




Science.  
Applied to Life.™

A photograph showing two male workers in a factory setting. They are standing in front of a large roll of white paper. The worker on the left is wearing a light blue t-shirt, blue jeans, and safety glasses. The worker on the right is wearing a light blue t-shirt, blue jeans, and work gloves. They are both touching the surface of the paper roll. A blue strip of material is visible on the roll. The background shows industrial machinery and a red structure. The bottom half of the image is overlaid with a large orange and yellow diagonal graphic.

**Productivity and  
performance  
throughout printing  
plants, web and paper  
processing facilities.**

3M Solutions for Web Processing

# Solutions to keep the work flowing and your customers coming back.

When you need to splice webs, reduce plate damage or improve print quality, you can rely on 3M to provide you with the right solutions.

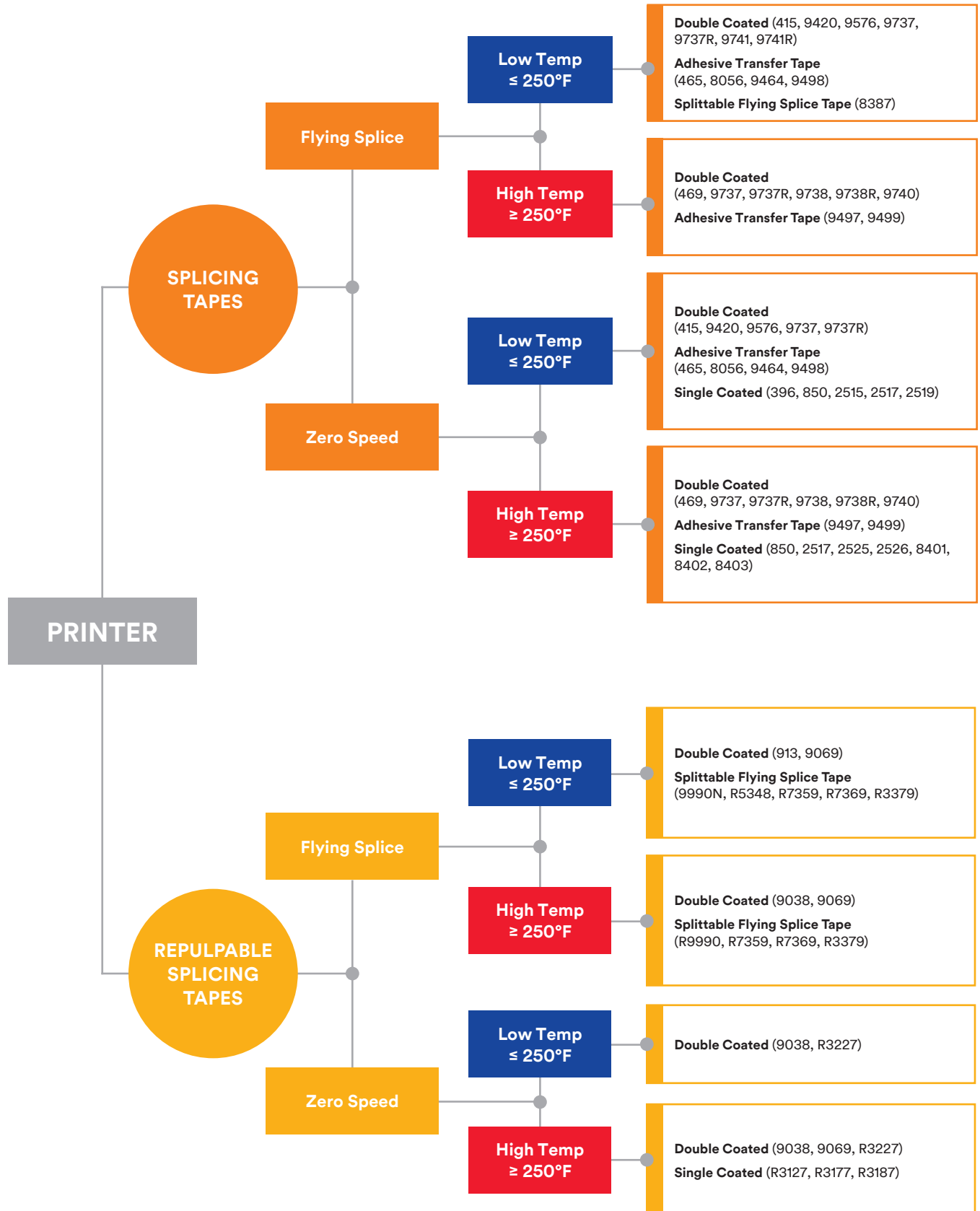
Having the right products makes all the difference. 3M can help you maximize your plant's potential by offering reliable products such as air-release tapes that provide clean and easy removal of printing plates, splicing tapes for improved productivity and efficiencies, and web handling systems that can increase or decrease the level of traction.

Plus, a line of products that can help keep the rest of your plant running smoothly, like lane marking tapes to show the way, case sealers that ease bottleneck and high to low temperature threadlockers.





# 3M™ Splicing Tapes Selection Guide



Temperature ratings are dependent on oven time, web tension, web speed and substrate thickness. See data page for exact temperature rating.

# 3M™ Splicing Tapes

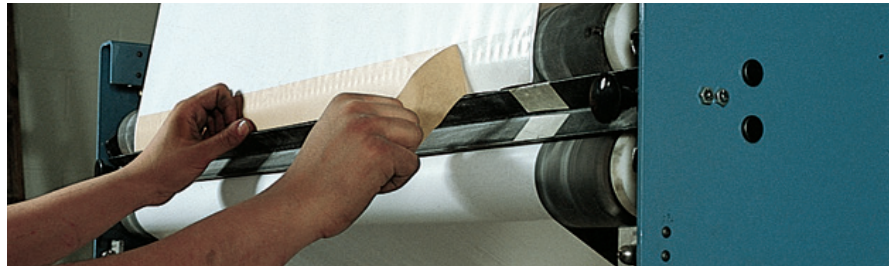
## Adhesive transfer and double coated tapes for reliable overlap splices

### 3M™ Adhesive Transfer Tapes

For an overlap splice, simply press the adhesive side of the tape to one of the surfaces to be spliced. Peel off the liner and you have a neat strip of adhesive for immediate bonding. Select from a range of adhesive properties.

### 3M™ Double Coated Tapes

Adhesive is on both sides of a carrier that increases dimensional stability of the adhesive for easy handling and application in making overlap splices.



High tack 3M™ Adhesive Transfer Tape 465 grabs fast for flying and zero speed splices, resists up to 250°F for 20 seconds.



With high tack and good shear strength, 3M™ Double Coated Tape 9420 splices plastic film quickly and securely. Red carrier identifies the splice for later removal.

## 3M™ Splicing Tapes

(All tapes in this chart can be considered for zero speed or flying splices)

Product Number	Product Description	Tape Thickness mils (mm) without liner	Carrier		Color	Adhesion oz/in (N/25 mm)	Heat Resistance* (Short-term) °F (°C)	Go-To Application	
			Thickness mils (mm)	Type				Zero Speed	Flying Splice
Based on ASTM Test Method		D-3652	D-3652			D-3330			
<b>Adhesive Transfer Tape</b>									
465	High tack, excellent adhesion to most paper stocks, flexible to -60°F	2.0 (0.05)	—	None	Clear	25 (6.8)	250 (121)		
9498/9464	Low temperature splicing	2.0 (0.05)	—	None	Clear/Red	20 (6.0)	250 (121)	■	
9499/9497	High temperature splicing	2.0 (0.05)	—	None	Clear/Red	45 (12.5)	350 (177)	■	
<b>Double Coated Tapes</b>									
415/9420	High tack adhesion to paper and many other surfaces	4.0 (0.10)	0.5 (0.01)	Polyester	Clear/Red	25 (6.8)	180 (82)		
469	High temperature, high tack	5.5 (0.14)	1.0 (0.02)	Tissue	Red	60 (16.7)	350 (177)		■
9086	Easy tearing, easy handling, thick high tack adhesive, very conformable	7.5 (0.19)	1.5 (0.03)	Non-Woven Tissue	Clear	146 (40.0)	250 (121)		
9088	High temperature resistance, high tack and shear strength	8.3 (0.20)	0.5 (0.01)	Polyester	Clear	137 (37.5)	300 (150)		
9576	Medium tack for general splicing and roll closing	4.0 (0.10)	1.0 (0.02)	Polypropylene	Red/Black	30 (13.5)	165 (75)		
9737/9737R	Thin PET carrier, aggressive and versatile tape for many surfaces	3.5 (0.09)	0.5 (0.01)	Polyester	Clear/Red	60 (16.7)	300 (150)	■	■
9738/9738R	Non-woven tissue carrier, aggressive and versatile tape for many surfaces	4.3 (0.11)	1.3 (0.03)	Non-Woven Tissue	Clear/Red	60 (16.7)	300 (150)	■	■
9740	High performance over a wide range of temperatures, high peel, tack, and shear properties, performance grade splicing for corrugators	3.5 (0.09)	0.5 (0.01)	Polyester	Clear	70 (21.2)	425 (218)		■
9741/9741R	Thick tape adheres to a wide variety of substrates, super aggressive for low surface energy substrates	6.5 (0.17)	0.5 (0.01)	Polyester	Clear/Red	120 (34.0)	200 (93)		

\*As tested in laboratory. Results may vary depending on machine and web tensions, nature of paper surface, application pressure, etc. which are outside of 3M's control.

Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.

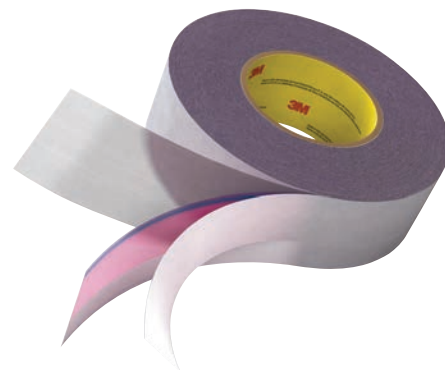
# 3M™ Splicing Tapes (cont.)

## 3M™ Splittable Flying Splice Tape 8387

**Maximize speed.** Keep your presses running at higher speeds so you can get the best from your press with consistent results.

**Optimize surface adhesion.** Splice even the most challenging substrates, such as: polyethylene, biaxially oriented polypropylene, cast polypropylene, polyester and aluminum foil.

**Minimize contamination.** Save cleanup time and money by reducing tab debris and fiber contamination on your central impression (CI) drum and rollers, as well as eliminating the hazards of using glue.



Product Number	Adhesive	Backing	Liner	Color	Tape Thickness Mils (mm)	Liner Thickness Mils (mm)	Post — Split Tape Thickness Mils (mm)
8387	Differential Adhesive	Film	Easy-release coated paper	Splicing Side: Pink Tabbing Side: Black	7.0 (0.19) without liner	3.0 (0.09)	Splicing: 4.0 (0.10) Tabbing: 3.0 (0.09)

## 3M™ Polyester Tapes

These high strength single-coated tapes provide thin caliper with some of the highest tensile strengths available for overlap and butt splices.



For marking splice location, 3M™ Polyester Tape 850 is available in red, black, white and silver. Transparent is also available to blend with the web stock. Pressure sensitive acrylic adhesive grabs on contact and holds butt splices securely. High tensile strength backing resists web handling stresses.

Product Number	Color	Adhesive Type	Backing Material	Backing Thickness mils (mm)	Total Thickness mils (mm)	Adhesion to Steel oz/in (N/100 mm)	Tensile Strength lb/in (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)	Comments
Based on ASTM Test Method:				D-3652	D-3652	D-3330	D-3759	D-3759		
<b>General Industrial Tapes</b>										
850	Various	Acrylic	Polyester	0.9 (0.02)	1.9 (0.05)	30 (33)	28 (491)	120	-60 to 300 (-50 to 150)	Splicing, holding, sealing. Transparent, Red, Black, White.
<b>High Temperature Masking and Liner Splicing Tapes</b>										
8401	Translucent Cream	Silicone/Rubber Blend	Polyester	1.0 (0.03)	1.9 (0.05)	22 (24)	34 (595)	100	-60 to 300 (-50 to 150)	Splicing many release coated paper.
8402	Translucent Green	Silicone	Polyester	0.9 (0.02)	1.9 (0.05)	24 (26)	25 (438)	100	-60 to 425 (-50 to 218)	Adheres well to silicone.
8403/ 8403L	Translucent Green	Silicone	Polyester	1.4 (0.04)	2.4 (0.06)	27 (29)	46 (806)	150	-60 to 425 (-50 to 218)	Adheres well to silicone. 8403L is lined version.
8991/ 8991L	Blue	Silicone	Polyester	1.0 (0.03)	2.4 (0.06)	31 (34)	29 (508)	100	-60 to 400 (-50 to 204)	Economical, thin tape. Adheres well to silicone. 8991L is lined version.
8992/ 8992L	Green	Silicone	Polyester	2.0 (0.05)	3.2 (0.08)	44 (48)	57 (998)	148	-60 to 400 (-50 to 204)	Economical tape. Adheres well to silicone. 8992L is lined version.
<b>Reflective Tapes</b>										
850	Silver	Acrylic	Polyester	0.9 (0.02)	1.9 (0.05)	42 (46)	28 (491)	120	-60 to 300 (-50 to 150)	Splicing, holding, sealing, decorating, metal detecting.

Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.

## 3M™ Splicing Tapes (cont.)

### Scotch® Flatback Crepe Tapes

With high strength paper backings, these single-coated tapes provide high machine direction tensile strength yet can be conveniently torn off the roll by hand for application ease.

With a core capability of coating technology, 3M flatback tapes offer a range of backings and adhesive strengths to hold up to your job.

- High strength backings with strong cross direction tensile properties used for tabbing and splicing
- Highly visible backing to help you identify and remove splices



Versatile 3M™ Performance Flatback Tape 2525 provides high visibility for holding many materials, edge banding and splicing.



Scotch® Flatback Tape 2525 is great for applications requiring a unique color.



Scotch® Flatback Tape 2517 is great for low or high temperature splicing.

Product Number	Color	Adhesive Type	Backing Material	Total Thickness mils (mm)	Adhesion to Steel oz/in (N/100 mm)	Tensile Strength lb/in (N/100 mm)	Elongation at Break %	Maximum Operating Temperature °F (°C)**	Time at Maximum Temperature (mins.)	Can be Certified to Specification	Comments
Based on ASTM Test Method:				D-3652	D-3330	D-3759	D-3759				
250	Tan	Rubber	Flatback Paper	6.0 (0.15)	87 (95)	59 (1033)	4	125 (52)	30	ASTM D 6123; D 6123M-97	Used in paint adhesion testing.
253	Tan	Silicone	Treated Flatstock Paper	4.6 (0.12)	49 (54)	60 (1052)	3	150 (66)	—	—	Silicone butt splicing tape.
256	White, Red, Green	Rubber	Flatback Paper	4.8 (0.12)	35 (38)	32 (560)	3	200 (93)	60	ASTM D 6123; D 6123M-97	Printable, accepts marking inks.
346	Tan	Rubber	Flat Paper Stock	16.7 (0.42)	22 (24)	28 (490)	4	100 (38)	—	—	Heavy-duty abrasion, moisture, UV protection.
2515*	Tan	Rubber	Kraft Paper	6.4 (0.16)	54 (59)	40 (700)	9	150 (65)	30	—	General purpose splicing, holding and bundling applications.
2517	Medium Brown	Rubber	Kraft Paper	6.5 (0.16)	78 (85)	35 (543)	2	300 (149)	30	ASTM D 6123; D 6123M-97	Excellent splicing, holding and bundling applications.
2519	Brown	Rubber	Kraft Paper	7.3 (0.19)	45 (49)	45 (790)	9	200 (93)	30	—	Excellent for splicing liner boards, bundling, holding, reinforcing, wrapping and protecting.
2525	Orange	Rubber	Flatback Paper	9.5 (0.24)	69 (75)	49 (858)	2	300 (149)	60	—	Premium splicing, bright color.
2526	White	Rubber	Flatback Paper	9.8 (0.24)	69 (75)	50 (858)	4	300 (149)	30	—	Excellent adhesion and strength for textile applications.

\*3M brand.

\*\*2519 Maximum Operating Temperature determined for holding a paper splice at 200°F (93°C) under a force of 2 pounds/linear inch (PLI).

Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.



