



Adhesive Transfer Tapes

450EK • 450XL • 465XL • 920XL

Technical Data

November, 1997

Product Description

450EK 0.001 in. (0.025 mm) thick Adhesive Transfer Tape

450XL 0.001 in. (0.025 mm) thick Adhesive Transfer Tape

465XL 0.002 in. (0.05 mm) thick Adhesive Transfer Tape

920XL 0.001 in. (0.025 mm) thick Adhesive Transfer Tape

These tapes feature excellent quick stick to most papers and plastics. The non-fibered adhesive readily breaks away from the release liner allowing easy attachment.

Construction

Products	Tape 450EK	Tape 450XL	Tape 465XL	Tape 920XL
Adhesive Type:	A-50	A-50	A-50	A-50
Adhesive Carrier:	None	None	None	None
Release Liner:	70# White Extensible Kraft	60# Kraft Glassine-Tan with green print	60# Kraft Glassine-Tan with green print	40# Kraft White-Red Print
Approximate Thickness:				
Release Liner:	.0056 in. (0.146 mm)	.0035 in. (0.09 mm)	.0035 in. (0.09 mm)	.0025 in. (0.065 mm)
Tape Only:	.001 in. (0.025 mm)	.001 in. (0.025 mm)	.002 in. (0.05 mm)	.001 in. (0.025 mm)
Tape Color:	clear	clear	clear	clear

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.

Products	Tape 450EK	Tape 450XL	Tape 465XL	Tape 920XL
Adhesion to Steel:	20 oz./in. width (22 N/100 mm)	20 oz./in. width (22 N/100 mm)	25 oz./in. width (22 N/100 mm)	20 oz./in. width (22 N/100 mm)
Relative High Temperature Operating Ranges:				
Long Term: (days, weeks)	180°F (84°C)	180°F (84°C)	180°F (84°C)	180°F (84°C)
Short Term: (minutes)	250°F (121°C)	250°F (121°C)	250°F (121°C)	250°F (121°C)
Relative Solvent Resistance:	Good	Good	Good	Good
U.V. Resistance:	Excellent	Excellent	Excellent	Excellent
Shelf Life:	24 months from date of manufacture when stored in original cartons at 70°F (21°C) and 50% R.H.			

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Available Sizes	Products	Tape 450EK	Tape 450XL	Tape 465XL	Tape 920XL
Available Width:		1 in. (25 mm) Liner extension is 1/16 in. on each side. This decreases the adhesive width by 1/8 in.	1 in. (25 mm)	1 in. (25 mm)	1 in. (25 mm)
Available Length:		600 yards (548 m)	750 yards (685 m)	600 yards (548 m)	1000 yards (914 m)
Normal Slitting Tolerance:		± 1/32 in. (0.8 mm)	± 1/32 in. (0.8 mm)	± 1/32 in. (0.8 mm)	± 1/32 in. (0.8 mm)

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 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.

Application Ideas

- These tapes are ideal for pharmaceutical outsert attachment. Tape 450XL has a heavier liner than tape 920XL to help reduce liner breakage during application. Tape 450EK has the most tear resistant liner of these products. This release liner has stretch built into the paper making it tough and tear resistant. Tape 465XL is .002 in. thick for surface which requires more adhesive mass.

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 Bonding Systems 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 Bonding Systems Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

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