



Technical Data Sheet

3M™ Adhesive Transfer Tape 9375W

Product Description

3M™ Adhesive Transfer Tapes are acrylic based and specially formulated to provide a permanent bond between substrates in environments requiring regulatory compliance with flame retardant standards such as Federal Aviation Regulation 25.853.

Product Features

Flame Retardant

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		Off White (opaque)
Adhesive Type		Tackified Acrylic, 300FR Series
Areal Density		188 g/m ²
Net Weight		83 lb/Ream
Total Tape Thickness	ASTM D3652	0.127 mm (0.005 in) (5 mil)
Thickness Tolerance		±15 %
Liner		PCK
Liner Thickness		0.17 mm (6.5 mil)
Primary Liner Color		Tan, unprinted

Typical Performance Characteristics

Substrate: Stainless Steel
Temperature: 23 °C (73 °F)
Dwell Time: 72 h

Attribute Name	Test Method	Value
180° Peel Adhesion	ASTM D3330	14 N/cm (126 oz/in) ¹

¹ 304 mm/min (12 in/min)

90° Peel Adhesion

Dwell Time: 72 h
Backing: 2 mil PET
Test Method: ASTM D3330

Temperature	Substrate	Value
23 °C (73 °F)	ABS	9.4 N/cm (86 oz/in) ¹
23 °C (73 °F)	High Density Polyethylene (HDPE)	7.3 N/cm (67 oz/in) ¹
23 °C (73 °F)	Polycarbonate (PC)	9.5 N/cm (87 oz/in) ¹
23 °C (73 °F)	Polypropylene (PP)	6 N/cm (55 oz/in) ¹
23 °C (73 °F)	Stainless Steel	11.7 N/cm (107 oz/in) ¹

Temperature	Substrate	Value
70 °C (158 °F)	Stainless Steel	17.5 N/cm (160 oz/in) ¹

¹ 304 mm/min (12 in/min)

Static Shear

Test Method: ASTM D3654

Temperature	Test Condition	Value
23 °C (73 °F)	1000 g	>10,000 min ¹
70 °C (158 °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	121 °C (250 °F) ¹
Long Term Temperature Resistance	82 °C (180 °F) ²

¹ Short Term (minutes, hour)

² Long Term (day, weeks)

Typical Environmental Performance

Attribute Name	Value
Solvent Resistance	Very Good
UV Resistance	Very Good

Handling/Application Information

Application Examples

This family of products has been formulated for applications requiring flame retardancy and high bond strength to a wide variety of substrates.

These attributes and choice of three product thicknesses make the products ideally suited to applications in aerospace, maritime, electronic, automotive and building construction applications on both smooth and textured substrates.

Application Techniques

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure helps develop better adhesive contact and improve bond strength. 15 psi momentary pressure is typical.

Ideal tape application temperature range is 70°F to 100°F (21°C to 37°C). Initial tape application to surface at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once applied, low temperature holding is generally satisfactory.

Surfaces should be clean and dry prior to bonding. We recommend a final surface cleaning with a mixture of 50% isopropyl alcohol* and water.

Two liner options facilitate wide array of application techniques. Densified kraft liner ideal for roll to roll lamination and subsequent rotary die cutting. Heavy caliper, layflat, polycoated kraft liner, minimizes surface asperities, minimizes distortion of pre-laminated substrates in variable humidity conditions and provide convenient backing for kiss cutting operations.

*Carefully read and follow the manufacturer's precautions and directions for use when using cleaning solvents.

Application Equipment

To apply adhesives 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 additional dispenser information, contact your local 3M sales representative, or the toll free 3M sales assistance number at 1-800-362-3550.

Certifications/Standards

Federal Aviation Regulations, FAR 25.853

Yes

Underwriter Laboratories 94, UL-94 (V-2)

Yes

Industry Specifications

UL 94 (V-2)
FAR 25.853

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 18 months from date of manufacture.

Available Sizes

Attribute Name	Value
Core Size (ID)	76.2 mm (3 in)
Maximum Available Width	60 in
Normal Slitting Tolerance	±0.8 mm (±1/32 in)
Precision Slitting Tolerance	±0.1 mm (±0.004 in) ¹
Standard Roll Length	180 m

¹ Precision slitting is available on select products with minimum order of full web increments.

Available Sizes - Detailed

Minimum Slit Width:		1" up to 3"	1/2" up to 3"	2" up to 3"
	minimum length	60 yards	60 yards	60 yards
	maximum length	180 yards	180 yards	180 yards
3" to 30"	minimum length	60 yards	60 yards	60 yards
	maximum length	720 yards	720 yards	720 yards
31" to 48"	minimum length	—	—	60 yards
	maximum length	—	—	500 yards
31" to 60"	minimum length	60 yards	60 yards	—
	maximum length	500 yards	500 yards	—

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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