# 3M™ Repulpable Splicing Tapes

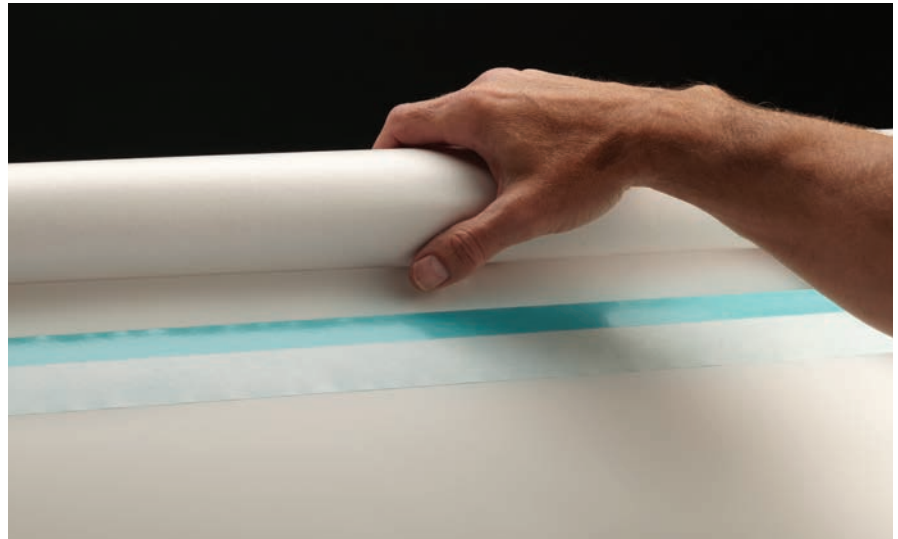
## 3M™ Repulpable Splicing Tapes for the Printing Industry

From core starting to roll closing/ tabbing and all the splices in between, this line of repulpable tapes offers choices for the dependability you need to keep production at full speed.

**Splittable Flying Splice Tapes**  
For flying splice a variety of papers.

**Repulpable Single Coated Tapes**  
For roll closing and tabbing.

**Repulpable Double Coated Tapes**  
For core starting and flying/zero speed splices.



3M™ Splicing Tape 9990N is a splittable flying splice tape with a metalized layer for automatic splice detection. It performs well on a wide range of papers.

Product Number	Color	Comments	Tape Thickness mils (mm) without liner	Tape Structure		Liner		Heat Resistance* °F (°C)	FDA Compliant†
				Backing/ Carrier	Adhesive	Type	Thickness mils (mm)		
<b>Splittable Flying Splice (SFS)</b>									
R5348	Blue	Use with light- to medium-weight papers running through medium-temperature ovens	5.0 (0.11)	Paper	Repulpable	Paper	2.9 (0.07)	350 (180)	—
R7359	Blue	Use with light- to heavy-weight papers running at high speeds and high temperatures	6.6 (0.17)	Paper	Repulpable	Paper	2.9 (0.07)	400 (200)	—
R7369	Blue	Use with light- to heavy-weight paper on wide web rolls to help compensate for roll profile variations running at high speeds and high temperatures	7.4 (0.19)	Paper	Repulpable	Paper	2.9 (0.07)	400 (200)	—
9990N	Blue	Splittable flying splice (SFS) system with metalized layer for auto-sensing splice detection applications	5.5 (0.14)	Aluminized Paper**	Repulpable	Paper	2.2 (.05)	350 (180)	—
<b>Repulpable Single Coated</b>									
R3127	Blue/ White/ Kraft	General purpose, excellent holding power	4.5 (0.11)	Paper	Repulpable	—	None	400 (200)	Yes
R3187	Blue/ White/ Kraft	General purpose, strong repulpable backing	7.5 (0.19)	Paper	Repulpable	—	None	400 (200)	Yes
R3177	Blue/ White/ Red	Heavy duty, extensible repulpable backing	7.0 (0.16)	Paper	Repulpable	—	None	400 (200)	Yes
<b>Repulpable Double Coated</b>									
913	Blue	Paster tape for splices at newspaper printers	3.5 (0.09)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	—
9038	Blue/ White	General purpose plus flying splice tape for commercial printers and corrugators	3.5 (0.09)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	350 (180)	Yes
9069	Blue	Excellent for newsprint or directory stock	3.5 (0.09)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	—
R3227	Blue/ White	For zero speed splicing	3.5 (0.09)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	Yes

\*As tested in laboratory. Results may vary depending on machine and web tensions, nature of paper surface, application pressure, etc. which are outside of 3M's control.

\*\*Non-repulpable, screenable aluminized sensor strip.

†All components of the adhesive and backing meet the requirements of indirect food additive regulations as described under 21 CFR 176.170 (Components of paper and paperboard in contact with aqueous and fatty food) and 21 CFR 176.180 (Components of paper and paperboard in contact with dry foods).

**Note:** The technical information and data should be considered representative or typical only and should not be used for specification purposes.

# 3M™ PTFE and UHMW-PE Tapes

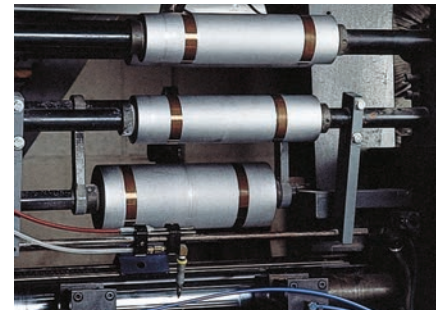
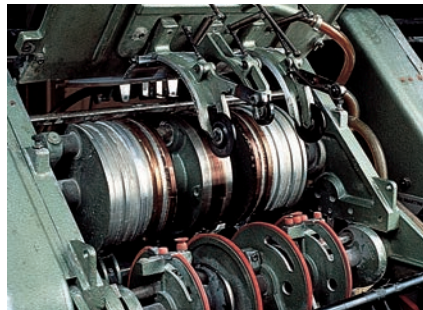
## 3M™ Slick Surface Tapes — Performance Comparison

Attribute	Good	Better	Best
Heat Resistance	UHMW-PE Tape	PTFE Film Tape	PTFE Glass Cloth Tape
Wear Life	PTFE Film Tape	PTFE Glass Cloth Tape	UHMW-PE Tape
Conformability	PTFE Glass Cloth Tape	UHMW-PE Tape	PTFE Film Tape
Low Friction Coefficient	UHMW-PE Tape	PTFE Glass Cloth Tape	PTFE Film Tape
Anti-stick/Solvent Resistance	PTFE Glass Cloth Tape	UHMW-PE Tape	PTFE Film Tape

## 3M™ Graphics Arts Tapes

### Slick surface roller wrap tapes for smoother web movement

PTFE Tapes perform at up to 500°F (260°C) and resist chemicals. For temperatures up to 225°F (107°C) and abrasion resistance, consider UHMW-PE (Ultra High Molecular Weight Polyethylene).



Conformable 3M™ PTFE Tape helps the movement of web materials in many types of roller wrapping applications.

## 3M™ PTFE Tapes

Product Number	Color	Adhesive Type	Backing Material	Backing Thickness mils (mm)	Total Thickness mils (mm)	Adhesion to Steel oz/in (N/100 mm)	Tensile Strength lb/in (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)	Comments
Based on ASTM Test Method:				D-3652	D-3652	D-3330	D-3759	D-3759		
<b>Skived Film</b>										
5480	Gray	Silicone	PTFE	2.0 (0.05)	3.7 (0.09)	20 (22)	26 (461)	140	-65 to 500 (-54 to 260)	Roller wrapping tape.
5481	Gray	Silicone	PTFE	5.0 (0.13)	6.8 (0.17)	32 (35)	59 (1039)	290	-65 to 500 (-54 to 260)	Heavy-duty roller wrapping tape.
<b>Extruded Film</b>										
5490	Gray	Silicone	PTFE	2.0 (0.05)	3.7 (0.09)	27 (30)	17 (304)	170	-65 to 500 (-54 to 260)	Lay-flat backing.
5491	Gray	Silicone	PTFE	5.0 (0.13)	6.7 (0.17)	35 (38)	42 (727)	260	-65 to 500 (-54 to 260)	Lay-flat backing.

Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.



# 3M™ Graphics Arts Tapes (cont.)

## 3M™ UHMW-PE Tapes

Product Number	Color	Adhesive Type	Backing Material	Backing Thickness mils (mm)	Liner Type	Total Thickness mils (mm)	Adhesion to Steel oz./in. (N/100 mm)	Tensile Strength lb./in. (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)	Comments
Based on ASTM Test Method:				D-3652		D-3652	D-3330	D-3759	D-3759		
5421	Translucent	Rubber	UHMW-PE	5.0 (0.13)	60# Densified Kraft Paper	6.7 (0.17)	34 (37)	46 (796)	470	-30 to 225 (-34 to 107)	General purpose tape to protect plastic and metal chutes, guide rails and containers from wear.
5423	Translucent	Rubber	UHMW-PE	10.0 (0.25)	60# Densified Kraft Paper	12 (0.30)	36 (39)	86 (1500)	530	-30 to 225 (-34 to 107)	Excellent abrasion resistance to protect plastic and metal chutes, guide rails and containers from wear.
5425	Translucent	Acrylic	UHMW-PE	3.0 (0.08)	55# Densified Kraft Paper	5.1 (0.13)	48 (53)	25 (444)	390	-30 to 225 (-34 to 107)	Solvent resistant adhesive with low coefficient of friction and abrasion resistance.

