

# 3M

## Secondary Liners

### 7526L • 7527L

Technical Data

February, 2003

#### Product Description

3M™ Secondary Liners 7526L and 7527L are available to liner screen printable adhesives after they are applied to a substrate and cured. The liners suggested are a 58# polycoated kraft paper liner and a high-density polyethylene liner respectively. These liners offer the screen-printing industry premium and compatible liners for protecting the pressure sensitive adhesive after application for downstream processing and/or stacking.

#### Construction

Product Number	Thickness (nominal)	Manufacturing Tolerance (in.)	Color	Coating	Printable
3M Liner 7526L	4.2 mils	4.2 ± .35	Kraft	Silicone – C2S	No
3M Liner 7527L	3.0 mils	3.0 ± .5	Cloudy	Silicone – C1S	No

C1S = coated one side with a premium silicone release agent – silicone normally on outside wraps of roll. Check with marking pen to be sure.

C2S = coated both sides with a silicone release agent

Gloss side = low release silicone normally on outside wraps of roll.

Matt side = medium release silicone.

Always do a quick test of liners by sticking a single coated tape to each side to determine low vs. medium release sides just in case material has been re-slit and sides have been reversed. A marking pen may also be used to determine differences in release characteristics.

#### Available Sizes

Product Number	Minimum Width	Maximum Width	Standard Length
3M Liner 7526L	3.0 inches	50 inches	360 yards
3M Liner 7527L	3.0 inches	50 inches	360 yards

Narrow rolls must be purchased in quantities totaling the maximum roll width available.

#### Performance Considerations

Lining products takes some expertise and careful consideration in how lined product as well as the finished die cut parts will be handled before the liner is actually applied to a substrate.

Users should be on the lookout for any possible signs of increased liner buildup once they convert the parts. Parts should be used in a timely manner. It is recommended to avoid having the parts subjected to elevated temperatures, which will only accelerate the increase in liner release values.

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**Application Techniques** It is necessary to provide pressure during lamination (1.5-20 pli recommended) to allow the adhesive to come into direct contact with the liner. Using a hard-edged plastic tool or roller, which is the full width of the laminated tape or part, helps to provide the necessary pressure at the point of lamination.

The ideal liner application temperature range is 60°F (21°C) to 100°F (38°C). Application is not recommended if the surface temperature is below 50°F (10°C) because the adhesive becomes too firm to adhere to readily. Once properly applied, at the recommended application temperature, low temperature holding is generally satisfactory.

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**Application Equipment** To apply secondary liners in a wide web format, lamination equipment is required to ensure acceptable quality. To learn more about working with pressure-sensitive adhesives, please refer to technical bulletin, Lamination Techniques for Converters of Laminating Adhesives (70-0704-1430-8).

For assistance in helping you with your application, contact your local 3M sales representative, or call 1-800-362-3550.

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**For Additional Information** To request additional product information or to arrange for sales assistance, call toll free 1-800-223-7427 or visit [www.3M.com/converter](http://www.3M.com/converter). Address correspondence to: 3M Industrial Adhesives and Tapes Division, Building 21-1W-10, 900 Bush Avenue, St. Paul, MN 55106. Our fax number is 651-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

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ISO 9002

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

**3M**

Industrial Business  
Converter Markets  
Industrial Adhesives and Tapes Division

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10% post-consumer

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