



Technical Data Sheet

3M™ High Performance Acrylic Adhesive
468MCF



[Product Details](#)

Product Description

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

3M™ 468MCF features a 200MP laminating adhesive on a 3M proprietary liner, which creates micro-channels in the adhesive surface (back side surface of adhesive). The crosshatched pattern creates a continuous and permanent network of micro-channels in the back side of the adhesive, allowing air to escape from between the adhesive surface and the substrate. This helps to facilitate bubble free laminations of graphics to substrates.

3M™ Adhesive 200MP is a popular choice for graphic attachment and nameplate applications because it has excellent quality, consistency and durability. In addition, as a result of 3M's innovative, proprietary process, 3M adhesive 200MP also offers the following excellent performance characteristics.

Product Features

- Clarity (virtually free of vapor inclusions that are commonly found in adhesives produced by the traditional solvent coating technique).
- Excellent high temperature performance as well as excellent shear strength (that minimizes edge lifting and slippage of parts).
- Excellent resistance to harsh environments; this adhesive can withstand splashes of organic solvents, weak acids and bases and salt water, cleaning solutions, germicides, disinfectants, oils, etc. In addition, it performs well after exposure to humidity and hot/cold cycles.
- Provides some initial repositionability when bonding to plastic parts (not metal) which allows graphic parts to be lifted and repositioned if initial alignment is incorrect.
- Adhesive family is provided with a polyester and PCK liner configurations to help ensure excellent process flexibility.

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		200MP
Total Tape Thickness	ASTM D3652	0.127 mm (5 mil)
Liner		PET
Liner Thickness		0.102 mm (4 mil)

Typical Performance Characteristics

90° Peel Adhesion

Substrate: Stainless Steel
Temperature: 23 °C (73 °F)
Backing: 2 mil Aluminum Foil
Test Method: ASTM D3330

Dwell Time	Value
15 min	7.6 N/cm (69 oz/in) ¹
72 h	16.1 N/cm (147 oz/in) ¹

¹ 304 mm/min (12 in/min)

Static Shear

Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil
Test Method: ASTM D3654

Temperature	Test Condition	Value
23 °C (73 °F)	2000 g	10,000+ min ¹
93 °C (200 °F)	1000 g	10,000+ min ¹
177 °C (350 °F)	500 g	10,000+ min ¹

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

Attribute Name	Value
Short Term Temperature Resistance	204 °C (400 °F) ¹
Long Term Temperature Resistance	149 °C (300 °F) ²

¹ Short Term (minutes, hour)

² Long Term (day, weeks)

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.

Information

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price. Warranty claims must be made within one (1) year from the date of 3M's shipment.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

Disclaimer: 3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and limitations, and the user must take any action required under any recall, field action or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, or death. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit www.3M.com.

ISO Statement

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

3M™ Industrial Adhesives and Tapes Division
3M Center, St. Paul, MN 55144-1000
3M.com/iatd

3M is a trademark of 3M Company
© 3M 2014 (3/14)