



Adhesive Transfer Tape

463 • 465

Technical Data

August, 1994

Product Description	463 .002 in. (0.05 mm) thick Adhesive Transfer Tape designed for use with 3M automatic dispensing equipment
	465 .002 in. (0.05 mm) thick Adhesive Transfer Tape with easy liner release for manual or hand application

Construction	Products	463 Tape	465 Tape
Adhesive Type:		A-40*	A-40*
Adhesive Carrier:		None	None
Release Liner:		Tan Paper	Tan Paper
Approximate Thickness:			
Release Liner		0.004 in. (0.10 mm)	0.004 in. (0.10 mm)
Tape only		0.002 in. (0.05 mm)	0.002 in. (0.05 mm)
Tape Color:		Clear	Clear

*A-40 is a medium-firm acrylic pressure-sensitive adhesive system. It features an excellent balance of high initial adhesion (quick stick) and good shear holding power.

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.

Adhesion to Steel: (ASTM D-3330)	25 oz./in. width (27 N/100 mm)	25 oz./in. width (27 N/100 mm)
Relative High Temperature Operating Ranges:		
Short Term (minutes, hours)	250°F (121°C)	250°F (121°C)
Long Term (Days, Weeks)	180°F (82°C)	180°F (82°C)
Relative Solvent Resistance:	Good	Good
U.V. Resistance:	Excellent	Excellent
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 yds. (54.9 m)	60 yds. (54.9 m)
	Maximum In:		
	1/8" to 3/8" widths	120 yds. (110 m)	60 yds. (54.9 m)
	3/8" to 1/2" widths	120 yds. (110 m)	60 yds. (54.9 m)
	1/2" to 2" widths	600 yds. (549 m)	360 yds. (329 m)
	2" and greater	360 yds. (329 m)	360 yds. (329 m)
Available Widths (Subject to Minimum Order Requirements):	Minimum	1/8 in. (3.18 mm)	1/8 in. (3.18 mm)
	Maximum	48 in. (1219 mm)	48 in. (1219 mm)
	Normal Slitting Tolerance:	± 1/32 in. (0.8 mm)	± 1/32 in. (0.8 mm)
Core Size (ID):	3.0 in. (76.2 mm)	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 manufacturer's safety precautions and directions for use when using solvents.
- 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

- Tapes meet the requirements of U.S. Government specification MIL-P-19834B, Type I.

Application Ideas

463 and 465 tapes are ideal for bonding together a wide variety of similar and dissimilar materials such as metals, glass, wood, papers, paints, and many plastics. Some application ideas include:

- High-speed flying splices on most grades of paper.
- Splicing of foils, films, fabrics.
- Laminating adhesive for foams, photos.
- Attaching metal or plastic nameplates.
- Mounting promotional items, posters.
- Core starting.

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-227-5085. Address correspondence to: 3M Industrial Tape and Specialties Division, 3M Center, Building 220-8E-04, St. Paul, MN 55144-1000. Our fax number is 612-733-9175. In Canada, phone: 1-519-451-2500. In Puerto Rico, phone: 1-809-750-3000. In Mexico, phone: 5-728-0400.

Important Notice

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ISO 9002

This Industrial Tape and Specialties Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

3M

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