



Science.
Applied to Life.™

EMEA Product guide

3M™ Thin Bonding

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From page 33

3M™ Acrylic Adhesive 100MP

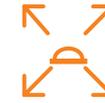
- ▶ Exceptional shear strength even at elevated temperatures and higher peel strength than many other adhesive families
- ▶ Very high temperature resistance
- ▶ High solvent resistance
- ▶ Short-term temperature resistance of up to 260°C. Long-term up to 150°C



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

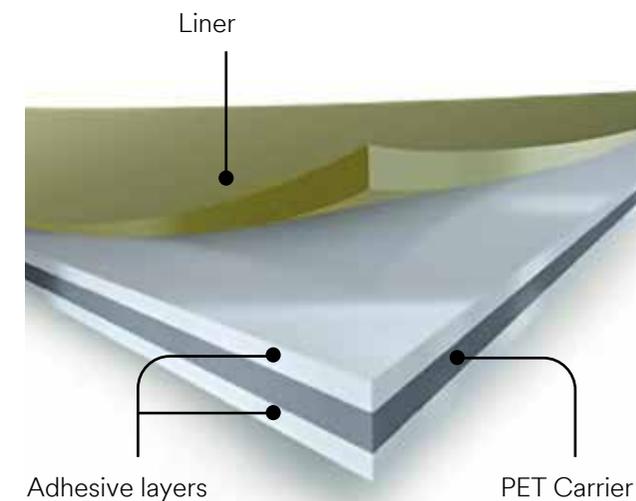
- ▶ Range of products for special applications
- ▶ Removable and repositionable products, products with a sticky note effect, silicone adhesive tapes, universal products and Low VOC adhesive solutions
- ▶ From simple paper application to demanding silicone application

Carriers

Double Coated Tapes with PET Carrier

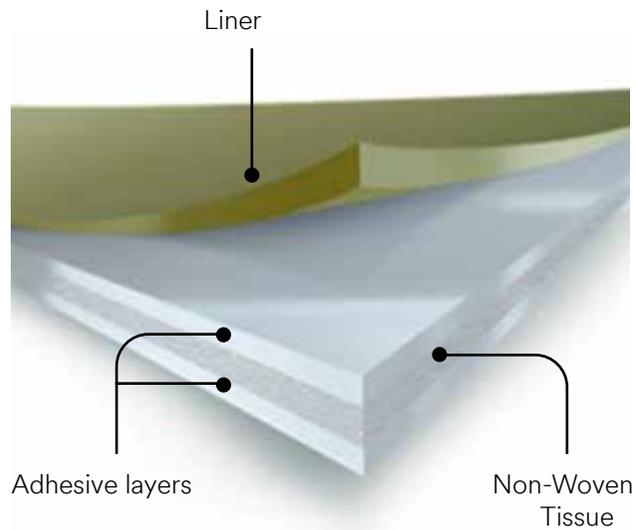
For extremely delicate die-cut shapes, double coated tapes provide the necessary stability during processing thanks to their carrier.

3M™ Double Coated Tapes with PET Carrier



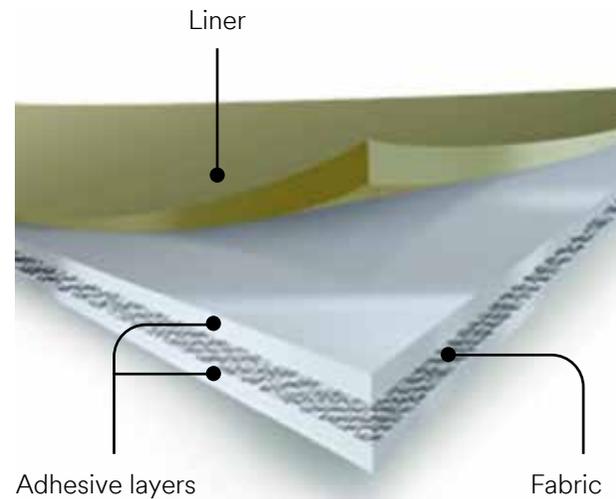
- ▶ Dimensional stability
- ▶ Tear resistant
- ▶ Carrier makes handling and processing easier
- ▶ Also suitable for narrow contours, edges and smaller, delicate die-cut shapes
- ▶ Electrical insulation properties (depending on the carrier thickness)

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



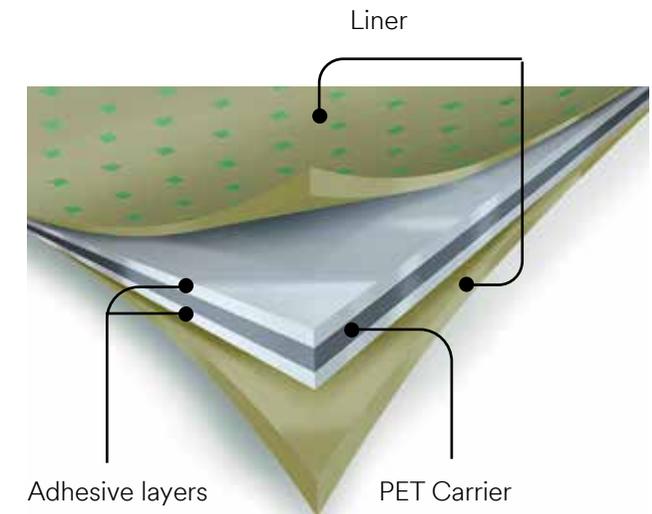
- ▶ Very thin carrier
- ▶ Conformable
- ▶ Hand tearable
- ▶ Carrier makes handling and processing easier
- ▶ Cheaper than PET adhesive tapes

