



# Technical Data Sheet

## 3M™ Adhesive Transfer Tape 9774WL+



[Product Details](#)

### Product Description

3M™ Adhesive Transfer Tape 9774WL+ 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	Value
Adhesive Type	300MP+ Acrylic
Density	0.91 g/cm <sup>3</sup>
Total Tape Thickness	0.10 mm (4 mil)

Attribute Name	Value
Liner	96# PCK
Liner Thickness	0.18 mm (7 mil)
Primary Liner Color	White
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	23 °C (73 °F)	Stainless Steel	8 N/cm (75 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	Stainless Steel	12 N/cm (110 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	ABS	9 N/cm (85 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	Polypropylene (PP)	6 N/cm (55 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Stainless Steel	5 N/cm (50 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	ABS	10 N/cm (88 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Polypropylene (PP)	5 N/cm (50 oz/in) <sup>1</sup>

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

## 90° Peel Adhesion

Backing: 2 mil Aluminum Foil

Test Method: ASTM D3330

Dwell Time	Temperature	Substrate	Value
72 h	23 °C (73 °F)	Stainless Steel	9 N/cm (85 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Stainless Steel	15 N/cm (140 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	ABS	8 N/cm (70 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	Polypropylene (PP)	5 N/cm (40 oz/in) <sup>1</sup>
20 min	23 °C (73 °F)	Stainless Steel	7.5 N/cm (65 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	ABS	5 N/cm (50 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Polypropylene (PP)	4 N/cm (35 oz/in) <sup>1</sup>

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

## Static Shear

Substrate: Stainless Steel

Dwell Time: 72 h

Backing: 2 mil Aluminum Foil

Test Method: ASTM D3654

Temperature	Test Condition	Value
23 °C (73 °F)	1000 g	10,000 min <sup>1</sup>
70 °C (158 °F)	500 g	10,000 min <sup>1</sup>
93 °C (200 °F)	1000 g	10,000 min <sup>1</sup>

<sup>1</sup> 25 x 25 mm (1 in x 1 in) sample area, test terminated after 10,000 minutes

## Shear Adhesion Failure Test - SAFT

Substrate: Stainless Steel

Dwell Time: 72 h

Backing: 2 mil Aluminum Foil

Test Method: PSTC 17

Test Condition	Value
1000 g	265 °F (200 min) <sup>1</sup>
500 g	250 min (310 °F) <sup>1</sup>

<sup>1</sup> 25 x 25 mm (1 in x 1 in) Area Contact

Attribute Name	Value
Short Term Temperature Resistance	121 °C (250 °F) <sup>1</sup>
Long Term Temperature Resistance	107 °C (225 °F) <sup>2</sup>

<sup>1</sup> Maximum temperature where tape supports 200g load per 6.5cm<sup>2</sup> (1 in<sup>2</sup>) in static shear for 60 minutes.

<sup>2</sup> Maximum temperature where tape supports 200g load per 6.5cm<sup>2</sup> (1 in<sup>2</sup>) in static shear for 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	15.0 N/cm (140.0 ) <sup>1</sup>
180° Peel Adhesion	ABS	9.3 N/cm (85.0 ) <sup>1</sup>
180° Peel Adhesion	Polypropylene (PP)	6.2 N/cm (57.0 ) <sup>1</sup>
90° Peel Adhesion	Stainless Steel	14 N/cm (120 oz/in) <sup>1</sup>
90° Peel Adhesion	ABS	6 N/cm (60 oz/in) <sup>1</sup>
90° Peel Adhesion	Polypropylene (PP)	5 N/cm (43 oz/in) <sup>1</sup>

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

Dwell Time: 1 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.

## 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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