



Double Coated Tape 415

Product Data Sheet

Updated : July 2001
Supersedes : March 1996

Product Description 415 has a medium-firm acrylic adhesive system. It features an excellent balance of high initial adhesion (quick stick) and good shear holding power. Bond strength generally increases somewhat with natural ageing.

Physical Properties
Not for specification purposes

Adhesive Type	Medium-firm Acrylic	3M ref : A-40
Carrier	Polyester Film	
Thickness (ASTM D-3652) Tape Liner Total	100 µm 4 Thou 100 µm 200 µm	
Release Liner	White	
Tape Colour	Clear	
Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

Performance Characteristics
Not for specification purposes

Adhesion to Stainless Steel ASTM D-3330	2.7 N/10mm	
Shear Resistance	Good	
Temperature Performance Max : Minutes / Hours Max : Days / Weeks Minimum	80 °C 65 °C - 30 °C	
Solvent Resistance	High	
UV Light Resistance	Excellent	

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Additional Product Information

This is a "permanent" adhesive in the sense that it does not degrade when sandwiched between two impermeable surfaces in normal use.

This adhesive will not bleed into most paper stocks, thus minimising possible discolouration of business forms, posters.

Application Techniques

1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact & thus improves bond strength.

2. To obtain optimum adhesion, the bonding

surfaces must be clean dry and well unified. A typical surface cleaning solvent is isopropyl alcohol. Use proper safety precautions for handling solvents.

3. Ideal tape application temperature range is 21°C to 38°C (70°F to 100°F).

Initial tape application to surfaces at temperatures below 10°C (50°F) is not recommended because the adhesive becomes too firm to adhere readily. However once properly applied low temperature holding is generally satisfactory.

Applications

415 is well suited for bonding together a wide variety of similar and dissimilar materials such as metals, glass, wood, papers, paints and many plastics.

High speed flying splices on most grades of paper such as newsprint, clay coated, corrugated stocks.

Splicing of foils, films, fabrics.

Laminating adhesive for foams, photos.

Mounting promotional items, posters.

Mounting rubber or photopolymer printing plates.

Miscellaneous joining and holding where high initial adhesion, easy liner release and a thin, long ageing bond is required.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



Tapes & Adhesives

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