Science. Applied to Life.™

English-EU

Last Revision Date: September, 2024

Supersedes: June, 2024

Technical Data Sheet

3M™ Double Coated Tape 415

Product Description

3M™ Double Coated Tape 415 utilizes an acrylic pressure sensitive adhesive system that offers a balance of initial adhesion and good holding power.

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 Condition	Value
Adhesive Type		400 Acrylic
Adhesive Carrier		Clear Polyester
Total Tape Thickness		0.1 mm
Adhesive Thickness	Faceside	0.038 mm [1]
Carrier Thickness		0.025 mm
Adhesive Thickness	Backside	0.038 mm [2]
Liner		60# DK, Tan
Liner Thickness		0.1 mm
Primary Liner Color		Tan

[1] Faceside adhesive is on the interior of the roll, exposed when unwound.

[2] Backside adhesive is on the exterior of the roll, exposed when liner is removed.

Typical Performance Characteristics

Attribute Name	Test Method	Temperature	Value
180° Peel Adhesion	ASTM D3330	22 °C	2.7 N/cm [1]
Short Term Temperature Resistance			82 °C [2]
Long Term Temperature Resistance			65 °C [3]

[1] 12 in/min (300 mm/min)

[2] Short Term (minutes, hour)

[3] Long Term (day, weeks)

Typical Environmental Performance

Attribute Name	Value
Solvent Resistance	Good
UV Resistance	Excellent

Handling/Application Information

Application Examples

• 3M™ Double Coated Tape 415 can be used for high-speed flying splices and zero speed splices on most grades of paper such as newsprint, clay coated, corrugated stocks.

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.
• To obtain optimum adhesion, the bonding surfaces must be clean, dry, and well unified.
• Ideal tape application temperature range is 70°F to 100°F (21°C to 38°C). Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

Industry Specifications

FDA Statement

This product might be suitable for use in indirect food contact applications. Please see the applicable Regulatory Data Sheet for more information relating to FDA compliance.

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.

Available Sizes

Attribute Name	Width	Value
Core Size (ID)		76.2 mm
Maximum Available Width		1219 mm
Maximum Length	1/4 in to 3/8 in widths	165 m
Maximum Length	3/8 in to 1/2 in width	165 m
Maximum Length	2 in and greater	329 m
Maximum Length	1/2 to 2 in widths	329 m
Minimum Available Width		6.35 mm
Normal Slitting Tolerance		± 0.8 mm
Note		Subject to Minimum Order Requirements
Standard Roll Length		32.9 m

Information

Precautionary Information: Refer to product label and Material Safety Data Sheet for health and safety information before using the product. For information, please contact your local 3M Office. You can click or scan QR code to see contact detail or visit www.3M.com Important Information: All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law. Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.

ISO Statement

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

For Additional Information

To request additional product information or to arrange for sales assistance, please contact your local 3M office.

3M™ Centre
Cain Rd, Binfield, Bracknell RG12 8HT, United Kingdom
3m.co.uk/iatd