3M™ Double Coated Tapes with Fabric Carrier



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

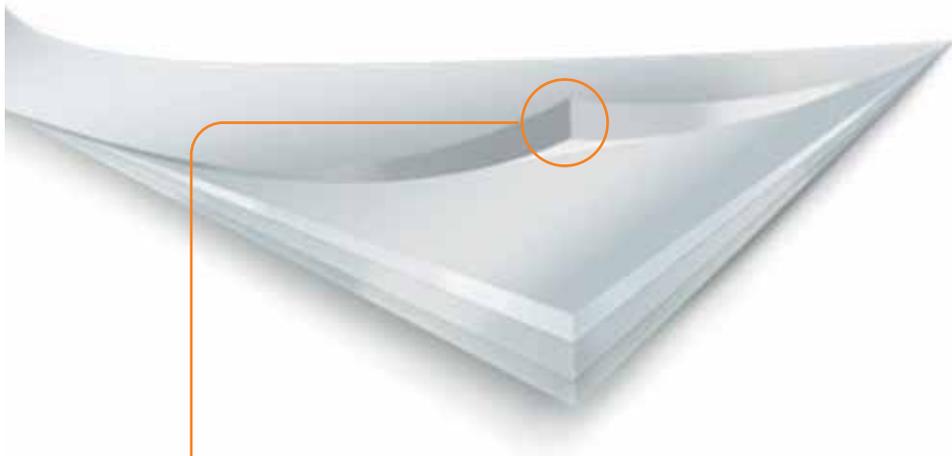
3M™ Spacers



- ▶ 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

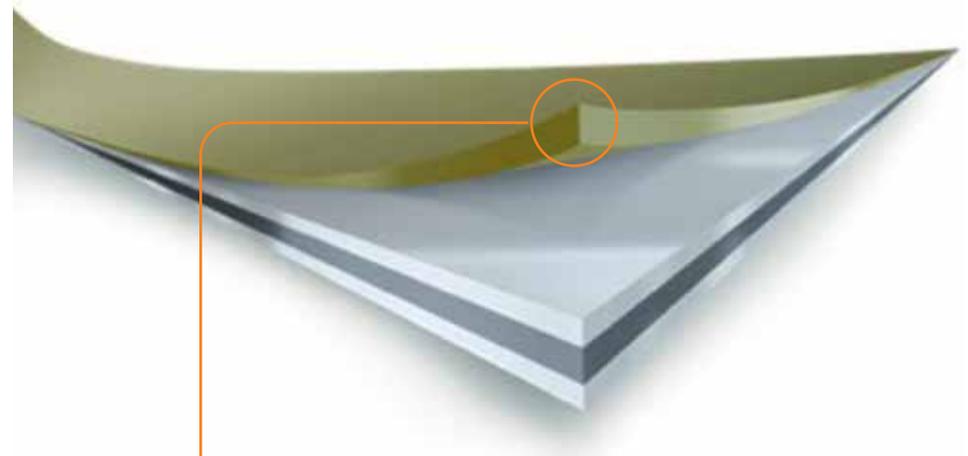
3M™ Liners

Liners – Polyester (PET)



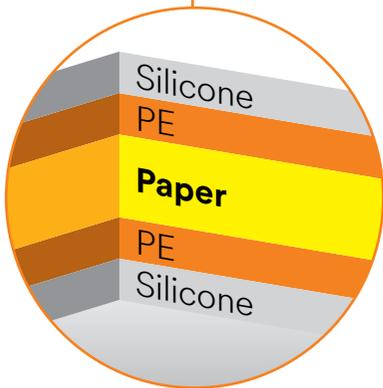
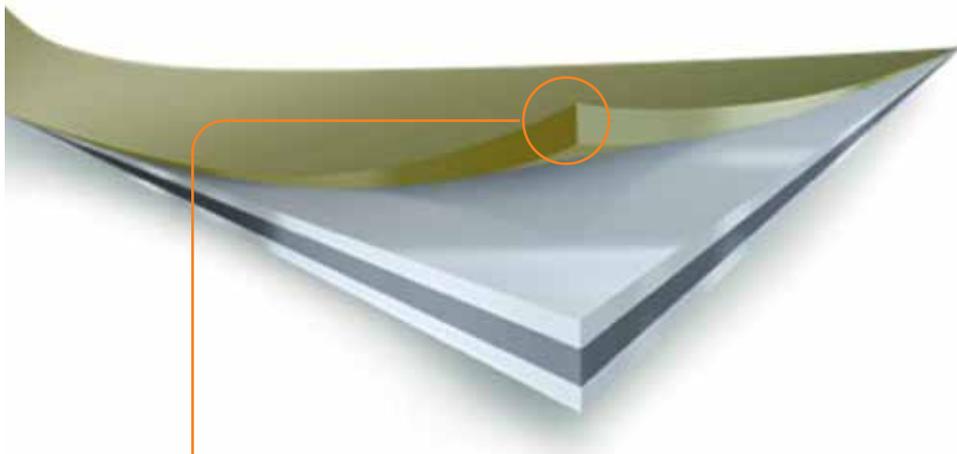
- ▶ Silicone treated on both sides
- ▶ Transparent (allows visual inspection)
- ▶ Well suited for rotary die-cutting
- ▶ Excellent moisture stability
- ▶ Suitable for clean rooms (no paper fibres)

