



# Adhesive Transfer Tapes

9372W • 9372DKW • 9375W

## Technical Data

July, 2010

**Product Description** 3M™ Adhesive Transfer Tapes are acrylic based and specially formulated to provide a permanent bond between substrates in environments requiring regulatory compliance with various flame retardant standards such as Federal Aviation Regulation 25.853, UL 94 V-0/2, NFPA 1971 (2000 Ed.), FMVSS 302 and others. 2.0 and 5.0 mil adhesive thicknesses are available. 3M™ Adhesive Transfer Tapes 9372W and 9372DKW are Waste Electrical and Electronic Equipment (WEEE) and Restriction of Hazardous Substances (RoHS) compliant.

| Construction | Product                                                    | 3M™ Adhesive Transfer Tapes                                                                           |        |
|--------------|------------------------------------------------------------|-------------------------------------------------------------------------------------------------------|--------|
|              |                                                            | 9372W & DKW                                                                                           | 9375W  |
|              | Adhesive Type:                                             | Tackified Acrylic, 300FR Series                                                                       |        |
|              | Adhesive Carrier:                                          | None                                                                                                  |        |
|              | Polycoated Kraft Release Liner:<br>(3M tape 9372W & 9375W) | 83 Lb./Ream, Tan, Unprinted, Approx. 6.5 mils thick<br>Layflat and Moisture Stable Liner              |        |
|              | Densified Kraft Release Liner:<br>(3M tape 9372DKW)        | 55 Lb./Ream, White, Unprinted, Approx. 4.0 mils thick<br>"DK" Suffix, Designed for Rotary Die Cutting |        |
|              | Adhesive Thickness:(inch)                                  | 0.0020                                                                                                | 0.0050 |
|              | (micron)                                                   | 50                                                                                                    | 125    |
|              | Areal Density (gm/Sq. M.)                                  | 75                                                                                                    | 188    |
|              | Thickness Tolerance:                                       | ± 15%                                                                                                 |        |
|              | Adhesive Color:                                            | Off White (opaque)                                                                                    |        |

## 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.

| Product                                                                    | 3M™ Adhesive Transfer Tapes   |                               |
|----------------------------------------------------------------------------|-------------------------------|-------------------------------|
|                                                                            | 9372W & DKW                   | 9375W                         |
| Adhesion to Steel: (ASTM D3330)<br>(180°, 72 Hour Dwell, Room Temperature) | 115 Oz./in.<br>(128 N/100 mm) | 126 Oz./in.<br>(140 N/100 mm) |
| Temperature Performance                                                    |                               |                               |
| Operating Ranges:                                                          |                               |                               |
| Short Term: (minutes/hours)                                                | 250°F (121°C)                 |                               |
| Long Term: (weeks/months)                                                  | 180°F (82°C)                  |                               |
| Relative Solvent Resistance:                                               | Very Good                     |                               |
| U.V. Resistance:                                                           | Very Good                     |                               |

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| Available Sizes                | Product        | 3M™ Adhesive Transfer Tapes |               |             |
|--------------------------------|----------------|-----------------------------|---------------|-------------|
|                                |                | 9372W                       | 9372DKW       | 9375W       |
| Core Size:                     |                | 3.0 in. (76.2 mm)           |               |             |
| Minimum Slit Width:            |                | 1" up to 3"                 | 1/2" up to 3" | 2" up to 3" |
| 3" to 30"                      | minimum length | 60 yards                    | 60 yards      | 60 yards    |
|                                | maximum length | 180 yards                   | 180 yards     | 180 yards   |
|                                | minimum length | 60 yards                    | 60 yards      | 60 yards    |
|                                | maximum length | 720 yards                   | 720 yards     | 720 yards   |
| 31" to 48"                     | minimum length | —                           | —             | 60 yards    |
|                                | maximum length | —                           | —             | 500 yards   |
| 31" to 60"                     | minimum length | 60 yards                    | 60 yards      | —           |
|                                | maximum length | 500 yards                   | 500 yards     | —           |
| Normal Slitting Tolerance:     |                | ± 1/32 in. (0.8 mm)         |               |             |
| Precision Slitting Capability: |                | ± 0.004 in. (0.10 mm)       |               |             |

