Product Data Sheet

Product Description

8415 is a member of a series of high-quality, linered and self-wound laminating films which protect and enhance the appearance of printed labels. The variety of films include transparent acetate and polyester. These films combined with specific adhesives are designed to give the ultimate environmental protection and adhesion to a wide variety of paper, plastic and metal surfaces. Other members in this series are 8041 and 8042.

Physical Properties

| Tape                  | 1.0 thou (25.4 micron) Transparent Polyester Linerless Film |
| Adhesive              | 0.6 thou (15.2 micron) #400 High Tack Adhesive             |
| Shelf Life            | 24 months from date of manufacture by 3M if stored at room temperature condition in cool, dry and sun protected room. |

Features:

- Excellent die cuttability.
- High bond strength to resist edge lifting.
- Adhesive that resists a variety of acids, alkalis, petroleum solvents and moisture.
- Matte transparent films for a non-glare appearance.
- Brushed transparent films for a brushed metal appearance.
- Transparent polypropylene film that resists the corrosive effects of acid.
- Combinations of the clear acetate and polyester backings with the #400 Adhesive System offers an ultra-clear laminate that resist U.V. exposure for extended periods of time.

Applications

- Add a different thickness of adhesive to one side of a membrane switch to build a membrane switch spacer.
- Designed for use as a substrate for membrane switch circuitry.
- Hold metal domes in place.
- Protect conductive leads.
Properties and Performance
Not for specification purposes

| Temperature Range          | Polyester Film: -73°C (-100°F) to 149°C (300°F)  
|                          | Adhesive: -51°C (-60°F) to 121°C (250°F)    |
| Edge Lifting or Flagging Resistance | Excellent                                              |
| Humidity Resistance        | No effect on applied labels when exposed to 100% R.H., 100°F for 200 hours. |
| Chemical Resistance        | Excellent resistance to acids, alkalis and salts.      |
| Solvent Resistance         | Resists most common oils, aliphatic solvents such as heptane, kerosene and alcohols when applied to impervious substrates. |
| U.V. Resistance            | Good, depending on severity of exposure.                 |

180° Peel Adhesion
Stainless Steel N/10mm
( ASTM D-3330)

<table>
<thead>
<tr>
<th></th>
<th>Initial Dwell</th>
<th>72 hours room temp.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.95 N/10mm</td>
<td>3.6 N/10mm</td>
<td></td>
</tr>
</tbody>
</table>

Processing
Recommended for overlaminating, not die cuttable, except when overlaminated to appropriate base materials.

3M is a trademark of the 3M Company.

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.

3M Tapes & Adhesives Group © 3M United Kingdom PLC 2000

3M United Kingdom PLC 3M House, Adelphi Centre, Market Place, Upper Georges Street, Bracknell, Berkshire, Dun Laoghaire, Co. Dublin, RG12 1JU Ireland

Product Information : Tel 0870 60 800 50 Fax 0870 60 700 99

3M Ireland 3M House, PO Box 1, Upper Georges Street, Tel (01) 280 3555 Fax (01) 280 3509

Customer Service :