



Double Coated Tapes with 200MP Adhesive

Technical Data

June, 2001

Product Description These double coated film tapes feature a thin polyester film for dimensional stability and improved handling with ease of die-cutting and laminating. The 3M™ “Hi-Performance” Acrylic Adhesive 200MP provides exceptional temperature and chemical resistance. 3M™ Tapes 9492B, 9495B, 9495BF and 9598BF have a black polyester film to provide opacity or visibility.

Constructions

Product Number	Faceside ^{1,4} Adhesive Type/Thickness	Carrier Type/Thickness	Backside ^{2,4} Adhesive Type/Thickness	Liner Color, Type, Print	Liner Caliper
9492MP	200MP/ 0.001" (0.025 mm)	Clear PET ³ 0.0005" (0.013 mm)	200MP/ 0.001" (0.025 mm)	Tan, 58#, Polycoated Kraft, “Scotch™ Laminating Adhesive”	0.004" (0.10 mm)
9492MPF	200MP/ 0.001" (0.025 mm)	Clear PET ³ 0.0005" (0.013 mm)	200MP/ 0.001" (0.025 mm)	Clear, PET, No Print	0.002" (0.051 mm)
9492B	200MP/ 0.001" (0.025 mm)	Black PET 0.0005" (0.013 mm)	200MP/ 0.001" (0.025 mm)	Tan, 58#, Polycoated Kraft, “Scotch™ Laminating Adhesive”	0.004" (0.10 mm)
9495MP	200MP/ 0.0028" (0.071 mm)	Clear PET 0.0005" (0.013 mm)	200MP/ 0.0023" (0.058 mm)	Tan, 58#, Polycoated Kraft, “Scotch™ Laminating Adhesive”	0.004" (0.10 mm)
9495MPF	200MP/ 0.0028" (0.071 mm)	Clear PET 0.0005" (0.013 mm)	200MP/ 0.0023" (0.058 mm)	Clear, PET, No Print	0.002" (0.051 mm)
9495FL	200MP/ 0.002" (0.051 mm)	Clear PET 0.001" (0.025 mm)	200MP/ 0.002" (0.051 mm)	⁵ Faceside liner – Opaque white, HDPE Backside liner – Tan, 58#, Polycoated Kraft, “Scotch™ Laminating Adhesive”	0.003" (0.076 mm)/ 0.004" (0.10 mm)
9495B	200MP/ 0.0028" (0.071 mm)	Black PET 0.0005" (0.013 mm)	200MP/ 0.0023" (0.058 mm)	Tan, 58#, Polycoated Kraft, “Scotch™ Laminating Adhesive”	0.004" (0.010 mm)
9495BF	200MP/ 0.0028" (0.071 mm)	Black PET 0.0005" (0.013 mm)	200MP/ 0.0023" (0.058 mm)	Clear, PET, No Print	0.002" (0.051 mm)
9598BF	200MP/ 0.0035" (0.089 mm)	Black PET 0.0005" (0.013 mm)	200MP/ 0.0035" (0.089 mm)	Clear, PET, No Print	0.002" (0.051 mm)

Note 1: Faceside adhesive is on the interior of the roll, exposed when unwound.

Note 2: Backside adhesive is on the exterior of the roll, exposed when liner is removed.

Note 3: PET (Polyester).

Note 4: The caliper listed is based on a calculation from manufacturing controlled adhesive coat weights using a density of 1.012 g/cc. While past data pages have listed a nominal caliper of 4.8 mils for 9495MP, 9495FL and 9495B, the coat weight has not changed.

Note 5: Backside liner is primary (stays with die cut part); Faceside is secondary (removed first).