## Traction wrap to enhance friction for web handling

Traction wrap to enhance friction for web handling 3M™ Traction Tape 5401 bonds on contact to rollers providing non-stick traction for enhanced friction that improves web handling.



3M™ Traction Tape 5401 enhances friction on web rollers to help maintain constant traction and tension for the web material from start-up through wind-up.

## 3M™ Application Specific Tapes

Product Number	Color	Adhesive Type	Backing Material	Backing Thickness mils (mm)	Liner Type	Total Thickness mils (mm)	Adhesion to Steel oz./in. (N/100 mm)	Tensile Strength lb./in. (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)	Comments
ASTM Test Method				D-3652		D-3652	D-3330	D-3759	D-3759		
<b>Graphic Arts Tapes</b>											
235	Black	Rubber	Crepe Paper	5.0 (0.12)	—	7.0 (0.17)	23 (25)	22 (386)	9	Up to 200 (Up to 93)	Photographic masking.
616	Ruby Red	Rubber	UPVC	1.6 (0.04)	—	2.4 (0.06)	36 (39)	29 (509)	50	Up to 120 (Up to 49)	Lithographers tape.
3051	White	Acrylic	Flatback Paper	3.4 (0.09)	—	3.8 (0.10)	4 (4)	39 (680)	2	Up to 150 (Up to 65)	Very low tack.
<b>Traction Tapes</b>											
5401	Tan	Silicone	Fiberglass Reinforced Silicone	8.0 (0.20)	—	9.3 (0.24)	12 (13)	220 (3853)	7	Up to 300 (Up to 148)	High coefficient of friction for traction.
5461	White	Rubber	Silicone Rubber	7.8 (0.19)	Silicone-Paper	9.1 (0.23)	30 (33)	85 (1500)	165	Up to 200 (Up to 93)	High friction roller tape.

Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.

# Scotch® ATG Transfer Tapes

## Finger touch application of pressure sensitive adhesive

Versatility, convenience and speed. That's what you get with Scotch® ATG Transfer Tapes for assembly operations in businesses ranging from appliance and printing to P.O.P. and electronics. Readily bond, join, mount, or laminate materials such as paper, plastics, metal, foam and more.

With Scotch® ATG Applicators, a touch of the finger triggers a quick, controlled application of Scotch® ATG Transfer Tape at the same time as the liner rewinds into the applicator. There is no mess and no cleanup. 3M advanced acrylic adhesive bonds on contact and is formulated with a choice of properties such as high temperature resistance, differential tack, adhesion to low surface energy plastic and more.



For musical greeting cards, securely attach the metal audio module to the heavy paper stock and bond the edges of the fold-over flap to seal in the module.



Scotch® ATG Applicator 700 with Scotch® ATG Transfer Tape 924 makes fast work of folder assembly. Pressure sensitive adhesive bonds immediately and the folder pocket is ready to hold contents.



Scotch® ATG Applicator 700 for 3/4" and 1/2" wide tape



Scotch® ATG Applicator 714 for 1/4" wide tape



Scotch® ATG Applicator 752C for 3/4", 1/2" and 1/4" wide tape (1/4" adapter purchased separately)



Scotch® ATG Applicator 3662 for 2" wide tape



Product Number	Tape Thickness w/o Liner (mils (mm))	Description	Temperature Resistance		Solvent Resistance	Relative Adhesion		Application Ideas	Adhesive Transfer Tape Equivalent
			Minutes Hours	Days Weeks		HSE	LSE		
<b>300 (High Tack Acrylic)</b>									
976	2 (0.05)	High tack. Excellent adhesion to most plastics.	250°F (121°C)	150°F (65°C)	Med	High	High	Attach fabric swatches in sample books. Assemble point-of-purchase displays. Bond trim strips to furniture or luggage. Bond labels to plastic toys. Attach gaskets or foams.	927
969	5 (0.13)	High tack. Excellent adhesion to most plastics.	250°F (121°C)	150°F (65°C)	Med	High	High	Assemble point-of-purchase displays. Bond trim strips to furniture or luggage. Bond labels to plastic toys. Attach gaskets or foams.	950
<b>350 (High Performance Acrylic)</b>									
926	5 (0.13)	High performance. Excellent temperature and solvent resistance.	450°F (232°C)	300°F (149°C)	High	High	High	Bond fabric or trim to window blinds. Splice aluminum coils. Bond foam insulation. Mount nameplates on award plaques.	F9485PC
<b>400 (General Purpose Adhesive)</b>									
924	2 (0.05)	General purpose. Excellent adhesion to most paper stocks.	250°F (121°C)	180°F (82°C)	Med	Med	Low	Seal pocket in folders. Bond mat board in picture frames. Splice paper, films, foils. General purpose bindery attaching.	465
987*	1.7 (0.040)	General purpose. Excellent adhesion to most paper stocks.	250°F (121°C)	180°F (82°C)	Med	Med	Low	Seal pocket in folders. Bond mat board in picture frames. Splice paper, films, foils. General purpose bindery attaching.	9498
<b>400/1000 (Repositionable Adhesive)</b>									
928	2 (0.05)	Differential tack. Repositionable.	180°F (82°C)	150°F (65°C)	Med	High/Low	Low/Low	Attach credit card in mailer. Core start/end tab paper, films and foils. Attach temporary labels.	9416

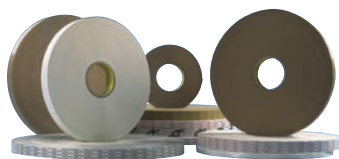
\*3M brand. Relative Adhesion: HSE — High Surface Energy; LSE — Low Surface Energy

Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.

# 3M™ Extended Liner Tapes

## Versatile pressure sensitive adhesive on easy-to-remove liners

3M™ Extended Liner Tapes offer the adhesive versatility of 3M tapes but with liners wider than the adhesive. This leaves an easy-to-lift edge for convenient and easy liner removal. With the variety of adhesives, you have a selection of performance characteristics such as high tack for coated papers and plastics, low tack for temporary attachment, high temperature resistance and more. Apply manually or with equipment matched to your production volume requirements.



3M™ Extended Liner Tapes are available with a release liner wider than the adhesive. This provides an easy-to-grab edge for convenient liner removal.



Depending on adhesive type, 3M™ Extended Liner Tapes are applied to envelopes, polybags, boxes or tubes. User simply peels off liner to expose the adhesive for an immediate, secure closure.



Automatic and semi-automatic equipment is available for higher volume applications. For example, apply tape to business forms, literature, bounce back and business reply cards.



3M™ Extended Liner Tapes 450XL, 450EK and 465XL immediately bond product information “outserts” to polyethylene bottles. Holds tightly but can be cleanly removed.

Product Number	Tape Thickness w/o liner mils (mm)	Liner Type	Description	Temperature Resistance		Solvent Resistance	Relative Adhesion		Application Ideas
				Minutes Hours	Days Weeks		HSE	LSE	
<b>340</b>									
466XL	2 (0.05)	62# DK White with Black Print	High tack; Permanent	180°F (82°C)	150°F (65°C)	Med	High	High	Coated papers and low surface energy (LSE) plastics. Overnight envelopes. Features an end-of-roll indicator tab for automated dispensing.
<b>400</b>									
465XL	2 (0.05)	60# DK Tan with Green Print							Seal flaps on overnight envelopes. Pressure sensitive edging on business forms. General commercial joining applications. For attaching materials that require more adhesive thickness. Larger outsert attachments.
450EK	1 (0.025)	78# Extensible Kraft White w/o Print	General purpose	250°F (121°C)	180°F (82°C)	Med	Med	Low	Pharmaceutical outsert attachment. For applications requiring a more tear resistant liner.
450XL	1 (0.025)	60# DK Tan with Green Print							Pharmaceutical outsert attachment. General paper attachment.
920XL	1 (0.025)	40# DK White with Red Print							Seal flaps on polybags and envelopes. Pressure sensitive edging on business forms, literature, photos, posters and labels.
9926XL	1 (0.025)	40# DK White with Red Print	General purpose	180°F (82°C)	150°F (65°C)	Med	Med	Low	Economical alternative for general paper-to-paper applications.
<b>600</b>									
9934XL	4 (0.10)	60# DK tan without Print	High tack to LSE materials	150°F (65°C)	120°F (49°C)	Med	High	High	P.O.P. displays. Difficult splicing applications, shelf talkers, price tags, polyethylene foam bonding. Indirect food-contact applications. <sup>1</sup> High tack to LSE materials.
<b>760</b>									
476XL	6 (0.16)	62# DK White with Red Print	High tack, double coated film	150°F (65°C)	120°F (49°C)	Med	High	High	Heavy-duty sealing. Mounting of promotional items. Core starting. Closure of overnight boxes, tubes and envelopes. Indirect food-contact applications. <sup>1</sup>
<b>770</b>									
9925XL <sup>2</sup>	2.5 (0.065)	43# DK White with Black Print	Tissue reinforced; High initial adhesion to a wide variety of materials	150°F (65°C)	100°F (41°C)	Low	Med	Med	General mounting. P.O.P. items. Attaching tags and labels. Core starting. Permanent bonding paper-to-paper, business forms, traffic tickets, novelty items and literature. Indirect food-contact applications. <sup>1</sup>

1. FDA acceptable dry ingredients listed as indirect food-contact additives when used in food packing with minimal opportunity for exposure.

