



Adhesive Transfer Tapes

with Adhesive 300

927 • 950 • 950EK

Technical Data

September, 2002

Product Description 3M™ Adhesive Transfer Tapes with 3M™ Adhesive 300 offer adhesion to a wide variety of surfaces, including many plastics. This pressure-sensitive medium firm acrylic adhesive family features a very high initial adhesion and good shear holding power.

Construction	Products	Tape 927	Tape 950	Tape 950EK
Adhesive Type:		300	300	300
Adhesive Carrier:		None	None	None
Release Liner:		Tan paper	Tan paper	White extensible Kraft paper
Approximate Thickness:				
Release Liner		0.004 in. (0.10 mm)	0.004 in. (0.10 mm)	0.006 in. (0.15 mm)
Tape only		0.002 in. (0.05 mm)	0.005 in. (0.13 mm)	0.005 in. (0.13 mm)
Tape Color:		Clear	Clear	Clear

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Typical Physical Properties and Performance Characteristics

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

Products	Tape 927	Tape 950	Tape 950EK
Adhesion to Steel: (ASTM Test Methods)	60 oz./in. (66 N/100 mm)	75 oz./in. (82 N/100 mm)	75 oz./in. (82 N/100 mm)
Relative High Temperatures Operating Ranges:			
Long Term (days, weeks)	180°F (82°C)	180°F (82°C)	180°F (82°C)
Short Term (minutes, hours)	250°F (121°C)	250°F (121°C)	250°F (121°C)
Relative Solvent Resistance:	Medium	Medium	Medium
U.V. Resistance:	Not recommended for direct exposure to sunlight or other sources of ultra violet (U.V.) light.		
Shelf Life of Tape in Roll Form:	24 months from date of manufacture when stored in original cartons at 70°F (21°C) and 50% relative humidity.		

Available Sizes

Available Lengths (Subject to Minimum Order Requirements):			
Standard	60 yd. (54.9 m)	60 yd. (54.9 m)	60 yd. (54.9 m)
Maximum in:			
1/8" - 5/16" widths	60 yd. (54.9 m)	60 yd. (54.9 m)	60 yd. (54.9 m)
5/16" - 1/2" widths	180 yd. (165 m)	180 yd. (165 m)	180 yd. (165 m)
1/2" - 1" widths	180 yd. (165 m)	180 yd. (165 m)	180 yd. (165 m)
1" - maximum	360 yd. (330 m)	360 yd. (330 m)	360 yd. (330 m)
Available Widths (Subject to Minimum Order Requirements):			
Minimum	1/8 in. (12.7 mm)	1/8 in. (12.7 mm)	1/8 in. (12.7 mm)
Maximum	48.0 in (1220 mm)	48.0 in (1220 mm)	48.0 in (1220 mm)
Normal Slitting Tolerance:	± 1/32 in. (0.8 mm)		
Core Size (ID):	3.0 in. (76.2 mm)		

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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. Some typical surface cleaning solvents are isopropyl alcohol or heptane. **Note:** Be sure to follow solvent manufacturer's precautions and directions for use when using solvents.
- Ideal tape application temperature range is 70°F to 100°F (21° 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 satisfactory.

General Information

- The resistance of these tapes to ultra violet (U.V.) light is fair. Applications where the adhesive mass is directly exposed to sunlight or other sources of U.V. light through glass, clear plastic, etc. should be avoided. Edge exposure is generally satisfactory.
- 3M™ Adhesive 300 has relatively good resistance to moderate amounts of plasticizers. Applications may be subjectively evaluated by the user testing the tape in contact with the materials at conditions of 150°F (66°C) for a period of 5-7 days.
- Adhesive 300 will not bleed into most paper stocks which helps minimize possible discoloration of posters, business forms.
- 3M™ tapes 927 and 950 meet the requirements of U.S. Government Specification MIL-P-19834B, Amend 1.

Application Ideas

3M™ tapes 927, 950 and 950EK are ideal for attaching a wide variety of similar and dissimilar materials where an aggressive adhesive with high initial adhesion is desired. Some applications ideas are:

- Splicing of film, foils, fabrics.
- Laminating adhesive for foams, photos, fabrics, metal or plastic nameplates.
- General purpose holding and mounting applications.

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.

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For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-223-7427 or visit www.3M.com/converter. Address correspondence to: 3M Engineered Adhesives Division, 3M Center, Building 220-7E-01, St. Paul, MN 55144-1000. Our fax number is 651-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

Certification/Recognition

MSDS

3M has not prepared a MSDS for this product which is not subject to the MSDS requirements of the Occupational Safety and Health Administration's Hazard Communication Standard, 29 C.F.R. 1910.1200(b)(6)(v). When used under reasonable conditions or in accordance with the 3M directions for use, the product should not present a health and safety hazard. However, use or processing of the product in a manner not in accordance with the directions for use may affect its performance and present potential health and safety hazards.

TSCA

This product is defined as an article under the Toxic Substances Control Act and is therefore exempt from inventory listing requirements.

Important Notice

3M MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which 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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If the 3M product is proved to be defective, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including, but not limited to, contract, negligence, warranty, or strict liability.

ISO 9002

This Engineered Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

3M

Converter Markets
Engineered Adhesives Division

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10% post-consumer

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