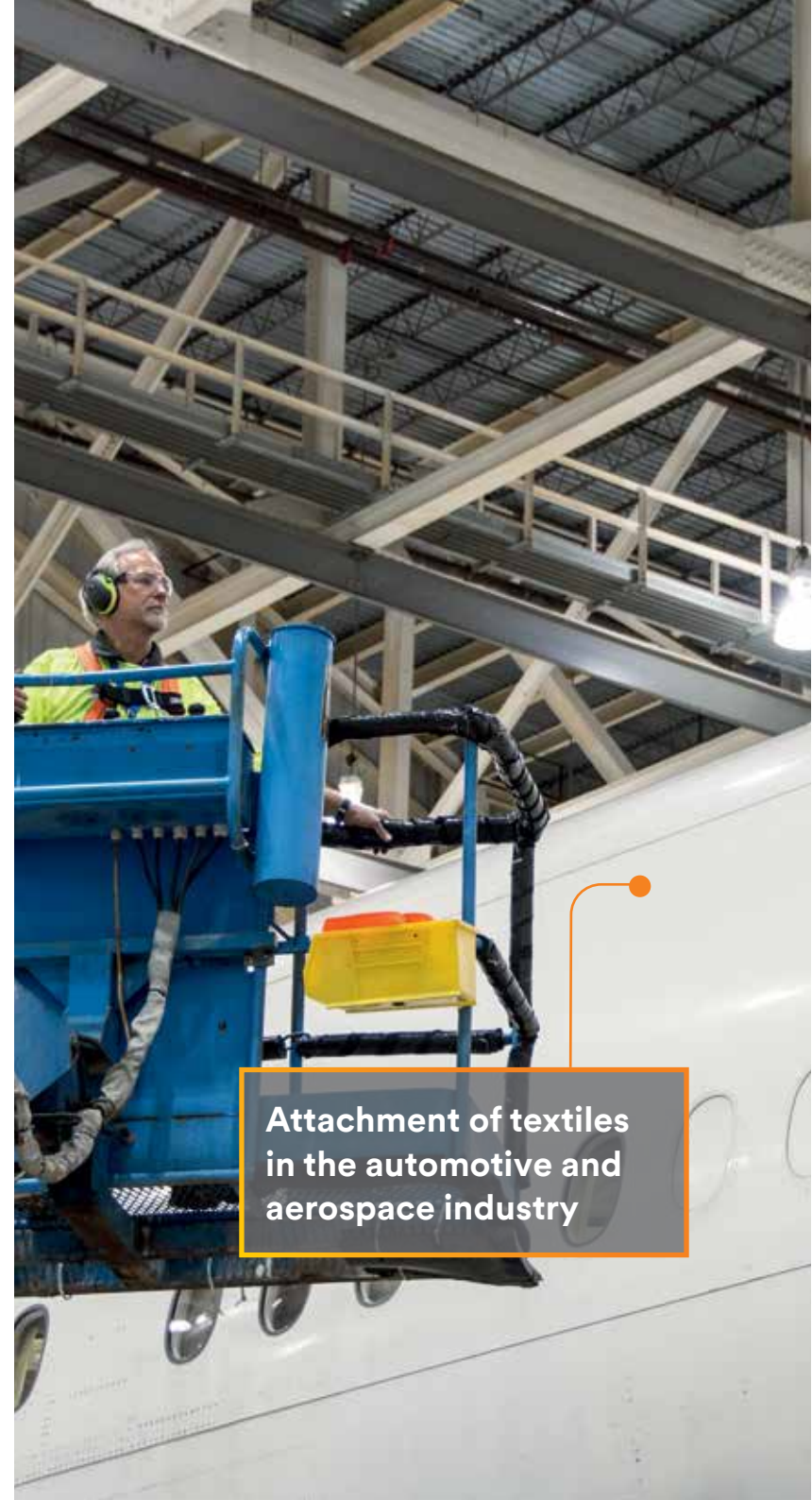
3M™ Acrylic Adhesive 420 – for applications exposed to shock loads

- ▶ High and low surface energy substrates
- ▶ Good chemical resistance
- ▶ Resistant to shock loads
- ▶ High long-term temperature resistance of 120°C. Short-term 150°C

Adhesive tapes for low surface energy substrates

3M™ Acrylic Adhesive 300 – thread reinforced adhesive tapes

- ▶ High adhesion to most material surfaces including low surface energy materials
- ▶ Ideal for foam and textiles
- ▶ Very high initial adhesion and good shear strength
- ▶ Thread reinforcement makes handling and processing easier
- ▶ Short-term temperature resistance of up to 120°C.
Long-term up to 80°C



Attachment of textiles
in the automotive and
aerospace industry



3M™ Acrylic Adhesive 300LSE – ideal for hard to bond low surface energy substrates

- ▶ High initial adhesion and shear strength even for low surface energy materials
- ▶ Outstanding performance on lightly oiled and powder coated surfaces
- ▶ Good chemical and moisture resistance
- ▶ Short-term temperature resistance of up to 150°C. Long-term up to 95°C



3M™ Acrylic Adhesive 300MP – specially designed for foam and other textured materials

- ▶ High shear strength on textured or rough surfaces as well as many other materials
- ▶ Versatile and high-performance thanks to soft and free-flowing adhesive
- ▶ Outstanding initial adhesion to foam, fabric, felt, nylon, carpet, leather, fibreglass and wood
- ▶ Dimensional stability and better handling
- ▶ Short-term temperature resistance of up to 120°C. Long-term up to 70°C

Adhesive tapes for low surface energy substrates

3M™ Acrylic Adhesive 350 – for high temperatures and low surface energy substrates

- ▶ Ideally suitable for a wide range of high and low surface energy substrates
- ▶ Exceptional shear strength
- ▶ High temperature, solvent and UV resistance
- ▶ Thread reinforced adhesive makes handling and processing easier
- ▶ Short-term temperature resistance of up to 230°C. Long-term up to 150°C



3M™ Acrylic Adhesive 360 – for quick bonding

- ▶ Suitable for a wide range of high and low surface energy substrates
- ▶ Very strong initial adhesion
- ▶ High adhesion with a thin adhesive layer
- ▶ Low odour
- ▶ Minimal oozing (bleed)
- ▶ Short-term temperature resistance of up to 175°C. Long-term up to 90°C




Special Products

3M™ Low VOC – optimised for vehicle interiors

- ▶ Suitable for a wide range of high and low surface energy substrates
- ▶ High adhesion to PU ester foams and EPDM
- ▶ Low-emission (tested to VDA278 and JAMA)
- ▶ Carrier makes handling and large-scale processing easier



Chrome adheres to plastic



Silicone rubber adheres to glass

3M™ Silicone – the solution for impossible tasks

- ▶ Good adhesion to silicone rubber, silicone foam and extremely low surface energy substrates
- ▶ High solvent resistance
- ▶ Very high short-term temperature resistance of up to 260°C

Adhesive family – performance comparison

When selecting the right adhesive tape for the job, there is an almost infinite number of factors and influences to consider. The three main factors to be considered first are the surface energy, surface contour and surface roughness.

Once you have chosen the most suitable adhesive series, you then select your product on the basis of a number of other factors.

