

3M

Polyester Tape

8402

Technical Data

March, 2014

Product Description 3M™ Polyester Tape 8402 is a film tape with a silicone adhesive for composite bonding and splicing of many silicone coated papers and films.

Product Construction	Backing	Adhesive	Color	Standard Roll Length
	Polyester film	Silicone	Translucent green	72 yds. (66 m)

Typical Physical Properties **Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.**

		ASTM Test Method
Adhesion to Steel:	24 oz./in. width (26 N/100 mm)	D-3330
Tensile Strength at Break:	25 lbs./in. width (438 N/100 mm)	D-3759
Elongation at Break:	100%	D-3759
Backing Thickness:	0.9 mils (0.02 mm)	D-3652
Total Tape Thickness:	1.9 mils (0.05 mm)	D-3652
Temperature Use Range:	Removes cleanly and remains flexible after 3 hours, 350°F (177°C), in autoclave.	

- Features**
- Abrasion, chemical and thermal resistant.
 - Retains flexibility from -60° to 350°F (-50° to 177°C).
 - Higher heat resistance as compared with acrylics.
 - Easy and clean removability.

- Application Ideas**
- Masking edges of overlap seams in metal bonding process where the excess epoxy ("flash") flows onto the tape. Clean-up is complete when the tape is removed.
 - Protective overall mask on panels subject to mild caustic or acid bath etching and to prevent scratches during handling prior to bonding operations.
 - Holding of parts or vacuum bags during bonding operation.
 - Mask for metal in acid or caustic chemical milling baths.
 - Paint mask for areas subject to high temperature bake cycles.
 - Splicing of silicone liners and papers.
 - Splicing of films subject to high temperatures.

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Storage	Store under normal conditions of 70°F (21°C) and 50% R.H. in the original carton.
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Shelf Life	To obtain best performance, use this product within 24 months from date of manufacture.
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Product Use	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 of application.
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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.



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