2. Non-liner side is adhesive coated full width.

**Relative Adhesion:** HSE – High Surface Energy; LSE – Low Surface Energy

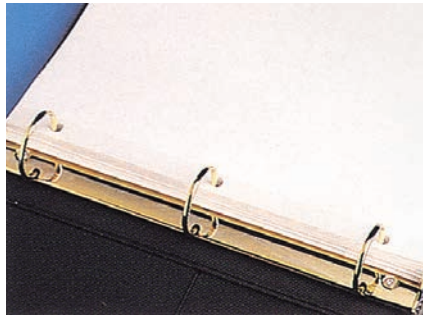
**Note:** The technical information and data should be considered representative or typical only and should not be used for specification purposes.



# 3M™ Polyester Tapes for Edging and Reinforcing

## Tear resistant reinforcement

With thin caliper and tear resistance, 3M™ Polyester Tapes provide tough low-profile reinforcement for card stock edges and punch holes. Choice of tape thickness and adhesives helps meet various end use conditions.



With thin caliper and tear resistance, 3M™ Polyester Tape provides tough low-profile reinforcement for punch holes in card stock. Acrylic adhesive resists yellowing in long-term use.

Product Number	Backing Material	Adhesive Type	Tensile Strength lb/in (N/100 mm)	Total Thickness mils (mm)	Adhesion Strength oz/in (N/100 mm)	Elongation at Break (%)	Color	Comments
			D-3759	D-3652	D-3330	D-3759		
856	Polyester	Acrylic	25 (438)	2.0 (0.05)	20 (22)	90	Transparent	General industrial tape. Economy edge and hole reinforcing.
8411	Polyester	Acrylic	26 (456)	1.5 (0.04)	30 (33)	120	Transparent	Release surface and liner splicing tape. Performance edge and hole reinforcing.
8412	Polyester	Acrylic	120 (2100)	6.3 (0.16)	42 (46)	130	Transparent	Release surface and liner splicing tape. Heavy-duty edge and hole reinforcing.

# Scotch® Tear Strip Tape

## Easy access with a simple pull

For easy opening of packages ranging from overnight envelopes to corrugated fiberboard, the recipient simply grabs and pulls the exposed end of a Scotch® Tear Strip Tape.

- Tensitized polypropylene tears through paper board and light to heavy weight fiber board with high pull-rate success
- Eliminates knives or other sharp edges from opening envelopes and panels



For overnight courier envelopes and mail order boxes, Scotch® Tear Strip Tape provides superior resistance to edge nicking and tearing compared to other film tear strip tapes without reinforcement.



Scotch® Tear Strip Tape with superior tensile strength tears through medium to heavy weight corrugated fiberboard as used in household detergent boxes.

Product Number	Backing Material	Reinforcement	Adhesive Type	Tensile Strength lb/in (N/100 mm)	Total Thickness mils (mm)	Adhesion Strength oz/in (N/100 mm)	Elongation at Break (%)	Color	Comments
				D-3759	D-3652	D-3330			
8624	Polypropylene	None	Synthetic Rubber	160 (2802)	4.5 (0.114)	65 (71)	30	Blue	Medium-strength tear strip for light- to medium-weight fiberboard packaging materials.

Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.

# 3M™ Splicing and Repulpable Tapes

## Tapes for paper mills and converters

From core starting to roll closing/ tabbing and all the splices in-between, this totally repulpable line offers choices for the dependability you need to keep production at full speed. Backings and adhesives are engineered for optimum strength on every type of splice: flying, overlap, butt and general purpose.

### Temporary Tapes

Good shear strength, high tack and reliable heat resistance

### Permanent Tapes

High shear strength to stay with paper through sheeting, printing, slitting and perforating



3M™ Repulpable Splittable Flying Splice Tape eliminates the time and work of “V” and “W” patterns with a straight across flying splice. Advanced coating provides a smooth and consistent opening force. A fiber-free break open means less blanket cleanup.



High tack 3M™ Temporary Single Coated Repulpable Tapes are available in white, blue and kraft for dependable core starting, roll closing and butt splicing.



3M provides a complete line of core starting tapes that are easy to use and stick reliably every time.



For finished mill overlap splicing, 3M™ Repulpable Permanent Tape provides high shear strength without adhesive oozing or bleed through.



One simple splice with 3M™ Splittable Flying Splice Tape replaces complex patterns.



For core starting and roll closing, the hand-held 3M™ Repulpable Tape Applicator RTA-500 dispenses tape and disposes of the liner with one pull of the trigger.

Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.

# 3M™ Splicing and Repulpable Tapes (cont.)

## 3M™ Repulpable Splicing Tapes for the Paper Mills

Product Number	Color	Comments	Tape Thickness mils (mm)	Tape Structure		Liner		Heat Resistance °F (°C)	FDA Compliant <sup>†</sup>
				Backing/ Carrier	Adhesive	Type	Thickness mils (mm)		
<b>Permanent Double Coated</b>									
405	Lt. Green	Excellent for raw and starch-treated papers	3.0 (0.08)	Tissue Carrier	Repulpable	UPVC	1.7 (0.04)	400 (200)	—
900	Blue	Recommended for light weight coated papers	2.5 (0.06)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	Yes
900B	Blue	Recommended for supercalendered papers	2.5 (0.06)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	Yes
<b>Permanent Single Coated</b>									
901	Lt. Green	Excellent for raw and starch-treated papers.	4.0 (0.10)	Paper	Repulpable	UPVC	1.7 (0.04)	400 (200)	—
910	Blue	Recommended for coated and uncoated papers and paperboard.	4.0 (0.10)	Paper	Repulpable	—	None	400 (200)	Yes
914	Blue	Recommended for high speeds, digital business forms, perforated splicing tape.	4.0 (0.10)	Paper	Repulpable	—	None	400 (200)	Yes
9103	Blue	Printable, coatable backing.	4.5 (0.11)	Paper	Repulpable	Paper	2.9 (0.07)	400 (200)	Yes
9960	Blue	Thinnest butt splicing tape for light weight uncoated and coated and supercalendered papers.	2.2 (0.06)	Paper	Repulpable	Paper	2.9 (0.07)	350 (180)	Yes
9969	Blue/ White	Very thin butt splicing/cover tape for uncoated, newsprint and most coated papers.	2.2 (0.06)	Paper	Repulpable	Paper	2.9 (0.07)	350 (180)	Yes
<b>Temporary Double Coated</b>									
906	Blue/ White	Flying splice at the Off-Machine Coater (OMC).	3.0 (0.08)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	Yes
9069	Blue	Excellent for newsprint or directory stock.	3.5 (0.09)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	—
9977	Blue	High strength tissue for flying splices where extra strength is needed.	4.0 (0.10)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	—
R3227	Blue/ White	General purpose temporary splicing.	3.5 (0.09)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	Yes
R3257	White	Thin tissue, very high tack.	4.1 (0.11)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	Yes
R3287	White	Heavy tissue, very high tack.	5.5 (0.14)	Tissue Carrier	Repulpable	Paper	3.2 (0.08)	400 (200)	Yes
<b>Temporary Single Coated</b>									
R3127	Blue/ White/ Kraft	General purpose, excellent holding power.	4.5 (0.11)	Paper	Repulpable	—	None	400 (200)	Yes
R3177	Blue/ White/ Red	Heavy duty, extensible repulpable backing.	7.0 (0.16)	Paper	Repulpable	—	None	400 (200)	Yes
R3187	Blue/ White/ Kraft	General purpose, strong repulpable backing.	7.5 (0.19)	Paper	Repulpable	—	None	400 (200)	Yes
<b>Splittable Flying Splice (SFS)</b>									
R3345	Blue	Thin SFS tape for flying splices through supercalendering operations, and permanent butt splices for light weight coated papers.	4.8 (0.12)	Paper	Repulpable	Paper	2.9 (0.07)	400 (200)	—
R3375	Blue	Strong SFS tape for flying splices on heavy papers and high tension web processing through supercalendering operations.	6.5 (0.16)	Paper	Repulpable	Paper	2.9 (0.07)	400 (200)	—
R3379	Blue	Repulpable Splittable Flying Splice Tape is used for high speed splicing conditions when high tack is required and to compensate for roll profile issues.	7.5 (0.18)	Paper	Repulpable	Paper	2.9 (0.07)	400 (200)	—
R3389B	Blue	Repulpable Splittable Flying Splice Tape for heavyweight papers in manual and automatic splicing equipment for high speed splicing conditions when high tack is required and to compensate for roll profile issues; Additional blue color on the backside.	7.0 (0.16)	Paper	Repulpable	Paper	2.9 (0.07)	400 (200)	—