Fig. 4: Factors affecting the performance of a pressure sensitive adhesive

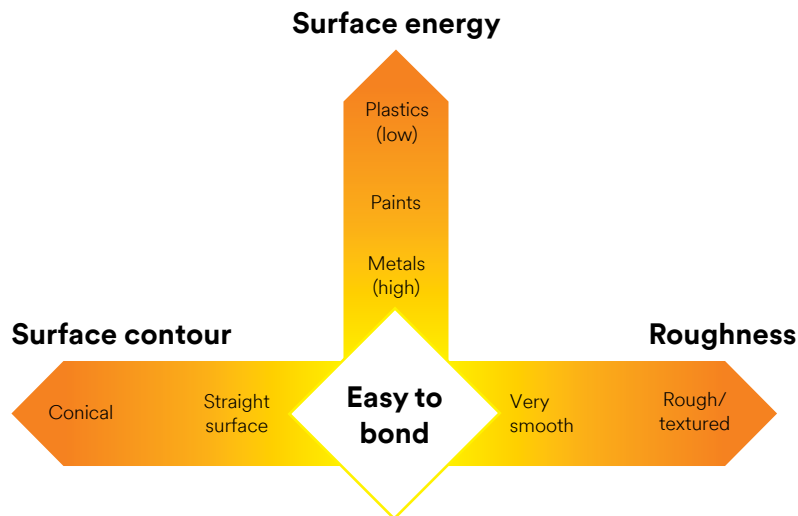


Fig. 5: Adhesion to high surface energy substrates

e.g. aluminium, copper, anodised aluminium, stainless steel, glass

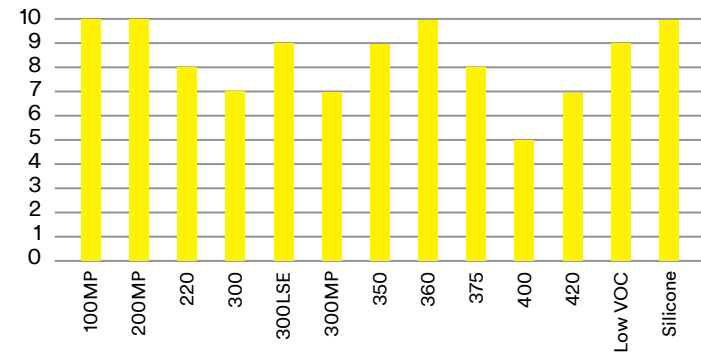


Fig. 6: Adhesion to low surface energy plastics

e.g. PE, PP

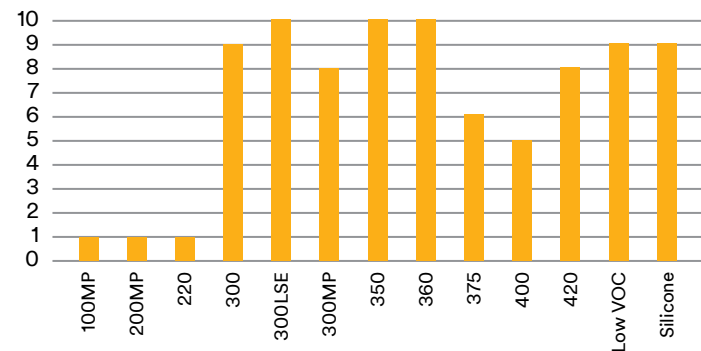
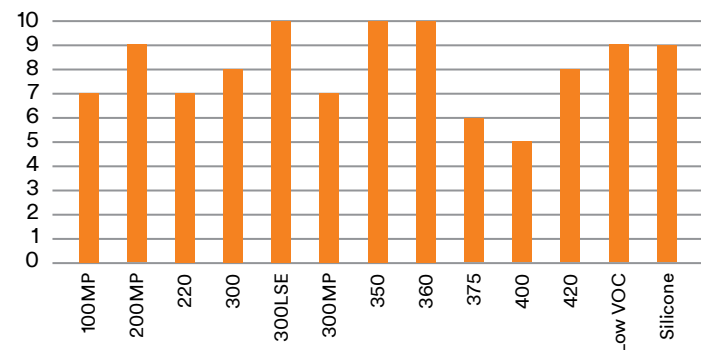


Fig. 7: Adhesion to high surface energy plastics

e.g. ABS, polyester, polycarbonate, PVC



Values represent only the relative performance of the products. 0 = not suitable, 10 = maximum adhesion

Fig. 8: UV/light resistance

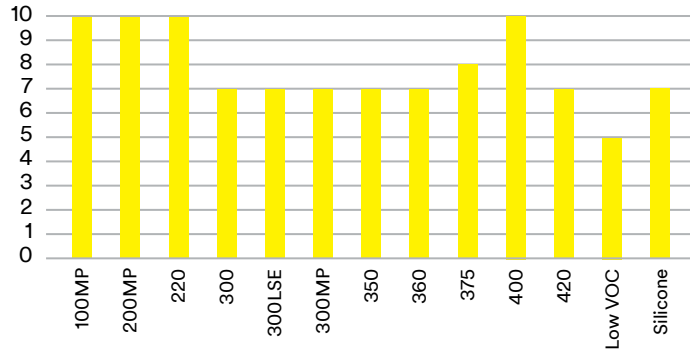


Fig. 9: Solvent resistance

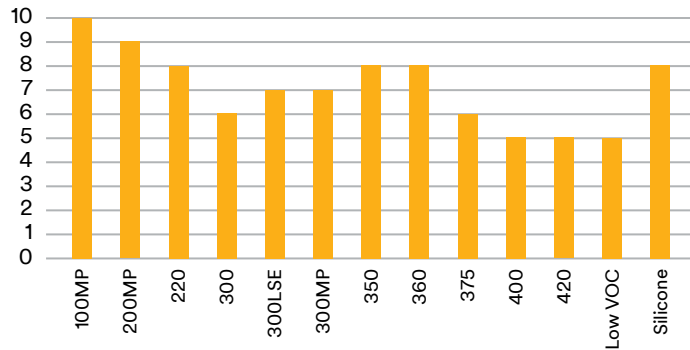
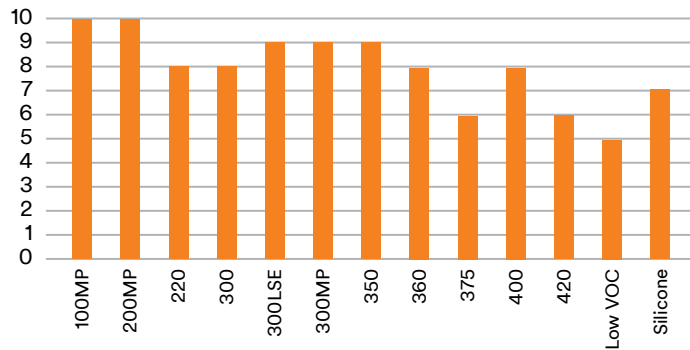


Fig. 10: Moisture resistance

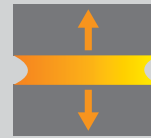


4 types of stress on bonded joints



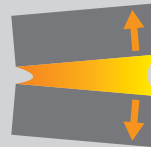
Shear forces

- ▶ The forces act in parallel to the adhesive surface
- ▶ They are more common than tensile forces



Tensile forces

- ▶ The forces act perpendicular to the adhesive surface



Cleavage forces

- ▶ The forces are not distributed evenly over the adhesive surface, but are instead concentrated at one edge
- ▶ Both substrates are rigid



Peel forces

- ▶ The forces act only at the edge of the bonded area, so that only a very small amount of adhesive can counteract them
- ▶ At least one substrate is flexible

Applications

Applications:

- ▶ Bonding
- ▶ Attaching
- ▶ Sealing
- ▶ Splicing
- ▶ Laminating
- ▶ Labelling
- ▶ Repositioning
- ▶ Mounting

Markets:

- ▶ Aerospace industry
- ▶ Automotive industry
- ▶ Electronics
- ▶ Promotions and trade fairs
- ▶ Graphic market
- ▶ Medical technology
- ▶ Domestic appliances



Quick selection guide based on surface

		Rubber*		Foam, textiles		Paper, paperboard		Silicone		PP, PE, powder coatings, PS		ABS, acrylic, PI, PET, PC		Steel, aluminium, glass*, ceramics*	
		Adhesive Transfer Tape	Double Coated Tape	Adhesive Transfer Tape	Double Coated Tape	Adhesive Transfer Tape	Double Coated Tape	Adhesive Transfer Tape	Double Coated Tape	Adhesive Transfer Tape	Double Coated Tape	Adhesive Transfer Tape	Double Coated Tape	Adhesive Transfer Tape	Double Coated Tape
Steel, aluminium, glass*, ceramics*	Thin	467MP 9471LE	92015 93010LE	9773WL 9774WL 9471LE	93010LE	467MP 9773WL 9471LE	92015 93010LE	91022	9731	9773WL 9471LE	93010LE	467MP 9471LE	92015 93010LE	467MP 9471LE F9460PC	92015 93010LE
	Thick	468MP 9472LE	93015LE 93020LE 99786	950 9775WL 9472LE	93015LE 93020LE 99786	468MP 9775WL 9472LE	93015LE 93020LE 99786	-	96042	9774WL 9775WL 9472LE	93015LE 93020LE 99786	468MP 9472LE	93015LE 93020LE 99786	468MP 9472LE F9469PC/F9473PC	93015LE 93020LE 99786
ABS, acrylic, PI, PET, PC	Thin	467MP 9471LE	92015 93010LE	9773WL 9774WL 9471LE	93010LE	467MP 9773WL 9471LE	92015 93010LE	91022	9731	9773WL 9471LE	93010LE	467MP 9471LE	92015 93010LE		
	Thick	468MP 9472LE	93015LE 93020LE	950 9775WL 9472LE	93015LE 93020LE 99786	468MP 9775WL 9472LE	93015LE 93020LE 99786	-	96042	9774WL 9775WL 9472LE	93015LE 93020LE 99786	468MP 9472LE	93015LE 93020LE 99786		
PP, PE, powder coatings, PS	Thin	467MP 9471LE	92015 93010LE 9731	9773WL 9774WL 9471LE	93010LE	467MP 9773WL 9471LE	92015 93010LE	91022	9731	9773WL 9471LE	93010LE	9773WL 9471LE	93010LE		
	Thick	468MP 9472LE	93015LE 93020LE 99786	950 9775WL 9472LE	93015LE 93020LE 99786	468MP 9775WL 9472LE	93015LE 93020LE 99786	-	96042	9774WL 9775WL 9472LE	93015LE 93020LE 99786	9774WL 9472LE	93015LE 93020LE 99786		
Silicone	Thin	91022	9731	91022	-	91022	9731	91022	-	91022	9731				
	Thick	-	96042	-	96042	-	96042	-	96042	-	96042				
Paper, paperboard	Thin	467MP 9471LE	92015 93010LE	9773WL 9774WL 9471LE	93010LE	904 465	415								
	Thick	468MP 9472LE	99786 93015LE 93020LE	950 9775WL 9472LE	93015LE 93020LE 99786	969 950	444 9088-200								
Foam, textiles	Thin	467MP 9471LE	92015	9773WL 9774WL 9471LE	93010LE										
	Thick	468MP 9472LE	99786	950 9775WL 9472LE	93015LE 93020LE 99786										
Rubber*	Thin	467MP 9471LE	92015 9731 93010LE												
	Thick	468MP 9472LE	99786 93015LE 93020LE												

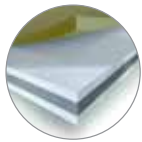
Other product solutions provided in the product overviews or on request.