Liners – Densified Kraft/Glassine



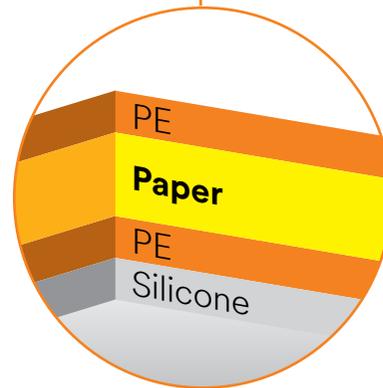
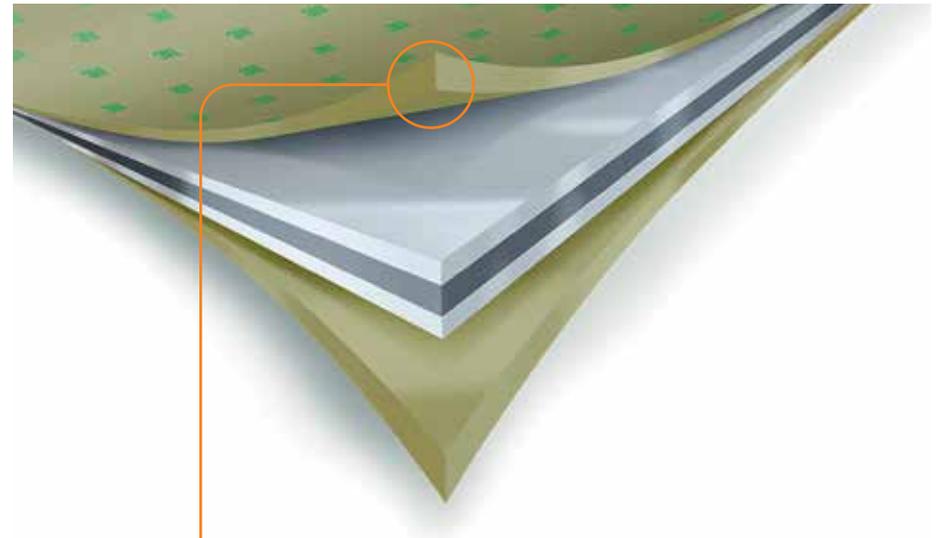
- ▶ Silicone treated on both sides
- ▶ Well suited for rotary die-cutting
- ▶ No moisture stability

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

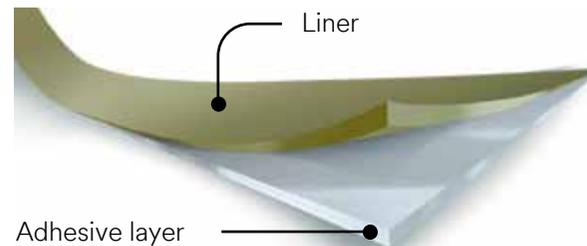
When choosing a suitable adhesive tape, the adhesive is not the only important consideration. For rough and textured surfaces in particular, the thickness of the adhesive layer can be a decisive factor. Transfer tape is therefore generally a better choice than a double coated tape for highly textured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

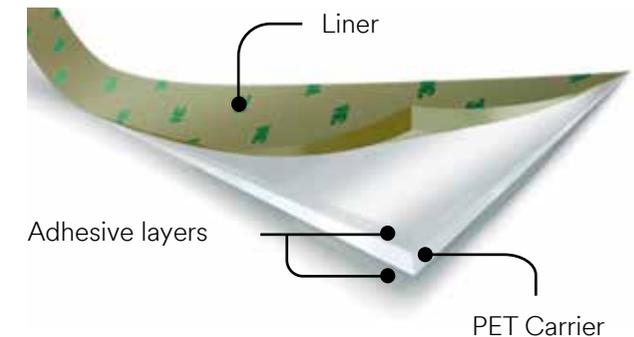
Spacers are a special type of double coated tape. They have a thicker carrier and therefore offer a spacer function.

