



# Technical Data Sheet

## 3M™ Adhesive Transfer Tape 9773WL+

### Product Description

Finite Element Analysis (FEA) data is available for this product at: [3m.com/FEA](https://www.3m.com/FEA)

3M™ Adhesive Transfer Tape 9773WL+ with 3M™ Adhesive 300MP+ is suitable for bonding to most surfaces including various fabricated foams, fabrics, and other substrates. This tape also meets the highly variable needs of most gasket fabricators.

### Product Features

- Double sided acrylic adhesive designed for use on foams, plastics, wood and fabrics
- Humidity resistance
- Performs at higher temperatures

### Technical Information Note

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

### Typical Physical Properties

Attribute Name	Test Method	Value
Adhesive Type		300MP+ Acrylic
Total Tape Thickness	ASTM D3652	0.07 mm (3 mil)
Density		0.91 g/cm <sup>3</sup>

Attribute Name	Value
Liner	96# white
Liner Thickness	0.18 mm (7.0 mil)
Liner Print	None

### Typical Performance Characteristics

#### 180° Peel Adhesion

Backing: 2 mil Aluminum Foil

Test Method: ASTM D3330

Dwell Time	Temperature	Substrate	Value
20 min	22 °C (72 °F)	Stainless Steel	6.49 N/cm (59 oz/in) <sup>1</sup>
72 h	22 °C (72 °F)	Stainless Steel	11.55 N/cm (105.00 oz/in) <sup>1</sup>
72 h	22 °C (72 °F)	ABS	8.96 N/cm (81.00 oz/in) <sup>1</sup>
72 h	22 °C (72 °F)	Polypropylene (PP)	4.82 N/cm (44 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Stainless Steel	14.82 N/cm (135 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	ABS	9.15 N/cm (83.00 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Polypropylene (PP)	5.11 N/cm (46.00 oz/in) <sup>1</sup>

<sup>1</sup> 12 in/min (300 mm/min)

## 90° Peel Adhesion

Backing: 2 mil Aluminum Foil

Test Method: ASTM D3330

Dwell Time	Temperature	Substrate	Value
20 min	22 °C (72 °F)	Stainless Steel	5.55 N/cm (50.00 oz/in) <sup>1</sup>
72 h	22 °C (72 °F)	Stainless Steel	10.95 N/cm (100.00 oz/in) <sup>1</sup>
72 h	22 °C (72 °F)	ABS	6.55 N/cm (60.00 oz/in) <sup>1</sup>
72 h	22 °C (72 °F)	Polypropylene (PP)	3.98 N/cm (36.00 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Stainless Steel	9.94 N/cm (90.00 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	ABS	4.75 N/cm (43.00 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Polypropylene (PP)	4.00 N/cm (36.00 oz/in) <sup>1</sup>

<sup>1</sup> 12 in/min (300 mm/min)

Dwell Time: 16 h

Attribute Name	Test Method	Value
Fogging (Photometric method)	SAEJ1756	95 % <sup>1</sup>

<sup>1</sup> Fogging condensate on the glass plate determined by measuring the 60o specular gloss. The 60o specular gloss for the same glass plate is used as a reference value. The higher value indicates less fogging.

## Static Shear

Substrate: Stainless Steel

Dwell Time: 72 h

Backing: 2 mil Aluminum Foil

Test Method: ASTM D3654

Temperature	Test Condition	Value
22 °C (72 °F)	1000g	10,000 min <sup>1</sup>
70 °C (158 °F)	500g	10,000 min <sup>1</sup>

<sup>1</sup> 1 in x 1 in sample area, test terminated after 10,000 minutes

## Typical Environmental Performance

Temperature: 32 °C (90 °F)

Dwell Time: 72 h

Backing: 2 mil Aluminum Foil

Test Method: ASTM D3330

Environmental Condition: 90%RH

Attribute Name	Substrate	Value
180° Peel Adhesion	Stainless Steel	14.76 N/cm (134.00 oz/in) <sup>1</sup>
180° Peel Adhesion	ABS	9.02 N/cm (82.00 oz/in) <sup>1</sup>
180° Peel Adhesion	Polypropylene (PP)	5.47 N/cm (50.00 oz/in) <sup>1</sup>
90° Peel Adhesion	Stainless Steel	10.74 N/cm (98.00 oz/in) <sup>1</sup>
90° Peel Adhesion	ABS	5.64 N/cm (51.00 oz/in) <sup>1</sup>
90° Peel Adhesion	Polypropylene (PP)	3.84 N/cm (35.00 oz/in) <sup>1</sup>

<sup>1</sup> 12 in/min (300 mm/min)

## Electrical and Thermal Properties

Attribute Name	Test Method	Value
Glass Transition Temperature (Tg)	ASTM E1356	-60 °C <sup>1</sup>

<sup>1</sup> Glass Transition Temperature (Tg) determined using DSC Analyzer with a heating rate of 4°C per minute. First heat values given.

## Storage and Shelf Life

Store under normal conditions of 16° to 27°C (60° to 80°F) and 40 to 60% relative humidity in the original packaging, out of direct sunlight. For best performance, use this product within 24 months from date of manufacture.

## Automotive Disclaimer

### Select Automotive Applications:

This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

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## ISO Statement

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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