* Primer recommended. Glass: Silane Glass Primer;

Rubber: Primer 94 or AP-111; Ceramics: Primer 94 or AP-111

Quick selection guide for industrial applications

Standard: metals and high surface energy plastics



200MP

**Double Coated Tape
(liner on one side)**

- ▶ 92015, 150 µm



200MP

**Adhesive Transfer Tape
(liner on one side)**

- ▶ 467MP, 58 µm
- ▶ 468MP, 132 µm

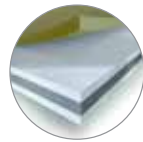


220

**Adhesive Transfer Tape
(liner on one side)**

- ▶ 9502, 60 µm
- ▶ 9505, 120 µm

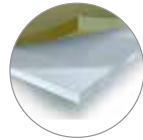
Standard: low surface energy substrates and powder coatings



300LSE

**Double Coated Tape
(liner on one side)**

- ▶ 93010LE, 100 µm
- ▶ 93015LE, 150 µm
- ▶ 93020LE, 200 µm

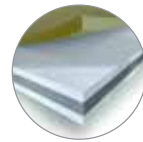


300LSE

**Adhesive Transfer Tape
(liner on one side)**

- ▶ 9471LE, 58 µm
- ▶ 9453LE, 80 µm
- ▶ 9472LE, 132 µm

Universal, economical

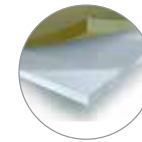


Acrylic and 375

**Double Coated Tape
(liner on one side)**

- ▶ 9088-200, 150 µm
- ▶ 9086, 190 µm
- ▶ 9087, 278 µm
- ▶ 9448A, 150 µm
- ▶ CT-6348, 95 µm

High temperatures, high surface energy substrates



100MP

**Adhesive Transfer Tape
(liner on one side)**

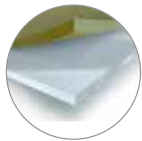
- ▶ (F)9460PC, 58 µm
- ▶ (F)9469PC, 132 µm
- ▶ (F)9473PC, 269 µm

High temperatures,
low surface energy
substrates

Removable

Strong initial adhesion,
bonding of PP and PE

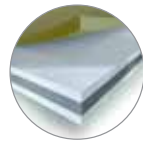
Textiles, leather, foam



350

**Adhesive Transfer Tape
(liner on one side)**

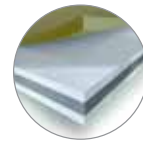
- ▶ 9482PC, 50 µm
- ▶ 9485PC, 130 µm



1000/1050

**Double Coated Tape
(liner on one side)**

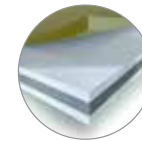
- ▶ 9415PC, 50 µm
- ▶ 9416, 50 µm
- ▶ 9425HT, 137 µm



360

**Double Coated Tape
(liner on one side)**

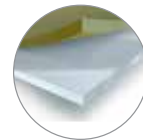
- ▶ 9628FL, 50 µm
- ▶ 9629PC, 100 µm



300/300MP

**Double Coated Tape
(liner on one side)**

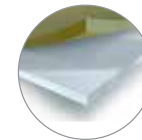
- ▶ 99786, 140 µm



360

**Adhesive Transfer Tape
(liner on one side)**

- ▶ 9626, 58 µm
- ▶ 9627, 132 µm



300/300MP

**Adhesive Transfer Tape
(liner on one side)**

- ▶ 927, 50 µm
- ▶ 950, 130 µm
- ▶ 977XWL, 76-125 µm

Quick selection guide for graphic applications

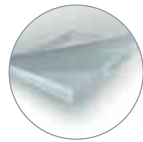
Standard: metals and high surface energy plastics



200MP

**Adhesive Transfer Tape
(liner on one side)**

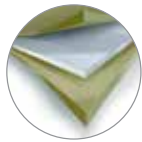
- ▶ 467MP, 58 µm
- ▶ 468MP, 132 µm



200MP

**Spacer (adhesive
on one side)**

- ▶ 7993MP, 83 µm
- ▶ 7995MP, 134 µm
- ▶ 7997MP, 185 µm



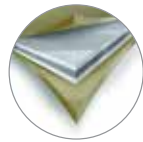
200MP

**Adhesive Transfer Tape
(liner on both sides)**

- ▶ 7952MP, 58 µm
- ▶ 7955MP, 132 µm

Thicker liner

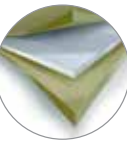
- ▶ 7962MP, 58 µm
- ▶ 7965MP, 132 µm



200MP

**Spacer (liner on
both sides)**

- ▶ 7953MP, 100 µm
- ▶ 7945MP, 141 µm
- ▶ 7956MP, 167 µm
- ▶ 7957MP, 192 µm
- ▶ 7959MP, 243 µm
- ▶ 7961MP, 294 µm



300LSE

**Adhesive Transfer Tape
(liner on both sides)**

- ▶ 8132LE, 58 µm
- ▶ 8153LE, 80 µm



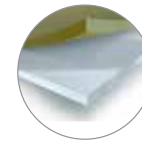
300LSE

**Adhesive Transfer Tape
(liner on one side)**

- ▶ 9471LE, 58 µm
- ▶ 9453LE, 80 µm
- ▶ 9472LE 132 µm

Thicker liner

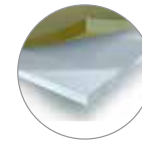
- ▶ 9671LE, 58 µm
- ▶ 9671LE, 132 µm



350

**Adhesive Transfer Tape
(liner on one side)**

- ▶ 9482PC, 50 µm
- ▶ 9485PC, 135 µm



Silicone

**Adhesive Transfer Tape
(liner on one side)**

- ▶ 91022, 50 µm
- ▶ 96042, 130 µm

**Very high temperatures
and chemical resistance**

Removable

**Strong initial adhesion,
bonding of PP and
PE/low odour**

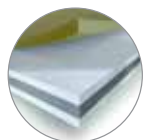
**Thread reinforcement
low energy/high energy**



100MP

**Adhesive Transfer Tape
(liner on one side)**

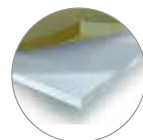
- ▶ (F)9460PC, 58 µm
- ▶ (F)9469PC, 132 µm
- ▶ (F)9473PC, 269 µm



400/1000

**Double Coated Tape
(liner on one side)**

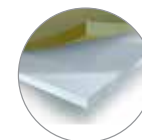
- ▶ 9415PC, 50 µm



360

**Adhesive Transfer Tape
(liner on one side)**

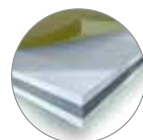
- ▶ 9626, 58 µm
- ▶ 9627, 132 µm



300

**Adhesive Transfer Tape
(liner on one side)**

- ▶ 9471, 58 µm
- ▶ 9472, 132 µm



Low VOC

**Double Coated Tape
(liner on one side)**

- ▶ 98010LVC, 100 µm
- ▶ 99015LVC, 150 µm



3M™ Acrylic Adhesive 100MP

Advantages

- ▶ Very good shear strength
- ▶ Exceptional temperature and chemical resistance
- ▶ Very good aging performance and UV resistance
- ▶ 3M™ VHB™ Series high-performance connection system

Application examples

- ▶ Self-adhesive finishing of various types of signs
- ▶ Bonding of noise-damping shims (brake discs)
- ▶ PCB bonding
- ▶ Suitable for the aerospace and automotive industry

100MP
VHB™

3M™ VHB™ 59xx Series

Advantages

- ▶ High adhesion to powder coatings
- ▶ Very good conformability
- ▶ Very good compensation of gap and expansion differences
- ▶ Very good impact strength