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

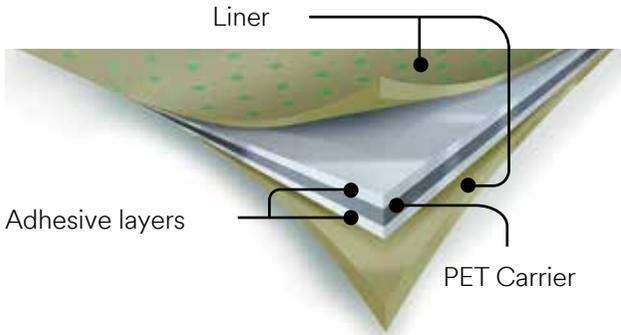


- ▶ **Thickness: 50 – 250 µm**
- ▶ **With (intermediate) carrier**
- ▶ Lower flexibility and conformability than adhesive transfer tape
- ▶ Compensates for surface roughness less effectively than adhesive transfer tape
- ▶ Carrier limits temperature resistance
- ▶ Increased internal stability thanks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

Adhesive transfer tape vs double coated tape

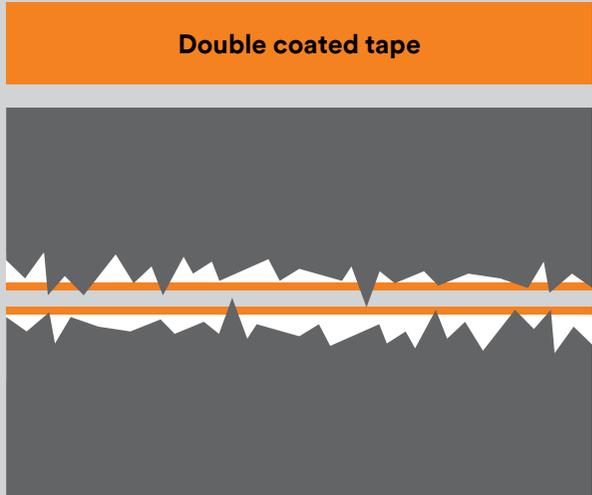
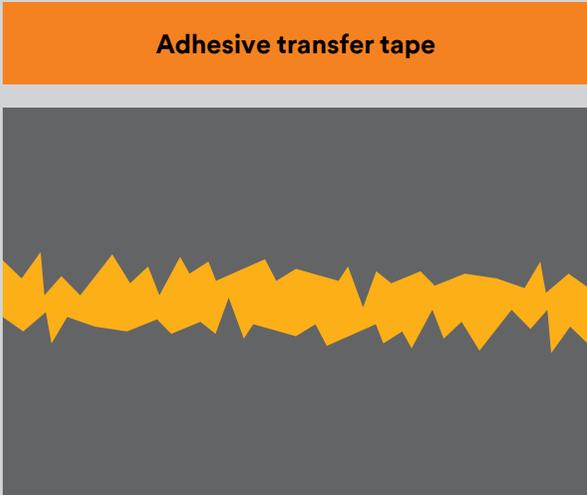
| Property | Adhesive transfer tape (without carrier) | Double coated tape (with carrier) |
|------------------------------------|------------------------------------------|-----------------------------------|
| Flexibility | + | - |
| Compensation for surface roughness | + | - |
| Temperature resistance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

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

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.



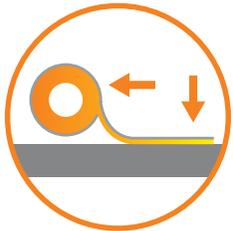
1. Clean/dry:

