



Technical Data Sheet

3M™ Polyester Tape 8402



[Product Details](#)



[Regulatory Info/SDS](#)

Product Description

3M™ Polyester Tape 8402 is a film tape with a silicone adhesive for holding down bagging materials and parts during composite and metal bonding operations. Ideal for splicing applications on surfaces that are difficult to adhere too, such as silicone coated papers and films.

Product Features

- Works in demanding conditions and retains flexibility in autoclave conditions in temperatures ranging from -60°F (-50°C) to 350°F (176°C)
- Higher heat resistance as compared with acrylics
- Silicone adhesive provides clean removal from a variety of surfaces
- Translucent green backing is easily identifiable for splicing applications
- Chemical resistant adhesive and backing provides durability in difficult environments

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
Color		Translucent green
Adhesive Type		Silicone
Backing		Polyester
Backing Thickness	ASTM D3652	0.02 mm (0.92 mil)
Total Tape Thickness	ASTM D3652	0.05 mm (1.9 mil)

Typical Performance Characteristics

Attribute Name	Test Method	Temperature	Value
180° Peel Adhesion	ASTM D3330	23 °C (73 °F)	2.5 N/cm (23 oz/in) ¹
Elongation at Break	ASTM D3759		125 %
Tensile Strength	ASTM D3759		43.8 N/cm (25 lb/in)

¹ 304 mm/min (12 in/min)

Attribute Name	Value
Temperature Use Range note	Removes cleanly and remains flexible after 3 hours, 350°F (177°C), in autoclave.
Long Term Temperature Resistance	177 °C (350 °F) ¹
Minimum Long Term Temperature Resistance	-60 °C (-50 °F) ¹

¹ Long Term (day, weeks)

Handling/Application Information

Application Examples

- Flash breaker in metal bonding processes where the excess epoxy (flash) flows on the tape.
- Holding of bagging materials and parts during metal or composite bonding operations.
- Masking metal surfaces in acid or caustic chemical milling, etching, or anodization baths.
- Protective tape reduces scratches during handling and shipping.
- Paint mask for areas subject to higher temperature bake cycles.
- Splicing applications on surfaces that are difficult to adhere too, such as silicone coated papers and films.
- Splicing of films subject to high temperatures or chemicals.

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 12 months from date of manufacture.

Available Sizes

Attribute Name	Value
Standard Roll Length	66 m (72 yd)

Information

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ISO Statement

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

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3M Center, St. Paul, MN 55144-1000
3M.com/iat

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