<sup>†</sup>All components of the adhesive and backing meet the requirements of indirect food additive regulations as described under 21 CFR 176.170 (Components of paper and paperboard in contact with aqueous and fatty food) and 21 CFR 176.180 (Components of paper and paperboard in contact with dry foods).

\*Food Contact Notification issued by FDA.

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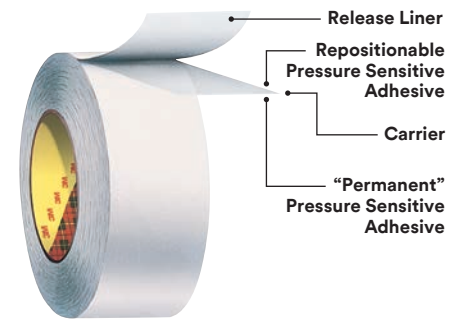
## 3M™ Splicing Aids

### Technology for knife cut signaling, core starting and more

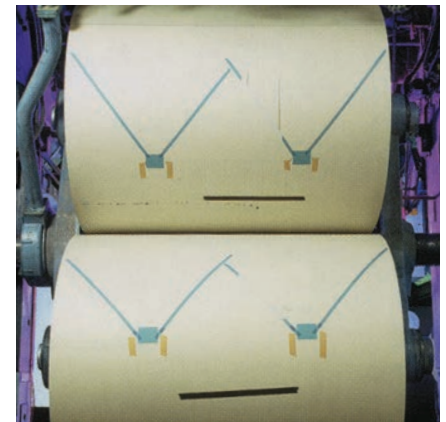
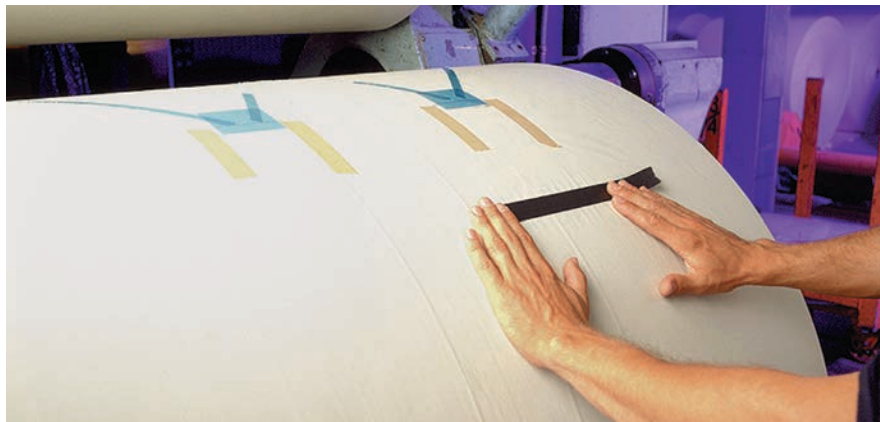
Building on the wide variety of adhesives and backings, 3M has developed specialized tapes for splicing and other web process aids.

For example, black crepe paper tape conforms to the roll and signals the knife cut during the splicing process.

For reusing cores, double coated removable/repositionable tape features a permanent adhesive on one side of a carrier that bonds permanently to the core. Adhesive strength on the other side of the carrier holds paper and film with enough strength for reliable wind-up but easy release when unwinding.



High tack side of 3M™ Removable/Repositionable Tape 9415PC permanently adheres to the core. Low tack side holds paper or film for wind-up, yet releases when needed during unwinding.



To mark a roll with opaque black crepe tape to signal a knife cut during a splicing operation, you can select either the 5.6 mil thick 3M™ Crepe Masking Tape 2510 or the 7.0 mil thick 3M™ Photographic Light Blocking Tape 235. With conformable backing and rubber adhesive, both tapes hold securely at full operating speeds.

Product Number	Color	Adhesive Type	Backing Material	Total Thickness mils (mm)	Liner	Maximum Operating Temperature °F (°C)	Comments
<b>Based on ASTM Test Method:</b>							
<b>Single Coated Tapes</b>							
235	Black	Rubber	Crepe Paper	7.0 (0.18)	None	200 (93)	Photographic light blocking tape.
2510	Black	Rubber	Crepe Paper	5.6 (0.14)	None	200 (93) for 1 hr	For marking and light blocking.
<b>Double Coated Tapes</b>							
9030	Blue	High Tack Repulpable	Tissue Carrier	3.0 (0.075)	Semi-bleached kraft	400 (204)	Nose tabs for quick grab to newsprint.
9415PC	Translucent	1000 (repositionable) adhesive on one side; 400 (permanent) on the other side	PET Carrier	2.0 (0.05)	78# PCK	180 (82)	Removable/repositionable tape for core starting and roll tabbing.
9425	Clear	1050 (repositionable) adhesive on one side; 420 (permanent) on the other side	UPVC Film Carrier	5.5 (0.14)	58# PCK	125 (52)	

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## Scotch® and Tartan™ Box Sealing Tapes

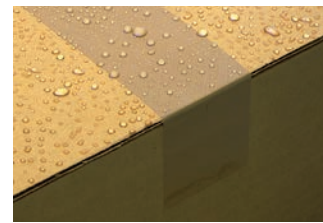
### Built tough for dependability

With choices of polyester or polypropylene backings and synthetic rubber or acrylic adhesives, you have dependability for a wide variety of box types, sizes, contents, handling situations and storage conditions.

- Reliability even with the stresses of over packed or under packed boxes
- Quick, easy application by hand, manual dispensers or 3M-Matic™ Case Sealers
- Choice of lengths, widths and colors to meet specific needs
- Scotch® Recycled Corrugate Tapes are made with a proprietary adhesive designed specifically for recycled corrugate cartons
- Specialty tapes add specialized form and/or functional properties for specific applications across all markets



Scotch® Box Sealing Tapes with polyester backing and synthetic rubber adhesive resist the moisture in storage and shipping.



Consistent quality of Scotch® Box Sealing Tapes means fewer interruptions on your packaging line.



Scotch® Box Sealing Tape 3779 alerts receivers to unauthorized opening with a red “Check Seal Before Accepting”.