- ▶ 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



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



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



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





For mounting promotional materials

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



Application of
camera lenses

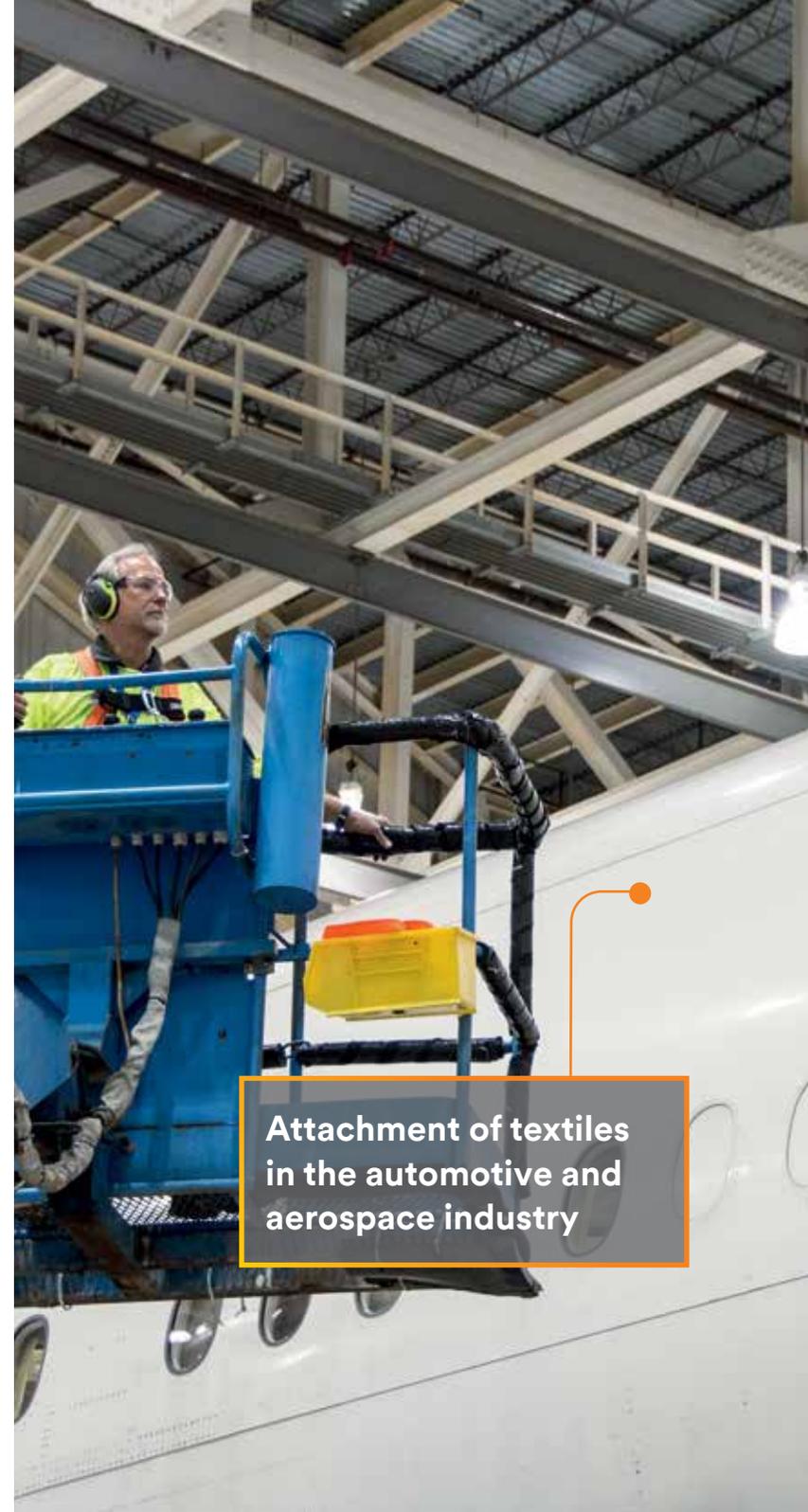
3M™ Acrylic Adhesive 420 – for applications exposed to shock loads