Application examples

- ▶ Touch panels
- ▶ Frame bonding
- ▶ Component mounting
- ▶ Trim bonding

3M™ Acrylic Adhesive 100MP & 3M™ VHB™ 59xx family

3M™ Acrylic Adhesive 100MP				
Product number	9460PC	9469PC	9473PC	F9460PC <small>TOP SELLER</small>
Product description	VHB™ Adhesive Transfer Tape	VHB™ Adhesive Transfer Tape	VHB™ Adhesive Transfer Tape	VHB™ Adhesive Transfer Tape
Adhesive	Acrylic	Acrylic	Acrylic	Acrylic
Colour	Transparent	Transparent	Transparent	Transparent
Total thickness (thickness in mm without liner)	0.058	0.132	0.269	0.058
Carrier material	-	-	-	-
Carrier thickness (mm)	-	-	-	-
Adhesive thickness per side (mm)	-	-	-	-
Liner type	Polycoated kraft	Polycoated kraft	Polycoated kraft	Polycoated kraft
Liner thickness in mm (g/m²)	0.107 (94)	0.107 (94)	0.107 (94)	0.107 (94)
Liner print	-	-	-	Green "3M VHB™"
Temperature resistance (short-term = max. 1 h)	260°C	260°C	260°C	260°C
Temperature resistance (long-term = days, weeks)	150°C	150°C	150°C	150°C
Temperature resistance min.	-40°C	-40°C	-40°C	-40°C
Specifications	UL 746C	UL 746C	UL 746C	UL 746C
Adhesive performance high surface energy substrates (e.g. metal)	10	10	10	10
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	7	7	7	7
Adhesive performance low surface energy substrates (e.g. PE/PP)	1	1	1	1
Conformability	+++	+++	+++	+++
Solvent resistance	+++	+++	+++	+++
Temperature resistance	+++	+++	+++	+++
Weather resistance	+++	+++	+++	+++
UV resistance	+++	+++	+++	+++

3M™ Acrylic Adhesive 100MP		3M™ 59xx series			
F9469PC <small>TOP SELLER</small>	F9473PC <small>TOP SELLER</small>	5906	5907	5908	5909
VHB™ Adhesive Transfer Tape	VHB™ Adhesive Transfer Tape	VHB™ Adhesive Tape	VHB™ Adhesive Tape	VHB™ Adhesive Tape	VHB™ Adhesive Tape
Acrylic	Acrylic	Acrylic	Acrylic	Acrylic	Acrylic
Transparent	Transparent	Black	Black	Black	Black
0.132	0.269	0.150	0.200	0.250	0.300
-	-	-	-	-	-
-	-	-	-	-	-
-	-	0.150	0.200	0.250	0.300
Polycoated kraft	Polycoated kraft	PET film	PET film	PET film	PET film
0.107 (94)	0.107 (94)	0.080	0.080	0.080	0.080
Green “3MVHB™”	Green “3MVHB™”	-	-	-	-
260°C	260°C	120°C	120°C	120°C	120°C
150°C	150°C	90°C	90°C	90°C	90°C
-40°C	-40°C	-40°C	-40°C	-40°C	-40°C
UL 746C	UL 746C	-	-	-	-
10	10	10	10	10	10
7	7	7	7	7	7
1	1	1	1	1	1
+++	+++	+++	+++	+++	+++
+++	+++	+++	+++	+++	+++
+++	+++	++	++	++	++
+++	+++	++	++	++	++
+++	+++	++	++	++	++



3M™ Acrylic Adhesive 200MP

Advantages

- ▶ High shear strength
- ▶ Very good chemical and temperature resistance
- ▶ High transparency and UV light resistance
- ▶ Lay-flat liner for excellent moisture stability

200MP

Application examples

- ▶ Multi-layer membrane keyboards
- ▶ Self-adhesive finishing of logos and signs
- ▶ Bonding of front covers and panels
- ▶ Self-adhesive trims

3M™ Acrylic Adhesive 200MP

Product number
Product description
Adhesive
Colour
Total thickness (thickness in mm without liner)
Carrier material
Carrier thickness (mm)
Adhesive thickness per side (mm)
Liner type
Liner thickness in mm (g/m ²)
Liner print
Temperature resistance (short-term = max. 1 h)
Temperature resistance (long-term = days, weeks)
Temperature resistance min.
Specifications
Adhesive performance high surface energy substrates (e.g. metal)
Adhesive performance medium surface energy substrates (e.g. polycarbonate)
Adhesive performance low surface energy substrates (e.g. PE/PP)
Conformability
Solvent resistance
Temperature resistance
Weather resistance
UV resistance

3M™ Acrylic Adhesive 200MP		
467MP <small>TOP SELLER</small>	467MPF <small>TOP SELLER</small>	468MP <small>TOP SELLER</small>
Adhesive Transfer Tape	Adhesive Transfer Tape	Adhesive Transfer Tape
Acrylic	Acrylic	Acrylic
Transparent	Transparent	Transparent
0.058	0.058	0.132
-	-	-
-	-	-
-	-	-
Polycoated kraft	PET film	Polycoated kraft
0.107 (94)	0.052	0.107 (94)
Green “3M™ 200MP”	-	Green “3M 200MP”
200°C	200°C	200°C
150°C	150°C	150°C
-40°C	-40°C	-40°C
UL 746C, UL 969, CSA-C22.2	UL 746C, UL 969, CSA-C22.3	UL 746C, UL 969, CSA-C22.4
10	10	10
7	7	7
1	1	1
+++	+++	+++
+++	+++	+++
++	++	++
++	++	++
+++	+++	+++

3M™ Acrylic Adhesive 200MP

468MPF	7952MP	7955MP <small>TOP SELLER</small>	7962MP	7965MP
Adhesive Transfer Tape	Adhesive Transfer Tape (Sheetstock, Double Lined)	Adhesive Transfer Tape (Sheetstock, Double Lined)	Adhesive Transfer Tape (Sheetstock, Double Lined)	Adhesive Transfer Tape (Sheetstock, Double Lined)
Acrylic	Acrylic	Acrylic	Acrylic	Acrylic
Transparent	Transparent	Transparent	Transparent	Transparent
0.132	0.058	0.132	0.058	0.132
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
PET film	Polycoated kraft	Polycoated kraft	Polycoated kraft	Polycoated kraft
0.052	0.107 (94)	0.107 (94)	0.158 (135) / 0.107 (94)	0.158 (135) / 0.107 (94)
-	Green “3M 200MP”	Green “3M 200MP”	Green “3M 200MP”	Green “3M 200MP”
200°C	200°C	200°C	200°C	200°C
150°C	150°C	150°C	150°C	150°C
-40°C	-40°C	-40°C	-40°C	-40°C
UL 746C, UL 969, CSA-C22.5	UL 746C, UL 969, CSA-C22.6	UL 746C, UL 969, CSA-C22.7	UL 746C, UL 969, CSA-C22.8	UL 746C, UL 969, CSA-C22.9
10	10	10	10	10
7	7	7	7	7
1	1	1	1	1
+++	+++	+++	+++	+++
+++	+++	+++	+++	+++
++	++	++	++	++
++	++	++	++	++
+++	+++	+++	+++	+++

200MP

3M™ Acrylic Adhesive 200MP

3M™ Acrylic Adhesive 200MP			
Product number	9172MP	92015	9495B
Product description	Adhesive Transfer Tape (Sheetstock, Double Lined)	Double Coated Tape with Polyester Carrier	Double Coated Tape with Polyester Carrier
Adhesive	Acrylic	Acrylic	Acrylic
Colour	Transparent	Transparent	Black
Total thickness (thickness in mm without liner)	0.050	0.150	0.145
Carrier material	-	PET film	PET film
Carrier thickness (mm)	-	0.013	0.013
Adhesive thickness per side (mm)	-	0.069	0.074 / 0.058
Liner type	Polycoated kraft / HDPE film	Polycoated kraft	Polycoated kraft
Liner thickness in mm (g/m²)	0.107 (94)	0.107 (94)	0.107 (94)
Liner print	Green "3M 200MP"	Green "3M 200MP"	Green "3M 200MP"
Temperature resistance (short-term = max. 1 h)	200°C	150°C	150°C
Temperature resistance (long-term = days, weeks)	150°C	120°C	120°C
Temperature resistance min.	-40°C	-40°C	-40°C
Specifications	UL 746C, UL 969, CSA-C22.10	UL 969, CSA-C22.11	-
Adhesive performance high surface energy substrates (e.g. metal)	10	10	10
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	7	7	7
Adhesive performance low surface energy substrates (e.g. PE/PP)	1	1	1
Conformability	+++	++	++
Solvent resistance	+++	+++	++
Temperature resistance	+++	+++	+++
Weather resistance	+++	++	++
UV resistance	+++	+++	+++

3M™ Acrylic Adhesive 200MP

9495MP	7945MP <small>TOP SELLER</small>	7953MP	7956MP <small>TOP SELLER</small>	7956WDL
Double Coated Tape with Polyester Carrier	Spacer (Sheetstock, Double Lined)	Spacer (Sheetstock, Double Lined)	Spacer (Sheetstock, Double Lined)	Spacer (Sheetstock, Double Lined)
Acrylic	Acrylic	Acrylic	Acrylic	Acrylic
Transparent	Transparent	Transparent	Transparent	White / Silver
0.145	0.141	0.100	0.167	0.167
PET film	PET film	PET film	PET film	PET, aluminium vapour coated on one side
0.013	0.025	0.013	0.051	0.051
0.074 / 0.058	0.058	0.043	0.058	0.058
Polycoated kraft	Polycoated kraft	Polycoated kraft	Polycoated kraft	Polycoated kraft
0.107 (94)	0.107 (94)	0.107 (94)	0.107 (94)	0.107 (94)
Green “3M 200MP”	Green “3M 200MP”	Green “3M 200MP”	Green “3M 200MP”	Green “3M 200MP”
150°C	150°C	150°C	150°C	150°C
120°C	120°C	120°C	120°C	120°C
-40°C	-40°C	-40°C	-40°C	-40°C
-	UL 696, CSA-C22.11	UL 746C, UL 696, CSA-C22.10	UL 746C, UL 696, CSA-C22.11	UL 746C, UL 696, CSA-C22.12
10	10	10	10	10
7	7	7	7	7
1	1	1	1	1
++	++	++	++	++
++	+++	+++	+++	+++
+++	+++	+++	+++	+++
++	+++	+++	+++	+++
+++	+++	+++	+++	+++

