



# Technical Data Sheet

## 3M™ Loop Fastener SJ3527N

### Product Description

3M™ Hook and Loop Fasteners offer advanced closure alternatives to zippers, screws, snaps, hooks and more. They offer greater design flexibility, faster product assembly, smoother and cleaner exterior surfaces and improved product performance in many applications. 3M hook and loop fasteners consist of hooks and loops which engage to form a quick fastening attachment. Simply pull the strips apart by hand to disengage.

### Product Features

The woven nylon hook has flexible, self-supporting inverted j-hooks protruding up from the backing with approximately 300 hooks per square inch (46 hooks/square cm). The woven nylon loop has thousands of soft, pliable napped loops protruding above the backing, providing for thousands of openings and closings (cycles). Both the hook and loop are preshrunk to insure maximum dimensional stability and flatness. Standard colors available are black, white and beige, with several custom colors available with extended delivery times and additional costs.

SJ3527N loop is coated on the backside with a high performance rubber based pressure sensitive adhesive which allow for easy and convenient attachment to a variety of substrates, including low surface energy plastics.

Commonly paired with 3M™ Hook Fastener SJ3526N, this loop fastener can also engage with other 3M™ Hook Fasteners.

### 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
Color		Black, White
Adhesive Type		Rubber
Weight		0.063 g/cm <sup>2</sup>
Material		Loop- Woven Nylon
Backing		High Performance rubber based PSA
Thickness	Maximum unmated without liner	2.3 mm <sup>1</sup>
Engaged Thickness		3.6 mm <sup>1</sup>
Liner		Polyethylene with red printing
Primary Liner Color		White
Liner Thickness		0.08 mm

<sup>1</sup> Thickness depends on the amount of compression load on the pieces.

### Typical Performance Characteristics

Substrate: Nylon Hook to Nylon Loop

Attribute Name	Temperature	Value
90° Peel Adhesion	23 °C	3.9 g/cm width <sup>1</sup>
Overlap Shear Strength		15.2 N/cm <sup>2</sup> <sup>2</sup>
T-Peel Adhesion		3.5 g/cm width <sup>3</sup>
Dynamic Tensile		7.6 N/cm <sup>2</sup> <sup>2</sup>
Cleavage Strength		13.1 g/cm width

<sup>1</sup> 304 mm/min (12 in/min). The 90° peel has one of the mated fasteners attached to a non-anodized aluminum panel, while the other

mated fastener is not attached to an adherend and is disengaged at 90° angle during the peel.

<sup>2</sup> 304 mm/min (12 in/min)

<sup>3</sup> 304 mm/min (12 in/min)

The "T" peel test only measures the closure performance per ASTM D5170 and was not adhered to aluminum panels.

Attribute Name	Substrate	Value
Long Term Temperature Resistance		49 °C <sup>1</sup>
Cycle Life	Nylon Hook to Nylon Loop	5,000 <sup>2</sup>

<sup>1</sup> Long Term (day, weeks)

<sup>2</sup> Number of closures before losing 50% of original peel strength

## **Handling/Application Information**

### **Directions for Use**

#### Attachment Techniques

The following information is intended to assist the designer considering the use of 3M hook and loop fasteners. System product performance depends upon a number of factors, including the fastener (material, adhesive and area), application method, surface characteristics (material, texture and cleanliness), environmental conditions (moisture, ultraviolet and temperature exposure) and the time it is expected to support a given load. Because many of these factors are uniquely within the user's knowledge and control, it is required that the user evaluate 3M products to determine whether they are fit for a particular purpose and are suitable for the user's substrates, method of application and desired end use.

Rounding the corners, slightly recessing the product into the substrate, or providing raised edges around the Reclosable fastener can reduce the possibility of edge lifting and improve the overall appearance of the fastener on the finished product. Mechanically securing the corners of the fastener with rivets, staples, screws, etc. may also reduce the possibility of edge lifting, but may reduce the closure performance.

The two most common techniques for attaching these 3M hook and loop fasteners to various surfaces are summarized below.

**Pressure Sensitive Adhesive Attachment:** The use of pressure sensitive adhesives eliminates or reduces the need for sewing, solvent activation, dielectric or ultrasonic bonding or bulk adhesive bonding. This can result in simplicity, improved safety and lower installation costs. Pressure sensitive adhesive products can be applied manually or automatically using a variety of equipment choices. Contact your 3M Sales Representative to discuss automated equipment options.

**Surface Preparation:** Highly textured surfaces may reduce the ultimate adhesion levels and care should be given to minimize the surface texture or roughness. Adhesive backed fasteners should be applied to surfaces that are clean, dry and free of oil, grease, dust, mold release agents or surface contaminants that could reduce the adhesion. It is recommended to remove any surface contaminants that may reduce adhesion by using a method suited for the type and quantity of surface contaminants present. Isopropyl alcohol is a good general use solvent for cleaning contaminants from surfaces for example.

In exceptional cases, especially when removing silicone mold release agents or on rough, porous surfaces, it may be necessary to lightly abrade the surface, use an adhesion promoter, or surface sealer to optimize the adhesive bond to the substrate. The selection of abrasion, priming or sealing methods will depend upon the substrates and the environmental conditions the product will be exposed to during use.

**Attachment Procedure:** To obtain optimum bond to any surface, both the fasteners and the target surfaces should have equilibrated for a minimum of one hour at temperatures between 68°F (20°C) to 100°F (38°C) before application. The liner protecting the adhesive is removed and preferably without touching the adhesive, the fastener is applied to the substrate. Exposure of the adhesive to ambient conditions without the protective liner, before applying to the surface, should be minimized as initial adhesive tack may decrease. Flexible materials should be lying on a hard flat surface so as to permit uniform adhesive contact with the surface. Use of a rubber hand roller, press platen or similar device is recommended to ensure full adhesive contact or wet- out with the substrate surface. Approximately 4.5 pounds of force per square inch, (310 grams per square centimeter) is recommended to increase adhesive contact, improving bond strength. For all adhesive applications, it is important to ensure that the edges are rolled down to reduce the chance of edge lifting.

#### Plain backed

The plain backed 3M hook and loop fasteners are most commonly sewn into their applications. Liquid or hot melt adhesives and staples are other forms of attachment that can be utilized.

**Sewing:** Although the selvedge edge was initially developed for stitching on, customers often find that they get better anchorage when stitching through the 3M hook and loop portions of the fastener – this may be application dependent. The type of thread and stitch type is also best determined based on individual application, however, the fastener should be stitched on all edges for the best seam strength. Typically, special machine adjustments are not necessary when using our 3M hook and loop fasteners

## **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.

## **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**

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](http://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: 2000 and ISO/TS 16949: 2002 standards.

3M™ Centre  
Cain Rd, Binfield, Bracknell RG12 8HT, United Kingdom  
[3m.co.uk/iatd](http://3m.co.uk/iatd)

3M is a trademark of the 3M Company.  
©3M 2024 (9/24)