- ▶ 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



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

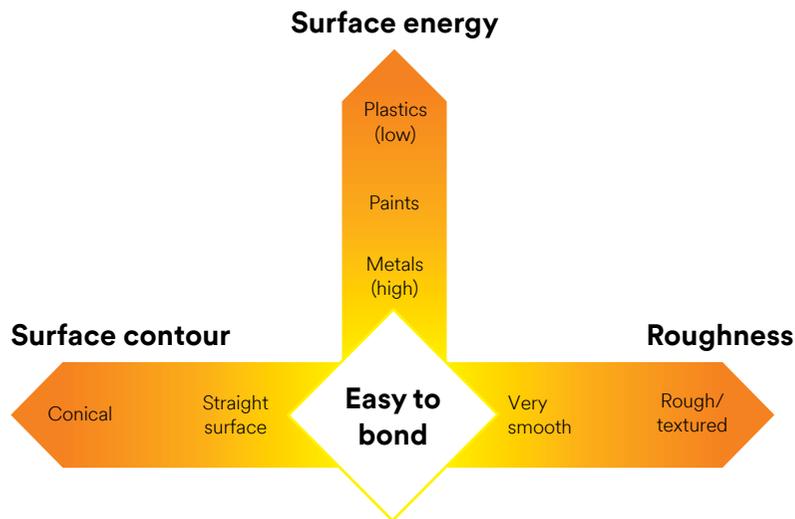


Fig. 5: Adhesion to high surface energy substrates

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

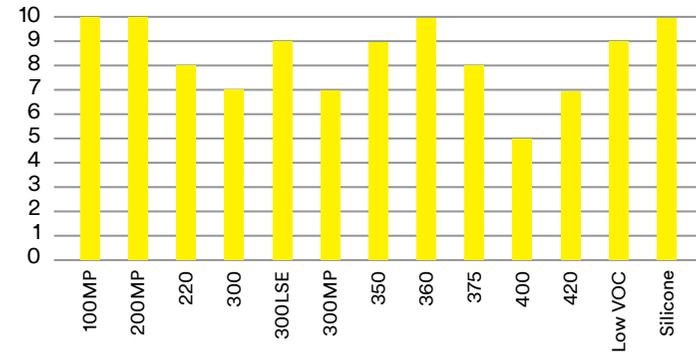


Fig. 6: Adhesion to low surface energy plastics

e.g. PE, PP

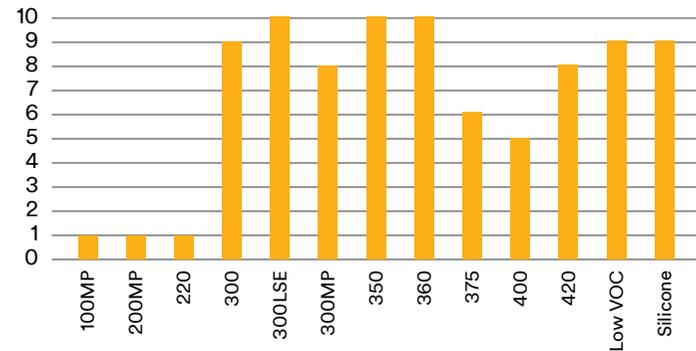
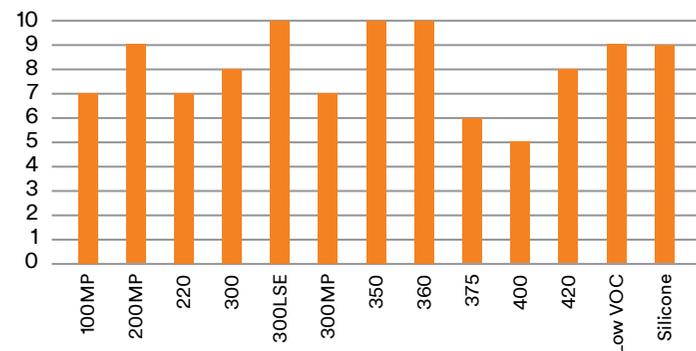


Fig. 7: Adhesion to high surface energy plastics

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

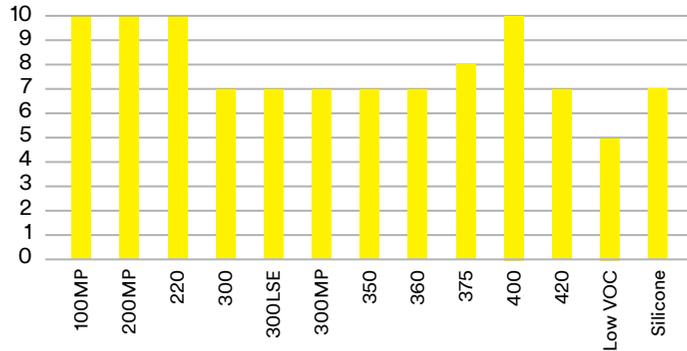


Fig. 9: Solvent resistance

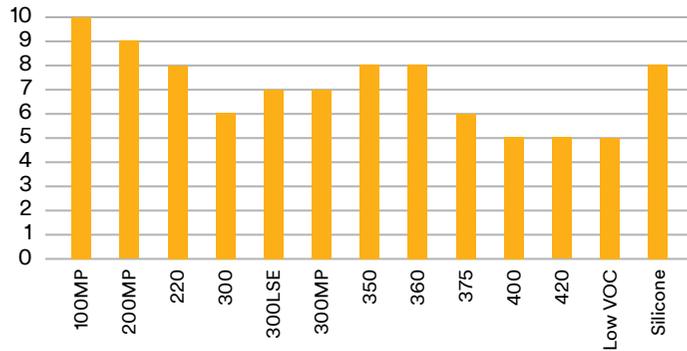
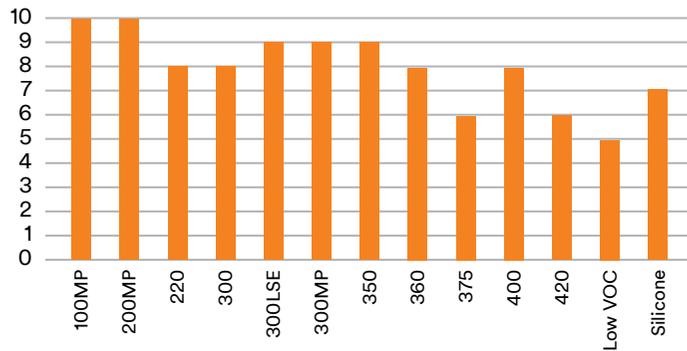
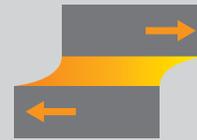


Fig. 10: Moisture resistance

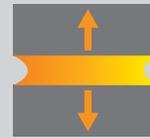


4 types of stress on bonded joints



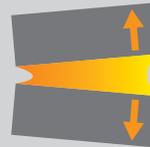
Shear forces

- ▶ 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 9775WL 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

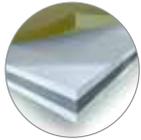
Quick selection guide for industrial applications

Standard: metals and high surface energy plastics

Standard: low surface energy substrates and powder coatings

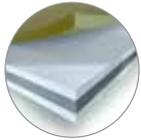
Universal, economical

High temperatures, high surface energy substrates



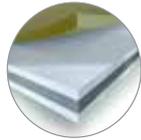
200MP
Double Coated Tape
(liner on one side)

- ▶ 92015, 150 µm



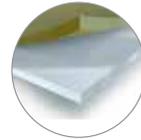
300LSE
Double Coated Tape
(liner on one side)