Product Number	Tape Structure (Backing/Adhesive)	Adhesion to Steel oz./in. (N/100 mm)	Tensile Strength lbs./in. (N/100 mm)	Elongation at Break (%)	Backing Thickness mils (mm)	Total Thickness mils (mm)	Available Colors/Comments
<b>ASTM Test Method</b>		<b>D-3330</b>	<b>D-3759</b>	<b>D-3759</b>	<b>D-3652</b>	<b>D-3652</b>	
<b>Scotch® Box Sealing Tapes</b>							
311	Polypropylene/Acrylic	22 (24)	25 (438)	125	1.1 (.028)	2.05 (.052)	Clear, Tan, Red, Yellow, Blue, White
313	Polypropylene/Acrylic	32 (35)	35 (613)	125	1.6 (.041)	2.55 (.065)	Clear, Tan
353	Polyester/Synthetic Rubber	45 (49)	25 (437)	110	1.0 (.025)	1.9 (.048)	Clear, Tan
355	Polyester/Synthetic Rubber	78 (85)	67 (1174)	130	2.0 (.051)	3.43 (.089)	Clear, Tan or Custom Printed
371	Polypropylene/Synthetic Rubber	40 (44)	22 (385)	160	1.2 (.030)	1.8 (.046)	Clear, Tan, Blue, Green, Orange, Red, White, Yellow or Custom Printed
372	Polypropylene/Synthetic Rubber	45 (49)	26 (455)	160	1.4 (.035)	2.2 (.056)	Clear, Tan or Custom Printed
373	Polypropylene/Synthetic Rubber	50 (55)	30 (525)	160	1.6 (.041)	2.5 (.064)	Clear, Tan, Blue, Green, Orange, Red, White, Yellow or Custom Printed
375	Polypropylene/Synthetic Rubber	55 (60)	35 (613)	160	2.0 (.051)	3.1 (.079)	Clear, Tan or Custom Printed
<b>Scotch® Recycled Corrugate Tapes</b>							
3071	Polypropylene/Synthetic Rubber	45 (49)	22 (385)	160	1.2 (.030)	2.1 (.053)	For use on recycled corrugate cartons, Custom Printed
3072	Polypropylene/Synthetic Rubber	65 (71)	22 (385)	160	1.2 (.030)	2.3 (.058)	For use on recycled corrugate cartons, Custom Printed
3073	Polypropylene/Synthetic Rubber	46 (50)	30 (525)	160	1.6 (.041)	2.6 (.066)	For use on recycled corrugate cartons, Custom Printed, 10% bio-based content
<b>Tartan™ Box Sealing Tapes</b>							
302	Polypropylene/Acrylic	18 (20)	23 (402)	116	1.0 (.025)	1.6 (.040)	Clear, Tan
305	Polypropylene/Acrylic	18 (20)	21 (368)	116	1.0 (.025)	1.8 (.046)	Clear, Tan
369	Polypropylene/Synthetic Rubber	30 (32)	19 (333)	160	1.0 (.025)	1.6 (.041)	Clear, Tan
<b>Custom Printed Tapes</b>							
355CP	Polyester/Synthetic Rubber	78 (85)	67 (1174)	130	2.0 (.051)	3.42 (.089)	Clear, Tan
<b>Security Tapes</b>							
3199	Polypropylene/Acrylic	22 (24)	25 (438)	125	1.1 (.028)	2.05 (.052)	Clear with Red Type: CHECK SEAL BEFORE ACCEPTING Tan with Red Type: IF SEAL IS BROKEN CHECK CONTENTS BEFORE ACCEPTING
3732	Polypropylene/Synthetic Rubber	50 (55)	30 (525)	160	1.6 (.041)	2.5 (.064)	Clear with Red Type: CHECK SEAL BEFORE ACCEPTING
3779	Polypropylene/Synthetic Rubber	40 (44)	22 (385)	160	1.2 (.030)	1.8 (.046)	Clear with Red Type: CHECK SEAL BEFORE ACCEPTING

Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.

# Scotch® Tape Dispensers

## Easy dispensing for manufacturing, office, commercial and retail jobs

All Scotch® Manual Dispensers for box sealing tapes, filament tapes, film tapes, label protection tapes and pouch tapes are application-designed to meet the needs of the customer. Select from a variety of hand-held and heavy duty pull-and-tear table top dispensers.



Hand-held dispensers for use with specially formulated Scotch® Box Sealing Tapes.



Portable, lightweight, easy to operate, hand-held dispenser with a retractable blade.



A hand-held, roll-on, pistol-grip dispenser designed to reduce the noise of tape unwind.



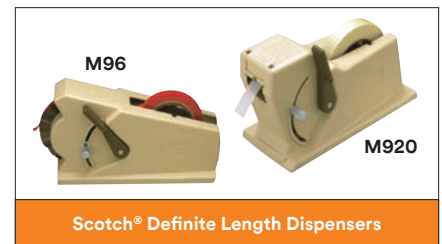
Hand-held dispensers for use with Scotch® High Strength Filament Tapes.



Manual heavy-duty dispensers for use with 3M™ Narrow Width Film Tapes.



Dispenser for pull and tear of up to 6 inches total width of tapes. P56W offers weighted base.



Dispensers that deliver a uniform length of 3M™ Narrow Width Tape and Scotch® Filament Tapes every time quickly and easily.

Product Number	Product Description	Max Tape Width
<b>Hand-Held Box Sealing Tape Dispensers</b>		
H100	Durable, lightweight, plastic tape dispenser	50.8mm
H122	Durable plastic dispenser with built-in brake for precise seals	48mm
H123	Lightweight, compact metal tape dispenser	72mm
H128	Heavy-duty durable metal tape dispenser	48mm
H129	Quick and easy one hand method to apply, cut, and buff the tape closures	48mm
H150	Tape dispenser designed to reduce the noise of tape unwind during application	48mm
H180	Portable and easy to operate pistol grip dispenser	48mm
H183	Portable and easy to operate pistol grip dispenser	72mm
H190	Pistol grip dispenser features pull apart design	48mm
H192	Ergonomical tape dispenser with hand brake	48mm
H320	Ultra-light, economical, plastic tape dispenser	48mm
H1755	Lightweight, pistol grip tape dispenser	48mm
HB903	Economical pistol grip tape dispenser	48mm
HR80	Portable, lightweight, easy to operate, dispenser with a retractable blade	48mm
HR83	Tape dispenser with a retractable blade	72mm
<b>Table Top Dispensers</b>		
C22	Weighted dispenser for easy pull and cut tape dispensing	2 in.
M96	Definite length dispenser — dispenses tape in lengths of 3/4 in. to 5 in. per stroke	1 in.
M920	Definite length dispenser — dispenses tape in lengths of 1/2 in. to 4 in. per stroke	1 in.
P56	Mainline tabletop manual pull and cut dispenser with multiple roll capacity	6 in.
P56W	Mainline tabletop manual pull and cut dispenser with multiple roll capacity (comes with weighted base)	6 in.

Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.



# 3M-Matic™ Case Sealers

## Adjustable case sealers

With quick manual height and width adjustment, these rugged units reliably and accurately seal runs of the same size cartons.




## Random Case Sealers

Adjusting height and width automatically, these rugged units reliably and accurately seal runs of random size cartons.

**200a\***


- Up to 40 cs/min
- Up to 85 lbs
- Bottom belt drive



3M-Matic™ Case Sealer 200a is an adjustable bottom belt drive case sealer to dependably seal uniform cases at up to 40 per minute.

**7000a Pro\***


- Up to 40 cs/min
- Up to 85 lbs
- Top and bottom belt drives



3M-Matic™ Adjustable Case Sealer 7000a Pro is an adjustable top and bottom belt drive to dependably seal uniform cases at up to 40 cases per minute.

**8000a\***

- Up to 40 cs/min
- Up to 85 lbs
- Side belt drives



3M-Matic™ Side Belt Adjustable Case Sealer 8000a is an adjustable side belt drive case sealer. Seals up to 40 cases per minute, using tape widths from 36mm to 48mm, and also 72mm tape.

**7000r Pro\***

- Up to 24 cs/min
- Up to 85 lbs
- Top and bottom belt drives



3M-Matic™ Random Case Sealer 7000r Pro is a semi-automatic random case sealer that automatically adjusts for case height and width and is capable of sealing 24 cases per minute, using tape widths from 36mm to 48mm wide.

Machine	Drive System	Box Size Capacity (inches)						Power Requirements		Operating Rate (cs/min)	Belt-Drive Speed ft/min (m/s)	Taping Head	Comments
		Minimum			Maximum			Electrical	Air				
<b>Adjustable Case Sealer — Bottom Belt Drive Systems</b>													
200a	Bottom	6.0	6.5	4.5 [3.75]	N/L	21.5	24.5 [28.5]	115VAC 60Hz 1.9A 220W	No Air	Up to 40	100 (0,5)	2" 3M™ AccuGlide™ 3	Semi-Automatic Adjustable.
<b>Adjustable Case Sealer — Top and Bottom Belt Drive Systems</b>													
7000a Pro	Top and Bottom	6.0	6.5	2.0	N/L	26.5	28.0	115VAC 60Hz 3.8A 440W	No Air	Up to 40	100 (0,5)	2" 3M™ AccuGlide™ 3	
<b>Adjustable Case Sealer — Side Belt Drive Systems</b>													
8000a	Side	6.0	4.5	3.75	N/L	21.5	27.25	115VAC 60Hz 3.8A 440W	No Air	Up to 40	100 (0,5)	2" 3M™ AccuGlide™ 3	Extended size capabilities are possible, please contact 3M.
<b>Random Case Sealer — Top and Bottom Belt Drive Systems</b>													
7000r Pro	Top and Bottom	6.0	6.5	2.25	N/L	26.5	26.0	115VAC 60Hz 3.8A 440W	3.75 SCFM @ 85 PSIG	Up to 24	100 (0,5)	2" 3M™ AccuGlide™ 3	

Standard size capabilities are listed above. If additional sizes can be met, they are indicated by [Taping Head] or [Machine Configuration]. Changing the taping head or machine configuration will allow for enhanced box height range indicated in the chart above. Please refer to the Instructions and Parts List or 3M representative for more detail.