## Typical Peel Adhesions

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

**Peel Adhesion** (ASTM D3330 - Modified for 90°)

| Product           |                          | 3M™ Adhesive Transfer Tapes |           |
|-------------------|--------------------------|-----------------------------|-----------|
|                   |                          | 9372W & DKW                 | 9375W     |
| Surface:          |                          | Oz./in. (N/100 mm)          |           |
| Stainless Steel   | Initial                  | 70 (77)                     | 88 (96)   |
|                   | 72 Hr. Room Temp.        | 72 (79)                     | 107 (117) |
|                   | Ultimate (72 Hr., 158°F) | 98 (85)                     | 160 (175) |
| ABS               | 72 Hr. Room Temp.        | 62 (68)                     | 86 (94)   |
| Polycarbonate     | 72 Hr. Room Temp.        | 63 (69)                     | 87 (95)   |
| Polypropylene     | 72 Hr. Room Temp.        | 48 (53)                     | 55 (60)   |
| Polyethylene (HD) | 72 Hr. Room Temp.        | 51 (56)                     | 67 (73)   |

## Typical Static Shear Performance

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

**Shear Adhesion** (ASTM D-3654, 1" x 1" Overlap)

| Product         |                      | 3M™ Adhesive Transfer Tapes |          |
|-----------------|----------------------|-----------------------------|----------|
|                 |                      | 9372W & DKW                 | 9375W    |
| Surface:        |                      | Minutes to Fail             |          |
| Stainless Steel | 1000 gm, Room Temp.  | > 10,000                    | > 10,000 |
|                 | 500 gm, 158°F (70°C) | > 10,000                    | > 10,000 |

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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. 15 psi momentary pressure is typical.

Ideal tape application temperature range is 70°F to 100°F (21°C to 37°C). Initial tape application to surface at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once applied, low temperature holding is generally satisfactory.

Surfaces should be clean and dry prior to bonding. We recommend a final surface cleaning with a mixture of 50% isopropyl alcohol\* and water.

\*Carefully read and follow the manufacturer's precautions and directions for use when using cleaning solvents.

Two liner options facilitate wide array of application techniques. Densified kraft liner ideal for roll to roll lamination and subsequent rotary die cutting. Heavy caliper, layflat, polycoated kraft liner, minimizes surface asperities, minimizes distortion of pre-laminated substrates in variable humidity conditions and provide convenient backing for kiss cutting operations.

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## Applications

This family of products has been formulated for applications requiring flame retardency and high bond strength to a wide variety of substrates.

These attributes and choice of three product thicknesses make the products ideally suited to applications in aerospace, maritime, electronic, automotive and building construction applications on both smooth and textured substrates.

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## 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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## Storage

Store under normal conditions of 70°F (21°C) and 50% relative humidity 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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## Certification/ Recognition

### Federal Aviation Regulations, FAR 25.853

These products were designed for use in applications that must comply with both the 12 and 60 second vertical burn requirements, as well as the maximum energy release and smoke opacity requirements of FAR 25.853, Appendix F. Applications using these products have also demonstrated compliance with current OEM Drager Tube toxicity standards.

### Underwriter's Laboratory, UL 94 (UL File E213134)

3M™ Adhesive Transfer Tapes 9372W and 9372DKW have been rated UL 94 V-0 when mounted on polyimide (Kapton) 1 mil thick or greater or mounted on aluminum 2 mils thick or greater.

3M™ Adhesive Transfer Tape 9375 has been rated UL 94 V-2 when mounted on 1 mil polyimide (Kapton) or mounted on aluminum 5 mils thick or greater.

### National Fire Protection Association, NFPA 1971 (2000 Edition)

Customers have obtained this recognition for their specification applications in fire fighting apparel.

### Federal Motor Vehicle Safety Standards, FMVSS 302

All products have been certified to this standard.

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## Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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## Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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## Warranty, Limited Remedy, and Disclaimer

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## Limitation of Liability

Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

**ISO 9001:2000**

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



### Industrial Adhesives and Tapes Division

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