200MP

3M™ Acrylic Adhesive 200MP

3M™ Acrylic Adhesive 200MP			
Product number	7957MP	7959MP	7961MP
Product description	Spacer (Sheetstock, Double Lined)	Spacer (Sheetstock, Double Lined)	Spacer (Sheetstock, Double Lined)
Adhesive	Acrylic	Acrylic	Acrylic
Colour	Transparent	Transparent	Transparent
Total thickness (thickness in mm without liner)	0.192	0.243	0.294
Carrier material	PET film	PET film	PET film
Carrier thickness (mm)	0.076	0.127	0.178
Adhesive thickness per side (mm)	0.058	0.058	0.058
Liner type	Polycoated kraft	Polycoated kraft	Polycoated kraft
Liner thickness in mm (g/m ²)	0.107 (94)	0.107 (94)	0.107 (94)
Liner print	Green “3M 200MP”	Green “3M 200MP”	Green “3M 200MP”
Temperature resistance (short-term = max. 1 h)	150°C	150°C	150°C
Temperature resistance (long-term = days, weeks)	120°C	120°C	120°C
Temperature resistance min.	-40°C	-40°C	-40°C
Specifications	UL 746C, UL 696, CSA-C22.13	UL 746C, UL 696, CSA-C22.14	UL 746C, UL 696, CSA-C22.15
Adhesive performance high surface energy substrates (e.g. metal)	10	10	10
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	7	7	7
Adhesive performance low surface energy substrates (e.g. PE/PP)	1	1	1
Conformability	++	++	++
Solvent resistance	+++	+++	+++
Temperature resistance	+++	+++	+++
Weather resistance	+++	+++	+++
UV resistance	+++	+++	+++

3M™ Acrylic Adhesive 200MP

7966WDL	7993MP	7995MP	7997MP
Spacer (Sheetstock, Double Lined)	Spacer (Adhesive on One Side)	Spacer (Adhesive on One Side)	Spacer (Adhesive on One Side)
Acrylic	Acrylic	Acrylic	Acrylic
White / Silver	Transparent	Transparent	Transparent
0.230	0.083	0.134	0.185
PET, aluminium vapour coated on one side	PET film	PET film	PET film
0.051	0.025	0.076	0.127
0.058 / 0.125	0.058	0.058	0.058
Polycoated kraft	Polycoated kraft	Polycoated kraft	Polycoated kraft
0.107 (94)	0.172 (156)	0.172 (156)	0.172 (156)
Green “3M 200MP”	Green “3M 200MP”	Green “3M 200MP”	Green “3M 200MP”
150°C	150°C	150°C	150°C
120°C	120°C	120°C	120°C
-40°C	-40°C	-40°C	-40°C
UL 746C, UL 696, CSA-C22.16	UL 969	UL 969	UL 969
10	10	10	10
7	7	7	7
1	1	1	1
++	++	++	++
+++	+++	+++	+++
+++	+++	+++	+++
+++	+++	+++	+++
+++	+++	+++	+++

200MP



3M™ Acrylic Adhesives 300, 300LSE, 300MP

300

Advantages

- ▶ Suitable for high and low surface energy substrates
- ▶ High initial adhesion
- ▶ Good shear strength
- ▶ Thread reinforcement makes handling and processing easier

Application examples

- ▶ Self-adhesive finishing of films, foams, textiles, metal and plastic signs as well as trims
- ▶ Suitable for the aerospace and automotive industry

300LSE

Advantages

- ▶ Suitable for high and low surface energy substrates
- ▶ Good chemical, temperature and moisture resistance
- ▶ Suitable for lightly oiled surfaces
- ▶ High transparency
- ▶ High initial adhesion

Application examples

- ▶ Self-adhesive finishing of signs, labels, front panels printed from the back
- ▶ Bonding of polycarbonate signs printed from the back on powder coatings

300MP

Advantages

- ▶ Suitable for high and low surface energy substrates
- ▶ Particularly soft and free-flowing adhesive
- ▶ Good temperature resistance

Application examples

- ▶ Self-adhesive finishing of foams
- ▶ Suitable for porous and textured materials such as cork, leather, textiles

**300
300LSE
300MP**

3M™ Acrylic Adhesives 300

3M™ Acrylic Adhesives 300				
Product number	927	950 <small>TOP SELLER</small>	9458	9471 <small>TOP SELLER</small>
Product description	Adhesive Transfer Tape	Adhesive Transfer Tape	Adhesive Transfer Tape	Adhesive Transfer Tape
Adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive
Colour	Transparent	Transparent	Transparent	Transparent
Total thickness (thickness in mm without liner)	0.058	0.130	0.025	0.058
Carrier material	-	-	-	-
Carrier thickness (mm)	-	-	-	-
Adhesive thickness per side (mm)	-	-	-	-
Liner type	Densified kraft	Densified kraft	Densified kraft	Densified kraft
Liner thickness in mm (g/m ²)	0.089 (98)	0.089 (98)	0.089 (98)	0.089 (98)
Liner print	-	-	-	Green "3M"
Temperature resistance (short-term = max. 1 h)	120°C	120°C	120°C	120°C
Temperature resistance (long-term = days, weeks)	85°C	85°C	85°C	85°C
Temperature resistance min.	-40°C	-40°C	-40°C	-40°C
Specifications	-	UL 969	UL 969	UL 969
Adhesive performance high surface energy substrates (e.g. metal)	7	7	7	7
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	8	8	8	8
Adhesive performance low surface energy substrates (e.g. PE/PP)	8	8	8	8
Conformability	++	+++	++	++
Solvent resistance	++	++	++	++
Temperature resistance	++	++	++	++
Weather resistance	++	++	++	++
UV resistance	++	++	++	++

3M™ Acrylic Adhesives 300

9472 <small>TOP SELLER</small>	9672	950EK	9019
Adhesive Transfer Tape	Adhesive Transfer Tape	Adhesive Transfer Tape	Double Coated Tape with Polyester Carrier
Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive
Transparent	Transparent	Transparent	Transparent
0.130	0.130	0.130	0.030
-	-	-	PET film
-	-	-	0.013
-	-	-	0.0084
Densified kraft	Polycoated kraft	Polycoated kraft	Paper
0.089 (98)	0.165	0.150	0.089 (98)
Green “3M”	-	-	-
120°C	120°C	120°C	120°C
85°C	85°C	85°C	85°C
-40°C	-40°C	-40°C	-40°C
UL 696, CSA-C22.16	UL 696, CSA-C22.16	-	-
7	7	7	7
8	8	8	8
8	8	8	8
+++	+++	+++	+
++	++	++	++
++	++	++	++
++	++	++	++
++	++	++	++

300
300LSE
300MP

3M™ Acrylic Adhesives 300LSE

3M™ Acrylic Adhesives 300LSE				
Product number	8132LE	8153LE	9453LE	9471FL <small>TOP SELLER</small>
Product description	Adhesive Transfer Tape (Sheetstock, Double Lined)	Adhesive Transfer Tape (Sheetstock, Double Lined)	Adhesive Transfer Tape	Adhesive Transfer Tape
Adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive
Colour	Transparent	Transparent	Transparent	Transparent
Total thickness (thickness in mm without liner)	0.058	0.080	0.080	0.058
Carrier material	-	-	-	-
Carrier thickness (mm)	-	-	-	-
Adhesive thickness per side (mm)	-	-	-	-
Liner type	Polycoated kraft	Polycoated kraft	Polycoated kraft	PET film
Liner thickness in mm (g/m ²)	0.100 (98) / 0.141 (130)	0.100 (98) / 0.141 (130)	0.100 (98)	0.050
Liner print	Green “3M 300LSE”	Green “3M 300LSE”	Green “3M 300LSE”	-
Temperature resistance (short-term = max. 1 h)	150°C	150°C	150°C	150°C
Temperature resistance (long-term = days, weeks)	90°C	90°C	90°C	90°C
Temperature resistance min.	-40°C	-40°C	-40°C	-40°C
Specifications	UL 746C, UL 696, CSA-C22.14	UL 746C, UL 696, CSA-C22.14	UL 696, CSA-C22.16	UL 696, CSA-C22.16
Adhesive performance high surface energy substrates (e.g. metal)	9	9	9	9
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	9	9	9	9
Adhesive performance low surface energy substrates (e.g. PE/PP)	9	9	9	9
Conformability	+++	+++	+++	+++
Solvent resistance	+++	+++	+++	+++
Temperature resistance	++	++	++	++
Weather resistance	++	++	++	++
UV resistance	++	+++	++	++