3M™ Double Coated Tapes with 200MP Adhesive

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.			
	Product Number	9492MP, 9492MPF, 9492B	9495MP, 9495MPF, 9495B, 9495BF, 9495FL	9598BF
	Adhesion to stainless steel ASTM D3330 - 90 degree	Oz/in (N/100 mm)	Oz/in (N/100 mm)	Oz/in (N/100 mm)
	- 15 minute RT	45 (49)	70 (76)	72 (78)
	- 72 Hour RT	62 (67)	82 (89)	95 (104)
	- 72 Hour 158°F	69 (75)	92 (100)	100 (109)
	ASTM D3330 - 180 degree, 2 mil al foil			
	- 72 Hour RT		100 (109)	125 (136)
	3) Adhesion to other surfaces* ASTM D3330 – 90 degree, 2 mil al foil, 72 hours RT			
	ABS	48 (52)	62 (67)	66 (72)
	Acrylic	55 (60)	60 (66)	77 (84)
	Polycarbonate	37 (40)	60 (66)	74 (80)
	Shear Strength – ASTM D3654 modified - (.5 inch ² sample size)			
	1000 grams at 72°F	>10,000 min	>10,000 min	>10,000 min
	500 grams at 158°F	>10,000 min	>10,000 min	>10,000 min
	Relative High Temperature Operating Ranges:			
	Long Term (days, weeks)	250°F	250°F	250°F
	Short Term (minutes, hours)	300°F	300°F	300°F
	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.		
	*Not recommended for low energy plastics (polypropylene, polyethylene). For these surfaces please refer to the 3M™ Adhesive Product Families 300, 300LSE, 350 and 300MP.			
Available Sizes	Roll length, width, slitting tolerance, core size.			
	Available Lengths (Subject to Minimum order requirements)			
	Maximum Length			
	1/4" to 1"	144 yd (132 m)		
	1" to 54"	360 yd (329 m)		
	Available Widths			
	Minimum	1/4" (6.35 mm)		
	Maximum	54" (1372 mm)		
	Normal Slitting Tolerance	± 1/32" (0.8 mm)		
	Core Size	3.0" (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 improves 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: Carefully read and follow the manufacturer's precautions and directions for use when working with solvents. These cleaning recommendations may not be in compliance with the rules of certain air quality management districts in California; consult applicable rules before use. 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.																		
General Information	These tapes have a film carrier, which can add dimensional stability to foams and other substrates. The carrier also provides easier handling during slitting and die-cutting. 3M™ Tapes 9492MPF, 9495MPF, 9495BF and 9598BF all have film liners for ease in rotary die-cutting and applications who demand low particle generating parts.																		
Features	A thin polyester carrier in the products provides dimensional stability and improved handling with ease of die-cutting and lamination compared to adhesive transfer tapes. 3M™ High Performance Acrylic Adhesive 200MP provides exceptional temperature and chemical resistance and withstands tough application environments.																		
Application Ideas	• Graphic overlays • Nameplates • Appliques • Decorative Trim • Thermal and sound damping applications in the electronics and appliance industry. • Gasket and lens attachment in mobile phones and pagers.																		
Liner Configuration Guide	<table> <tr> <td>General purpose steel rule die-cutting</td><td>58# PCK</td></tr> <tr> <td>Steel rule cutting many nameplates on common sheet</td><td>86# PCK</td></tr> <tr> <td>Kiss cutting, steel rule</td><td>86# PCK</td></tr> <tr> <td>Rotary die-cutting</td><td>PET</td></tr> <tr> <td>Selective die-cutting (cut adhesive before laminate)</td><td>Double-lined</td></tr> <tr> <td>Thermoforming</td><td>HDPE (High density Polyethylene)</td></tr> <tr> <td>Part inspection</td><td>HDPE, PET</td></tr> <tr> <td>Embossed metal parts</td><td>White PP (polypropylene), HDPE</td></tr> <tr> <td>Metal parts (punch press)</td><td>PET</td></tr> </table>	General purpose steel rule die-cutting	58# PCK	Steel rule cutting many nameplates on common sheet	86# PCK	Kiss cutting, steel rule	86# PCK	Rotary die-cutting	PET	Selective die-cutting (cut adhesive before laminate)	Double-lined	Thermoforming	HDPE (High density Polyethylene)	Part inspection	HDPE, PET	Embossed metal parts	White PP (polypropylene), HDPE	Metal parts (punch press)	PET
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Adding Liners for 3M™ Adhesive 200MP Double Coated Film Tape	1. Rotary processing, tape only, on a densified (*outside of #4994) kraft liner. In this process the tape waste will stay with the 58# PCK liner, leaving adhesive die-cuts dispensable from the #4994 (densified kraft) liner. 2. Rotary processing for finished parts. It is most efficient to use the polyester lined double coats (3M tapes 9492MPF, 9495MPF, 9495BF and 9598BF). Current process limitations prevent the supply of the 3M adhesive 200MP on a DK liner.																		

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Application Equipment

1) Wide web lamination

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 #70-0704-1430-8, Lamination Techniques for Converters of Laminating Adhesives (Fax-on-demand #800-223-7427, request document #50204).

2) To apply strips of adhesive

3M Dispenser Selection (for example)

Manual Dispensers - C25, H-10, H-128, M-712, M-742, M-744, P-52, P-56

Define Length Dispensers - M-82, M-87, M-96, M-910, M-920

Semiautomatic Dispensers - S-625 w/attachment, T-646, T653

For additional dispenser selection information refer to 3M's Dispenser/Tape Compatibility Guideline.

For assistance in helping you determine the best dispenser for your application, contact your local 3M sales representative, or the toll free 3M sales assistance number at 1-800-362-3550.

Certification/ Recognition

MSDS: 3M has not prepared a MSDS for these products which are 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, these products should not present a health and safety hazard. However, use or processing of the products in a manner not in accordance with the directions for use may affect their performance and present potential health and safety hazards.

TSCA: These products are defined as articles under the Toxic Substances Control Act and therefore, are exempt from inventory listing requirements.

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550 or visit www.3M.com/bonding. 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.

Important Notice

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ISO 9002

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



Engineered Adhesives Division

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