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



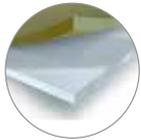
Acrylic and 375
Double Coated Tape
(liner on one side)

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



100MP
Adhesive Transfer Tape
(liner on one side)

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



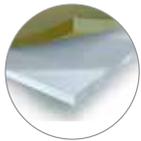
200MP
Adhesive Transfer Tape
(liner on one side)

- ▶ 467MP, 58 µm
- ▶ 468MP, 132 µm



300LSE
Adhesive Transfer Tape
(liner on one side)

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



220
Adhesive Transfer Tape
(liner on one side)

- ▶ 9502, 60 µm
- ▶ 9505, 120 µm

High temperatures,
low surface energy
substrates

Removable

Strong initial adhesion,
bonding of PP and PE

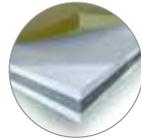
Textiles, leather, foam



350

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

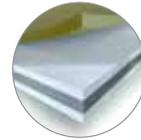
- ▶ 9482PC, 50 µm
- ▶ 9485PC, 130 µm



1000/1050

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

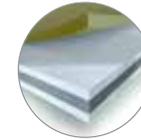
- ▶ 9415PC, 50 µm
- ▶ 9416, 50 µm
- ▶ 9425HT, 137 µm



360

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

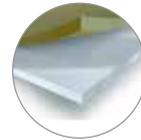
- ▶ 9628FL, 50 µm
- ▶ 9629PC, 100 µm



300/300MP

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

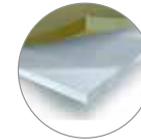
- ▶ 99786, 140 µm



360

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

- ▶ 9626, 58 µm
- ▶ 9627, 132 µm



300/300MP

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

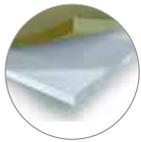
- ▶ 927, 50 µm
- ▶ 950, 130 µm
- ▶ 977XWL, 76-125 µm

Quick selection guide for graphic applications

Standard: metals and high surface energy plastics

Standard: low surface energy substrates and powder coatings

Very high temperatures, low surface energy substrates



200MP

Adhesive Transfer Tape (liner on one side)

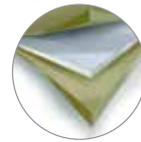
- ▶ 467MP, 58 µm
- ▶ 468MP, 132 µm



200MP

Spacer (adhesive on one side)

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



300LSE

Adhesive Transfer Tape (liner on both sides)

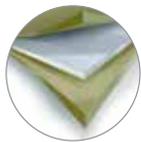
- ▶ 8132LE, 58 µm
- ▶ 8153LE, 80 µm



350

Adhesive Transfer Tape (liner on one side)

- ▶ 9482PC, 50 µm
- ▶ 9485PC, 135 µm



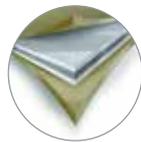
200MP

Adhesive Transfer Tape (liner on both sides)

- ▶ 7952MP, 58 µm
- ▶ 7955MP, 132 µm

Thicker liner

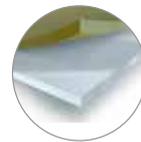
- ▶ 7962MP, 58 µm
- ▶ 7965MP, 132 µm



200MP

Spacer (liner on both sides)

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



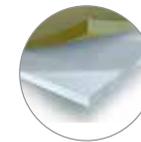
300LSE

Adhesive Transfer Tape (liner on one side)

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

Thicker liner

- ▶ 9671LE, 58 µm
- ▶ 9671LE, 132 µm



Silicone

Adhesive Transfer Tape (liner on one side)

- ▶ 91022, 50 µm
- ▶ 96042, 130 µm

**Very high temperatures
and chemical resistance**

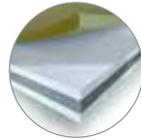


100MP

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

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

Removable

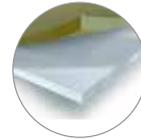


400/1000

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

- ▶ 9415PC, 50 µm

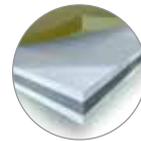
**Strong initial adhesion,
bonding of PP and
PE/low odour**



360

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

- ▶ 9626, 58 µm
- ▶ 9627, 132 µm



Low VOC

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

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

**Thread reinforcement
low energy/high energy**



300

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

- ▶ 9471, 58 µm
- ▶ 9472, 132 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

| Product number | 3M™ Acrylic Adhesive 100MP | | | |
|-----------------------------------------------------------------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------------|
| | 9460PC | 9469PC | 9473PC | F9460PC <small>TOP SELLER</small> |
| Product description | 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/m ²) | 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 | +++ | +++ | +++ | +++ |