3M™ Acrylic Adhesives 300LSE

9471LE	9472LE <small>TOP SELLER</small>	9671LE	9672LE	93010LE <small>TOP SELLER</small>
Adhesive Transfer Tape	Adhesive Transfer Tape	Adhesive Transfer Tape	Adhesive Transfer Tape	Double Coated Tape with Polyester Carrier
Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive
Transparent	Transparent	Transparent	Transparent	Transparent
0.058	0.132	0.058	0.132	0.100
-	-	-	-	PET film
-	-	-	-	0.012
-	-	-	-	0.044
Polycoated kraft	Polycoated kraft	Polycoated kraft	Polycoated kraft	Polycoated kraft
0.100 (98)	0.100 (98)	0.141 (130)	0.165 (140)	0.100 (98)
Green "3M 300LSE"	Green "3M 300LSE"	Green "3M 300LSE"	Green "3M 300LSE"	Green "3M 300LSE"
150°C	150°C	150°C	150°C	150°C
90°C	90°C	90°C	90°C	120°C
-40°C	-40°C	-40°C	-40°C	-40°C
UL 746C, UL 696, CSA-C22.14	UL 696, CSA-C22.16	UL 746C, UL 696, CSA-C22.14	UL 696, CSA-C22.16	UL 746C
9	9	9	9	9
9	9	9	9	9
9	9	9	9	9
+++	+++	+++	+++	+
+++	+++	+++	+++	+++
++	++	++	++	+++
++	++	++	++	+++
++	++	++	++	++

**300
300LSE
300MP**

3M™ Acrylic Adhesives 300LSE, 300MP

3M™ Acrylic Adhesives 300LSE				
Product number	93015LE <small>TOP SELLER</small>	93020LE <small>TOP SELLER</small>	9474LE	9495LE <small>TOP SELLER</small>
Product description	Double Coated Tape with Polyester Carrier	Double Coated Tape with Polyester Carrier	Double Coated Tape with Polyester Carrier (Sheetstock, Double Lined)	Double Coated Tape with Polyester Carrier
Adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive
Colour	Transparent	Transparent	Transparent	Transparent
Total thickness (thickness in mm without liner)	0.150	0.200	0.170	0.170
Carrier material	PET film	PET film	PET film	PET film
Carrier thickness (mm)	0.012	0.012	0.0125	0.0125
Adhesive thickness per side (mm)	0.069	0.094	0.071/0.086	0.071/0.086
Liner type	Polycoated kraft	Polycoated kraft	Polycoated kraft	Polycoated kraft
Liner thickness in mm (g/m ²)	0.100 (98)	0.100 (98)	0.100/0.165 (98/140)	0.100 (98)
Liner print	Green “3M 300LSE”	Green “3M 300LSE”	Green “3M 300LSE”	Green “3M 300LSE”
Temperature resistance (short-term = max. 1 h)	150°C	150°C	150°C	150°C
Temperature resistance (long-term = days, weeks)	120°C	120°C	90°C	90°C
Temperature resistance min.	-40°C	-40°C	-40°C	-40°C
Specifications	UL 746C	UL 746C	UL 969	UL 969
Adhesive performance high surface energy substrates (e.g. metal)	9	9	9	9
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	9	9	9	9
Adhesive performance low surface energy substrates (e.g. PE/PP)	9	9	9	9
Conformability	+	++	++	++
Solvent resistance	+++	+++	+++	+++
Temperature resistance	+++	+++	++	++
Weather resistance	+++	+++	++	++
UV resistance	++	++	++	++

3M™ Acrylic Adhesives 300MP				
6035PC	9773WL	9774WL <small>TOP SELLER</small>	9775WL <small>TOP SELLER</small>	99786
Adhesive Transfer Tape	Adhesive Transfer Tape	Adhesive Transfer Tape	Adhesive Transfer Tape	Double Coated Tape with Non-Woven Carrier
Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive
Transparent	Transparent	Transparent	Transparent	White
0.127	0.076	0.099	0.125	0.140
-	-	-	-	Non-woven tissue
-	-	-	-	-
-	-	-	-	0.070
Polycoated kraft	Polycoated kraft	Polycoated kraft	Polycoated kraft	Polycoated kraft
0.107	0.172 (156)	0.172 (156)	0.172 (156)	0.104 (94)
-	-	-	-	Green "3M™"
120°C	120°C	120°C	120°C	150°C
70°C	70°C	70°C	70°C	90°C
-	-	-	-	-
-	UL 746C	UL 746C	UL 746C	UL 696, CSA-C22.16
8	8	8	8	8
8	8	8	8	8
7	7	7	7	7
+++	+++	+++	+++	+
++	++	++	++	++
+	+	+	+	++
++	++	++	++	++
++	++	++	++	++

**300
300LSE
300MP**



3M™ Acrylic Adhesives 350 and 360

350

Advantages

- ▶ Suitable for a wide range of high and low surface energy substrates
- ▶ Good shear strength
- ▶ Very high temperature, solvent and UV resistance
- ▶ Thread reinforcement makes handling and processing easier

Application examples

- ▶ Bonding, holding and laminating of materials such as metal, paint, glass, wood, ceramics or plastic
- ▶ 9731: Bonding of silicone rubber with other high and low surface energy materials

360

Advantages

- ▶ Suitable for a wide range of high and low surface energy substrates
- ▶ Very strong initial adhesion – even to low surface energy plastics (PE, PP)
- ▶ High adhesion with a thin adhesive layer
- ▶ Low odour
- ▶ Minimal oozing

Application examples

- ▶ Attaching decorative trims/materials
- ▶ Bonding vinyl, leather, neoprene foam and textiles
- ▶ Assembly of hard cases and components

350
360

3M™ Acrylic Adhesives 350 and 360

Product number	3M™ Acrylic Adhesive 350		
	9482PC	9485PC	9500PC
Product description	Adhesive Transfer Tape	Adhesive Transfer Tape	Double Coated Tape with Polyester Carrier
Adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive
Colour	Transparent	Transparent	Transparent
Total thickness (thickness in mm without liner)	0.050	0.135	0.141
Carrier material	-	-	PET film
Carrier thickness (mm)	-	-	0.025
Adhesive thickness per side (mm)	-	-	0.058
Liner type	Polycoated kraft	Polycoated kraft	Polycoated kraft
Liner thickness in mm (g/m ²)	0.107 (94)	0.107 (94)	0.110
Liner print	-	-	-
Temperature resistance (short-term = max. 1 h)	200°C	200°C	200°C
Temperature resistance (long-term = days, weeks)	150°C	150°C	150°C
Temperature resistance min.	-40°C	-40°C	-40°C
Specifications	UL 746C, UL 696, CSA-C22.14	UL 746C, UL 696, CSA-C22.14	UL 510
Adhesive performance high surface energy substrates (e.g. metal)	9	9	9
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	9	9	9
Adhesive performance low surface energy substrates (e.g. PE/PP)	9	9	9
Conformability	++	+++	++
Solvent resistance	+++	+++	+++
Temperature resistance	+++	+++	+++
Weather resistance	+++	+++	+++
UV resistance	+++	+++	+++

3M™ Acrylic Adhesive 350					
9626 <small>TOP SELLER</small>	9627 <small>TOP SELLER</small>	9628B	9628FL <small>TOP SELLER</small>	9629B	9629PC <small>TOP SELLER</small>
Adhesive Transfer Tape	Adhesive Transfer Tape	Double Coated Tape with Polyester Carrier	Double Coated Tape with Polyester Carrier	Double Coated Tape with Polyester Carrier	Double Coated Tape with Polyester Carrier
Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive
Transparent	Transparent	Black	Transparent	Black	Transparent
0.050	0.130	0.050	0.050	0.100	0.100
-	-	PET film	PET film	PET film	PET film
-	-	0.013	0.013	0.013	0.013
-	-	0.019	0.019	0.040	0.040
Densified kraft	Densified kraft	Glassine paper	PET film	Glassine paper	Polycoated kraft
0.89 (98)	0.89 (98)	0.89 (98)	0.050	0.89 (98)	0.110
-	-	-	-	-	-
180°C	180°C	180°C	180°C	180°C	180°C
95°C	95°C	95°C	95°C	95°C	95°C
-	-	-40°C	-40°C	-40°C	-40°C
-	-	-	-	-	-
9	9	9	9	9	9
9	9	9	9	9	9
10	10	10	10	10	10
+++	+++	++	++	++	++
+++	+++	+++	+++	+++	+++
++	++	++	++	++	++
++	++	++	++	++	++
++	++	++	++	++	++

350
360



3M™ Scotch® ATG System

Advantages

Quick and easy

- ▶ Always ready for use
- ▶ Adhesive tape bonds immediately
- ▶ No rework required
- ▶ The liner is removed and rolled up automatically

Cost-effective and versatile

- ▶ Less adhesive needed
- ▶ Refillable
- ▶ The ideal tape for a wide range of materials and almost any application

Clean and safe

- ▶ Precise application
- ▶ Consistent adhesive tape width and thickness
- ▶ Apply precisely the amount of tape you need
- ▶ No strong odours
- ▶ Ergonomic design
- ▶ Effortless application

