



# Electroplating Tape

## 470

Technical Data

July, 1995

### Product Description

A conformable and abrasion-resistant vinyl plastic tape with excellent resistance to most chemicals used in typical electroplating processes. 470 tape can be qualified to meet specification HH-T-0025, Amendment 2.

### Construction

Backing	Adhesive	Color	Standard Roll Length
Pigmented vinyl plastic	Rubber-resin	Tan	36 yds. (33 m)
Standard Widths Available:	1/2, 3/4, 1, 2, 3, 4, 6 in. (13, 19, 25, 50, 75, 100, 150 mm)		

### 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.**

		ASTM Test Method
Adhesion to Steel:	26 oz./in. width (28 N/100 mm)	D-3330
Tensile Strength at Break:	20 lbs./in. width (350 N/100 mm)	D-3759
Elongation at Break:	180%	D-3759
Backing Thickness:	6.3 mils (.16 mm)	D-3652
Total Tape Thickness:	7.1 mils (.18 mm)	D-3652

### General Information

- Excellent resistance to most chemicals used in typical electroplating operations.
- Prolonged exposure to elevated temperatures (above 170°F/77°C) and hot caustics may cause weakening of the adhesive bond.
- Can be qualified to meet Federal Specification HH-T-0025 (GSA-FSS).
- While 470 tape resists most common solvents, care should be taken to avoid ketones, chlorinated hydrocarbons, and esters, found in lacquer thinners, degreasers, paint strippers, etc., which may cause the backing to swell or curl.
- The shelf life for 470 tape is 18 months from the date of manufacture when stored in a clean, dry environment between 60-80°F (15-27°C) and 40-50% relative humidity.

### Application Ideas

- Masking during many electroplating operations, including both flat strip and overlapping masks.
- Wrapping, patching, coated racks and masking many irregular surfaces.

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Features	Advantages	Benefits
<ul style="list-style-type: none"><li>• Resistant to most electroplating chemicals</li><li>• Abrasion resistant</li><li>• Conformable backing</li></ul>	<ul style="list-style-type: none"><li>• Less undercutting</li><li>• Helps protect parts from processing scratches and grit blasting</li><li>• Follows contours</li></ul>	<ul style="list-style-type: none"><li>• Helps save money because of fewer rejects</li><li>• Helps save money by reducing rework</li></ul>

## 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.

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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.



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