



Double Coated Film Tape

476XL

Technical Data

January, 1996

Product Description 476XL Double Coated Film Tape is a pressure-sensitive adhesive system that offers excellent quick stick for sealing many boxes and tubes used for various types of shipments. The adhesive width is decreased by 1/8 in. on each side to facilitate easy liner startability.

Construction	Product	476XL Tape
	Adhesive Type:	High tack synthetic rubber resin
	Adhesive Carrier:	Polypropylene film
	Release Liner:	White with red printing "Remove To Expose Adhesive"
	Approximate Thickness:	.009 in. (0.23 mm)
	Release Liner:	.003 in. (0.08 mm)
	Tape Only:	.006 in. (0.16 mm)
	Tape Color:	Clear

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.**

Adhesion to Steel:	130 oz./in. width (141 N/100 mm)
Relative High Temperature Operating Ranges:	
Long Term (days, weeks)	120°F (50°C)
Short Term (minutes)	150°F (65°C)
Shelf Life:	18 months from date of receipt by customer when stored in original cartons at 70°F (21°C) and 50% R.H.

Available Sizes	Core Size:	3.0 in. (76.2 mm)
	Available Widths:	1.5 in. (38 mm)
	Available Lengths:	540 yds. (494 mm)
	Normal Slitting Tolerance:	± 1/32 in. (0.8 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.
- Ideal tape application temperature range is 70°F to 100°F (21°C to 38°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.

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550. Address correspondence to: 3M Industrial Tape and Specialties Division, 3M Center, Building 220-7E-01, St. Paul, MN 55144-1000. Our fax number is 612-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-809-750-3000. In Mexico, phone: 5-728-2180.

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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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