Application examples

- ▶ Fast self-adhesive finishing of a wide range of materials
- ▶ Assembly of promotional materials
- ▶ Mounting in industrial applications
- ▶ Foam and film bonding

**Scotch® ATG
System**

3M™ Scotch® ATG System

Product number	3M™ Acrylic Adhesive 300		3M™ Acrylic Adhesive 350
	969 <small>TOP SELLER</small>	976	926
Product description	ATG Adhesive Tape	ATG Adhesive Tape	ATG Adhesive Tape
Adhesive	Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive
Colour	Transparent	Transparent	Transparent
Total thickness (thickness in mm without liner)	0.130	0.058	0.135
Carrier material	-	-	-
Carrier thickness (mm)	-	-	-
Adhesive thickness per side (mm)	-	-	-
Liner type	Paper	Paper	Paper
Liner thickness in mm (g/m²)	0.89 (98)	0.89 (98)	-
Liner print	-	-	-
Temperature resistance (short-term = max. 1 h)	120°C	120°C	230°C
Temperature resistance (long-term = days, weeks)	85°C	85°C	150°C
Temperature resistance min.	-	-	-40°C
Specifications	-	-	UL 746C, UL 696, CSA-C22.14
Adhesive performance high surface energy substrates (e.g. metal)	7	7	9
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	8	8	9
Adhesive performance low surface energy substrates (e.g. PE/PP)	8	8	9
Conformability	+++	+++	+++
Solvent resistance	++	++	+++
Temperature resistance	++	++	+++
Weather resistance	++	++	+++
UV resistance	++	++	+++

3M™ Acrylic Adhesive 400	3M™ Acrylic Adhesive 400/1000	Acrylics	ATG applicators	
924EU	928	904 <small>TOP SELLER</small>	ATG700 <small>TOP SELLER</small>	ATG700 ADAPTER
ATG Adhesive Tape	ATG Adhesive Tape	ATG Adhesive Tape	Applicator	Adapter for 6 mm Roll Width
Acrylic	Acrylic	Acrylic	-	-
Transparent	White	Transparent	Yellow	Black
0.050	0.028	0.050	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
Densified kraft	Paper	Paper	-	-
0.89 (98)	0.142	-	-	-
Green plaid	-	-	-	-
120°C	65°C	90°C	-	-
85°C	-	70°C	-	-
-40°C	-40°C	-40°C	-	-
-	-	-	-	-
5	5 /1	6	-	-
5	5 /1	6	-	-
5	5 /1	1	-	-
+++	+++	+++	-	-
++	+	++	-	-
++	+	+	-	-
+++	+	+++	-	-
+++	++	+++	-	-

Scotch® ATG System



3M™ Special products

Universal adhesive tapes

Advantages

- ▶ Suitable for high and low surface energy substrates
- ▶ Very good shear strength
- ▶ High transparency
- ▶ Carrier makes handling and processing easier

Application examples

- ▶ Universal
- ▶ Self-adhesive finishing of furniture trim mouldings, cable ducts or sealing profiles
- ▶ Mounting, assembly and holding of promotional materials

Removable and re-positionable products

Advantages

- ▶ Different strength adhesives on both sides
- ▶ Removable side can be removed from many surfaces without residue
- ▶ Can be repositioned multiple times

Application examples

- ▶ Bonding of removable seals
- ▶ Mounting of promotional materials
- ▶ Replaceable planning and presentation materials
- ▶ Resealable packaging materials

Silicone adhesive tapes

Advantages

- ▶ Good adhesion to most silicone substrates
- ▶ Noise and vibration reducing properties
- ▶ Very high temperature and solvent resistance

Application examples

- ▶ Bonding of seals
- ▶ Splicing of silicone liners
- ▶ Bonding on anti-fingerprint (easy-to-clean) surfaces
- ▶ Bonding of noise-damping shims on brakes

Low VOC (low-emission products)

Advantages

- ▶ Suitable for a wide range of high and low surface energy substrates
- ▶ High adhesion to PU ester foams and EPDM
- ▶ Low-emission (tested to VDA278 and JAMA)
- ▶ Reduced weight

Application examples

- ▶ Bonding of decorative trims in vehicle interiors
- ▶ Affixing of trim parts and decorative materials
- ▶ Bonding of sensors
- ▶ Attachment of carpets

3M™ Special products

Product number	3M™ Acrylic Adhesive 220		3M™ Acrylic Adhesive 375	
	9502 <small>TOP SELLER</small>	9505 <small>TOP SELLER</small>	9086	9087
Product description	Adhesive Transfer Tape	Adhesive Transfer Tape	Double Coated Tape with Non-Woven Tissue Carrier	Double Coated Tape with PVC Carrier
Adhesive	Acrylic	Acrylic	Acrylic	Acrylic
Colour	Transparent	Transparent	White	White
Total thickness (thickness in mm without liner)	0.060	0.120	0.190	0.278
Carrier material	-	-	Non-woven tissue	PVC
Carrier thickness (mm)	-	-	-	0.038
Adhesive thickness per side (mm)	-	-	0.095	0.120
Liner type	Polycoated kraft	Polycoated kraft	Densified kraft	Densified kraft
Liner thickness in mm (g/m ²)	0.107 (94)	0.107 (94)	0.070	-
Liner print	Green “3M”	Green “3M”	Black “3M”	Green “3M”
Temperature resistance (short-term = max. 1 h)	170°C	170°C	120°C	85°C
Temperature resistance (long-term = days, weeks)	120°C	120°C	85°C	70°C
Temperature resistance min.	-40°C	-40°C	-40°C	-40°C
Specifications	UL 969	UL 969	-	-
Adhesive performance high surface energy substrates (e.g. metal)	8	8	9	9
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	6	6	9	9
Adhesive performance low surface energy substrates (e.g. PE/PP)	1	1	9	9
Conformability	+++	+++	++	++
Solvent resistance	+++	+++	++	++
Temperature resistance	+++	+++	++	+
Weather resistance	++	++	++	++
UV resistance	+++	+++	+++	+++

3M™ Acrylic Adhesive 400	
465EU	415 <small>TOP SELLER</small>
Adhesive Transfer Tape	Double Coated Tape with Polyester Carrier
Acrylic	Acrylic
Transparent	Transparent
0.050	0.100
-	PET film
-	-
-	-
Densified kraft	Densified kraft
0.089 (98)	0.100
Green plaid	-
120°C	85°C
85°C	65°C
-40°C	-40°C
-	-
5	5
5	5
5	5
+++	++
++	++
++	+
+++	+++
+++	+++

3M™ Acrylic Adhesive 420		
94210	94215	94220
Double Coated Tape with Polyester Carrier	Double Coated Tape with Polyester Carrier	Double Coated Tape with Polyester Carrier
Modified acrylic adhesive	Modified acrylic adhesive	Modified acrylic adhesive
Transparent	Transparent	Transparent
0.100	0.150	0.200
PET film	PET film	PET film
0.012	0.012	0.012
0.044	0.069	0.094
Polycoated kraft	Polycoated kraft	Polycoated kraft
0.107 (94)	0.107 (94)	0.107 (94)
Green “3M”	Green “3M”	Green “3M”
150°C	150°C	150°C
120°C	120°C	120°C
-40°C	-40°C	-40°C
-	-	-
6	6	6
6	6	6
6	6	6
++	++	++
++	++	++
+++	+++	+++
++	++	++
+++	+++	+++

3M™ Special products

	Rubber	Low VOC	
Product number	9191	98010LVC	99015LVC
Product description	Double Coated Tape with Fabric Carrier	Scrim Reinforced Adhesive Transfer Tape	Double Coated Tape with Non-Woven Tissue Carrier
Adhesive	Rubber adhesive	Acrylic	Acrylic
Colour	White	Transparent (adhesive) / white (scrim)	White
Total thickness (thickness in mm without liner)	0.260	0.100	0.150
Carrier material	Rayon	Scrim	Non-woven tissue
Carrier thickness (mm)	-	-	-
Adhesive thickness per side (mm)	0.130	-	0.075
Liner type	Paper	Densified kraft	Densified kraft
Liner thickness in mm (g/m²)	0.060	0.080 (90)	0.080 (90)
Liner print	-	Red "3M low VOC"	Red "3M low VOC"
Temperature resistance (short-term = max. 1 h)	-	120°C	120°C
Temperature resistance (long-term = days, weeks)	60°C	90°C	90°C
Temperature resistance min.	-	-40°C	-40°C
Specifications	-	VDA 278, JAMA	VDA 278, JAMA
Adhesive performance high surface energy substrates (e.g. metal)	8 / 6	9	9
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	8 / 6	9	9
Adhesive performance low surface energy substrates (e.g. PE/PP)	-	9	9
Conformability	+	+++	+++
Solvent resistance	+	++	++
Temperature resistance	+	++	++
Weather resistance	+	++	++
UV resistance	+	++	++