**100MP
VHB™**

| 3M™ Acrylic Adhesive 100MP | |
|------------------------------------------|------------------------------------------|
| F9469PC <small>TOP SELLER</small> | F9473PC <small>TOP SELLER</small> |
| VHB™ Adhesive Transfer Tape | VHB™ Adhesive Transfer Tape |
| Acrylic | Acrylic |
| Transparent | Transparent |
| 0.132 | 0.269 |
| - | - |
| - | - |
| - | - |
| Polycoated kraft | Polycoated kraft |
| 0.107 (94) | 0.107 (94) |
| Green "3M VHB™" | Green "3M VHB™" |
| 260°C | 260°C |
| 150°C | 150°C |
| -40°C | -40°C |
| UL 746C | UL 746C |
| 10 | 10 |
| 7 | 7 |
| 1 | 1 |
| +++ | +++ |
| +++ | +++ |
| +++ | +++ |
| +++ | +++ |
| +++ | +++ |
| +++ | +++ |

| 3M™ 59xx series | | | |
|------------------------|--------------------|--------------------|--------------------|
| 5906 | 5907 | 5908 | 5909 |
| VHB™ Adhesive Tape | VHB™ Adhesive Tape | VHB™ Adhesive Tape | VHB™ Adhesive Tape |
| Acrylic | Acrylic | Acrylic | Acrylic |
| Black | Black | Black | Black |
| 0.150 | 0.200 | 0.250 | 0.300 |
| - | - | - | - |
| - | - | - | - |
| 0.150 | 0.200 | 0.250 | 0.300 |
| PET film | PET film | PET film | PET film |
| 0.080 | 0.080 | 0.080 | 0.080 |
| - | - | - | - |
| 120°C | 120°C | 120°C | 120°C |
| 90°C | 90°C | 90°C | 90°C |
| -40°C | -40°C | -40°C | -40°C |
| - | - | - | - |
| 10 | 10 | 10 | 10 |
| 7 | 7 | 7 | 7 |
| 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

Application examples

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

200MP

3M™ Acrylic Adhesive 200MP

| Product number | 3M™ Acrylic Adhesive 200MP | | |
|-----------------------------------------------------------------------------------|---------------------------------|----------------------------------|---------------------------------|
| | 467MP <small>TOP SELLER</small> | 467MPF <small>TOP SELLER</small> | 468MP <small>TOP SELLER</small> |
| Product description | Adhesive Transfer Tape | Adhesive Transfer Tape | Adhesive Transfer Tape |
| Adhesive | Acrylic | Acrylic | Acrylic |
| Colour | Transparent | Transparent | Transparent |
| Total thickness (thickness in mm without liner) | 0.058 | 0.058 | 0.132 |
| Carrier material | - | - | - |
| Carrier thickness (mm) | - | - | - |
| Adhesive thickness per side (mm) | - | - | - |
| Liner type | Polycoated kraft | PET film | Polycoated kraft |
| Liner thickness in mm (g/m ²) | 0.107 (94) | 0.052 | 0.107 (94) |
| Liner print | Green "3M™ 200MP" | - | Green "3M 200MP" |
| 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 969, CSA-C22.2 | UL 746C, UL 969, CSA-C22.3 | UL 746C, UL 969, CSA-C22.4 |
| 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

| 468MPF | 7952MP | 7955MP <small>TOP SELLER</small> | 7962MP | 7965MP |
|----------------------------|---------------------------------------------------|---------------------------------------------------|---------------------------------------------------|---------------------------------------------------|
| Adhesive Transfer Tape | 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

| Product number | 3M™ Acrylic Adhesive 200MP | | |
|-----------------------------------------------------------------------------------|---------------------------------------------------|-------------------------------------------|-------------------------------------------|
| | 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/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) | 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) |
| 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

| Product number | 3M™ Acrylic Adhesive 200MP | | |
|-----------------------------------------------------------------------------------|--------------------------------------|--------------------------------------|--------------------------------------|
| | 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

| Product number | 3M™ Acrylic Adhesives 300 | | | |
|-----------------------------------------------------------------------------------|---------------------------|-------------------------------|---------------------------|--------------------------------|
| | 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

| Product number | 3M™ Acrylic Adhesives 300LSE | | | |
|-----------------------------------------------------------------------------------|---------------------------------------------------|---------------------------------------------------|---------------------------|----------------------------------|
| | 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

| Product number | 3M™ Acrylic Adhesives 300LSE | | | |
|-----------------------------------------------------------------------------------|-------------------------------------------|-------------------------------------------|----------------------------------------------------------------------|-------------------------------------------|
| | 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 |
| 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/m ²) | 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 | | - | - |
| +++ | | +++ | | +++ | | - | - |
| ++ | | + | | ++ | | - | - |
| ++ | | + | | + | | - | - |
| +++ | | + | | +++ | | - | - |
| +++ | | ++ | | +++ | | - | - |





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

| Product number | Rubber | Low VOC | |
|-----------------------------------------------------------------------------------|----------------------------------------|-----------------------------------------|--------------------------------------------------|
| | 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/m ²) | 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/m ²) | 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 | Polycoated kraft | Polycoated 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 | |
| ++ | ++ | + | |
| + | + | ++ | |
| + | + | +++ | |
| + | + | ++ | |
| ++ | ++ | +++ | |

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