Acrylic			
9195	9080HL	New 3M™ GPT-020 <small>TOP SELLER</small>	9448A
Double Coated Tape with Polypropylene Carrier	Double Coated Tape with Non-Woven Tissue Carrier	Double Coated Tape with Polyester Carrier	Double Coated Tape with Non-Woven Tissue Carrier
Hot-melt / acrylic	Acrylic	Acrylic	Acrylic
Yellow	White	Transparent	Translucent
0.130	0.160	0.200	0.150
PP film	Non-woven	PP film	Non-woven tissue
0.050	-	0.012	-
0.040	0.080	0.094	0.075
Paper	Polycoated kraft	Polycoated craft	Polycoated kraft
-	-	0.080 (94)	0.140 (120)
-	Grey "3M"	Red "3M"	Blue "3M 9448A"
60°C	120°C	190°C	150°C
-	90°C	90°C	70°C
-40°C	-40°C	-40°C	-40°C
-	-	-	-
7/3	9	9	7
7/3	9	9	7
-	9	9	5
++	++	++	++
++	++	+++	++
+	++	++	++
++	++	+++	++
++	++	+++	++

3M™ Special products

Product number	3M™ Acrylic Adhesive 350/silicone		Silicone	
	9731 <small>TOP SELLER</small>		91022	96042
Product description	Double Coated Tape with Polyester Carrier		Adhesive Transfer Tape	Double Coated Tape with Polyester Carrier
Adhesive	Acrylic / silicone		Silicone	Silicone
Colour	Transparent		Transparent	Transparent
Total thickness (thickness in mm without liner)	0.100		0.050	0.130
Carrier material	PET film		-	PET film
Carrier thickness (mm)	0.014		-	0.025
Adhesive thickness per side (mm)	0.033 / 0.053		-	0.050
Liner type	Polycoated kraft/PET film		PET film	PET film
Liner thickness in mm (g/m²)	0.127 / 0.074		0.050	0.050
Liner print	-		-	-
Temperature resistance (short-term = max. 1 h)	200°C		260°C	150°C
Temperature resistance (long-term = days, weeks)	150°C		-	-
Temperature resistance min.	-		-40°C	-40°C
Specifications	-		-	-
Adhesive performance high surface energy substrates (e.g. metal)	10		10	10
Adhesive performance medium surface energy substrates (e.g. polycarbonate)	10		10	10
Adhesive performance low surface energy substrates (e.g. PE/PP)	10		9	8
Conformability	++		+++	+
Solvent resistance	++		+++	+++
Temperature resistance	+++		+++	+++
Weather resistance	+		+++	+++
UV resistance	+		+++	+++

3M™ Acrylic Adhesive 400 / 1000		3M™ Acrylic Adhesive 420 / 1050	
9416 (Removable)	9415PC (Removable) <small>TOP SELLER</small>	9425HT (Removable) <small>TOP SELLER</small>	
Double Coated Tape with Non-Woven Tissue Carrier (Removable)	Double Coated Tape with Polyester Carrier (Removable)	Double Coated Tape with Polyester Carrier (Removable)	
Acrylic	Acrylic	Acrylic	
White	Transparent	Transparent	
0.050	0.050	0.125	
Non-woven tissue	PET film	PET film	
-	0.025	0.025	
0.025	0.0125	0.050	
Paper	Polyc coated kraft	Polyc coated kraft	
0.142	0.140	0.104 (94)	
-	-	-	
65°C	65°C	120°C	
-	-	-	
-40°C	-	-	
-	-	-	
5/1	5/1	5/1	
5/1	5/1	5/1	
5/1	5/1	5/1	
++	++	+	
+	+	++	
+	+	+++	
+	+	++	
++	++	+++	

Index based on product numbers

Product No.	Description	Page
415	Double Coated Tape with Polyester Carrier	63
465EU	Adhesive Transfer Tape	63
467MP	Adhesive Transfer Tape	38
467MPF	Adhesive Transfer Tape	38
468MP	Adhesive Transfer Tape	38
468MPF	Adhesive Transfer Tape	39
ATG700	Applicator	59
ATG700 ADAPTER	Adapter for 6 mm Roll Width	59
904	ATG Adhesive Tape	59
924EU	ATG Adhesive Tape	59
926	ATG Adhesive Tape	58
927	Adhesive Transfer Tape	46
928	ATG Adhesive Tape	59
950	Adhesive Transfer Tape	46
950EK	Adhesive Transfer Tape	47
969	ATG Adhesive Tape	58
976	ATG Adhesive Tape	58
5906	VHB™ Adhesive Tape	35
5907	VHB™ Adhesive Tape	35
5908	VHB™ Adhesive Tape	35
5909	VHB™ Adhesive Tape	35
6035PC	Adhesive Transfer Tape	51
7945MP	Spacer (Sheetstock, Double Lined)	41
7952MP	Adhesive Transfer Tape (Sheetstock, Double Lined)	39
7953MP	Spacer (Sheetstock, Double Lined)	41
7955MP	Adhesive Transfer Tape (Sheetstock, Double Lined)	39
7956MP	Spacer (Sheetstock, Double Lined)	41
7956WDL	Spacer (Sheetstock, Double Lined)	41

Product No.	Description	Page
7957MP	Spacer (Sheetstock, Double Lined)	42
7959MP	Spacer (Sheetstock, Double Lined)	42
7961MP	Spacer (Sheetstock, Double Lined)	42
7962MP	Adhesive Transfer Tape (Sheetstock, Double Lined)	39
7965MP	Adhesive Transfer Tape (Sheetstock, Double Lined)	39
7966WDL	Spacer (Sheetstock, Double Lined)	43
7993MP	Spacer (Adhesive on One Side)	43
7995MP	Spacer (Adhesive on One Side)	43
7997MP	Spacer (Adhesive on One Side)	43
8132LE	Adhesive Transfer Tape (Sheetstock, Double Lined)	48
8153LE	Adhesive Transfer Tape (Sheetstock, Double Lined)	48
9019	Double Coated Tape with Polyester Carrier	47
9080HL	Double Coated Tape with Non-Woven Tissue Carrier	65
9086	Double Coated Tape with Non-Woven Tissue Carrier	62
9087	Double Coated Tape with PVC Carrier	62
9172MP	Adhesive Transfer Tape (Sheetstock, Double Lined)	40
9191	Double Coated Tape with Fabric Carrier	64
9195	Double Coated Tape with Polypropylene Carrier	65
9415PC	Double Coated Tape with Polyester Carrier (Removable)	67
9416	Double Coated Tape with Non-Woven Tissue Carrier (Removable)	67
9425HT	Double Coated Tape with Polyester Carrier (Removable)	67
9448A	Double Coated Tape with Non-Woven Tissue Carrier	65
9453LE	Adhesive Transfer Tape	48
9458	Adhesive Transfer Tape	46
9460PC	VHB™ Adhesive Transfer Tape	34
F9460PC	VHB™ Adhesive Transfer Tape	34
9469PC	VHB™ Adhesive Transfer Tape	34
F9469PC	VHB™ Adhesive Transfer Tape	35

Product No.	Description	Page
9471	Adhesive Transfer Tape	46
9471FL	Adhesive Transfer Tape	48
9471LE	Adhesive Transfer Tape	49
9472	Adhesive Transfer Tape	47
9472LE	Adhesive Transfer Tape	49
9473PC	3M™ VHB™ Adhesive Transfer Tape	34
F9473PC	3M™ VHB™ Adhesive Transfer Tape	35
9474LE	Double Coated Tape with Polyester Carrier (Sheetstock, Double Lined)	50
9482PC	Adhesive Transfer Tape	54
9485PC	Adhesive Transfer Tape	54
9495B	Double Coated Tape with Polyester Carrier	40
9495LE	Double Coated Tape with Polyester Carrier	50
9495MP	Double Coated Tape with Polyester Carrier	41
9500PC	Double Coated Tape with Polyester Carrier	54
9502	Adhesive Transfer Tape	62
9505	Adhesive Transfer Tape	62
9626	Adhesive Transfer Tape	55
9627	Adhesive Transfer Tape	55
9628B	Double Coated Tape with Polyester Carrier	55
9628FL	Double Coated Tape with Polyester Carrier	55
9629B	Double Coated Tape with Polyester Carrier	55
9629PC	Double Coated Tape with Polyester Carrier	55
9671LE	Adhesive Transfer Tape	49
9672	Adhesive Transfer Tape	47
9672LE	Adhesive Transfer Tape	49
9731	Double Coated Tape with Polyester Carrier	66
9773WL	Adhesive Transfer Tape	51
9774WL	Adhesive Transfer Tape	51

Product No.	Description	Page
9775WL	Adhesive Transfer Tape	51
91022	Adhesive Transfer Tape	66
92015	Double Coated Tape with Polyester Carrier	40
93010LE	Double Coated Tape with Polyester Carrier	49
93015LE	Double Coated Tape with Polyester Carrier	50
93020LE	Double Coated Tape with Polyester Carrier	50
94210	Double Coated Tape with Polyester Carrier	63
94215	Double Coated Tape with Polyester Carrier	63
94220	Double Coated Tape with Polyester Carrier	63
96042	Double Coated Tape with Polyester Carrier	66
98010LVC	Scrim Reinforced Adhesive Transfer Tape	64
99015LVC	Double Coated Tape with Non-Woven Tissue Carrier	64
99786	Double Coated Tape with Non-Woven Carrier	51

Important Note

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