\*Available with 3 in. taping head.

## 3M™ AccuGlide™ Taping Head Technology

### 3M taping heads for easy and accurate case sealing

3M™ AccuGlide™ Taping Heads are patented with a curvilinear design that applies tape securely with low impact that helps protect even lightweight cartons and contents.

#### 3M™ AccuGlide™ 3

Raising the speed limit to 100 ft. per minute for easy, consistent and accurate case sealing.



Note: The technical information and data should be considered representative or typical only and should not be used for specification purposes.

# 3M™ Aerosol Products

## Convenience and a fistful of work power for maintenance and production

In thousands of factories and plants, these aerosol products are proven daily to save time and effort in maintenance and production. Bonding, lubricating, cleaning, inhibiting rust, and other tough jobs become finger-touch easy.

Compact container fits in a tool box to go readily to any job site and can help you reduce storage space and cost. With targeted application you get more usable product for your money.

3M aerosol chemicals contain no methylene chloride, chlorofluorocarbons (CFCs) or 1,1,1-trichloroethane (methyl chloroform).



With 3M™ Super 77™ Multipurpose Spray Adhesive, you have fast tack, long bonding range, and little or no soak-in for bonding many lightweight materials including papers, labels, plastics, foils, foam, insulation, fabric, cardboard, and light gauge metal.



For fast, easy cleanup of gears, 3M™ Citrus Base Cleaner helps soften and loosen grease, oil and grime. After using this heavy-duty degreaser/cleaner, just wipe away with a shop towel.



3M™ Silicone Spray Low VOC 60% lubricates cutting tools and tables. Fast, easy application helps prevent buildup of adhesive, wax, inks and paints. Won't stain or become gummy.

## 3M™ Aerosol Products

Product	Key Characteristics	Available Format	Color	Application Method	Spray Pattern	VOC Content
<b>Aerosol Adhesives</b>						
Super 77™	Low soak-in for long lasting bond. High coverage and aggressive tack. Bonds quickly in 15 seconds.	Aerosol	Clear	Spray	Mist	54%
		5 gallon, 52 gallon	Clear	Brush/Roll/Spray	Mist	504g/L
		Large Cylinder	Clear	Spray	Mist	535g/L
Super 77™ CA Multi-Purpose (Low VOC)	Aggressive tack. Quick bonding. Long bonding range. Meets CARB/OTC VOC Requirements. Helps contribute to LEED® credits.	Aerosol	Clear	Spray	Mist	<25%
Multi-Purpose 27	Fast tack. Lightweight applications.	Aerosol	Clear	Spray	Mist	59%
<b>Aerosol Chemicals</b>						
Adhesive Remover	Citrus based. Fast acting. No residue left behind.	1 gallon, 5 gallon, 52 gallon	Pale Yellow	Brush/Roll/Spray	Mist	840g/L
		5 oz. Aerosol	Pale Yellow	Spray	Mist	100%
		18.5 oz. Aerosol	Pale Yellow	Spray	Mist	100%
		Mini Cylinder	Pale Yellow	Spray	Mist	800g/L
Adhesive Remover — Low VOC <20% Clear	Extended dwell time. No residual film. Meets CARB/OTC VOC Requirements. Helps contribute to LEED® credits.	Aerosol	Clear	Spray	Mist	15%
Citrus Base Cleaner	Citrus based. Non-corrosive. Cleans oil, grease, tar and grime.	Aerosol	Transparent	Spray	Mist	91%
Silicone Spray 60% VOC	Excellent lubricant. Fast drying. Long lasting and non-staining.	Aerosol	Clear	Spray	Mist	60%
5-Way Penetrant	Drives out moisture. Frees rusted bolts. Inhibits rust — lubricates, demoisturizes, inhibits corrosion, cleans and penetrates.	Aerosol	Amber	Spray	Mist	30%
Silicone Lubricant	Excellent lubricant. Fast Drying. Long-lasting and non-staining.	Aerosol	Clear	Spray	Mist	95%

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# 3M™ Duct Tapes

## Dependability and versatility for bundling, sealing, reinforcing and more

This family of rugged duct tapes adheres to most surfaces for applications ranging from bundling to moisture proofing, sealing to splicing, reinforcing to hanging poly drapes. Features include:

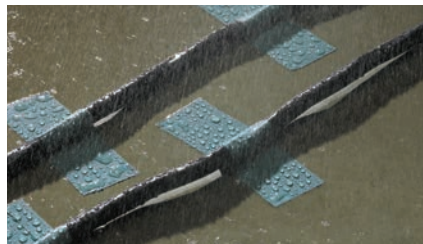
- Hand tearable
- High tensile strength
- Conformability



3M™ Duct Tapes are available in a variety of colors for color coding. A range of widths provides choices in coverage from 24mm to 22 inches.



For a tight seal in many containment situations, 3M™ Performance Plus Duct Tape 8979 attaches heavy poly draping, closes cuffs, and then removes cleanly when the job is finished.



Waterproof backing of 3M™ Performance Plus Duct Tape 8979 resists moisture and rain for up to a year.



For bundling a wide variety of items, 3M™ Duct Tapes with natural rubber adhesive and high tensile strength backings adhere on contact and hold securely. Write on the tape surface with pen or marker to leave a reminder or mark and identify works-in-progress, components, items bundled and more.

## 3M™ Duct Tapes

Product Number	Color	Adhesive Type	Backing Material	Thickness mils (mm)	Adhesion to Steel oz/in (N/100 mm)	Tensile Strength lb/in (N/100mm)	Elongation at Break %	Maximum Operating Temperature °F (°C)	Meets Specifications	Comments
Based on ASTM Test Method:				D-3652	D-3330	D-3759	D-3759			
<b>Clean Removal Duct Tapes</b>										
8979	Blue, Black, Olive	Rubber	Polyethylene Over Cloth Scrim	12.1 (0.31)	48 (53)	36 (630)	19	200 (93)	UL 723/ASTM E84	Up to six months clean removal from most opaque surfaces indoors and outdoors.
<b>Professional Grade Duct Tapes</b>										
3900	Black, Blue, Olive, Red, Silver, White, Yellow	Rubber	Polyethylene Over Cloth Scrim	7.6 (0.19)	53 (58)	28 (490)	19	200 (93)	—	General purpose duct tape, temporary repairs, color-coding.
3939	Silver	Rubber	Polyethylene Over Cloth Scrim	8.6 (0.22)	58 (63)	27 (472)	17	200 (93)	UL 723/ASTM E84	Use for demanding duct tape applications.
DT11	Silver, Black	Natural Rubber	Polyethylene Over Cloth Scrim	11.0 (0.27)	58 (63.4)	35 (613)	12	200 (93)	—	Provides easy tear and good conformability. Great for holding, sealing and packaging.
DT17	Black	Natural Rubber	Polyethylene Over Cloth Scrim	17.0 (0.43)	69 (75.5)	41 (718)	13	150 (65)	—	Provides easy tear and good conformability. Great for seaming applications, repair bottom boards and protecting various surfaces.
<b>Utility Duct Tapes</b>										
DT8	Silver	Synthetic Rubber	Polyethylene Over Cloth Scrim	8.0 (0.20)	100 (109.4)	31 (542)	21	200 (93)	—	Provides easy tear and good conformability. Great for sticking to metal, glass, plastic and sealed concrete.
2929	Silver	Rubber	Polyethylene Over Cloth Scrim	5.5 (0.14)	45 (49)	19 (333)	14	200 (93)	—	Utility grade duct tape for temporary repairs, sealing, holding and marking.

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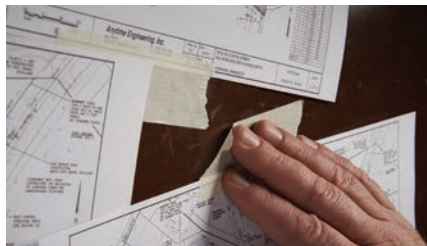


# 3M™ Masking Tapes — Crepe Paper

## Holding power and removal the way you want

In this simplified line, you will find a range of such characteristics as adhesive holding power, line sharpness, and clean removal to meet different application requirements for virtually every industrial and consumer application. 3M products also feature:

- Instant adhesion at a touch
- Easy tear without stretching or pulling
- Controlled unwind...not too easy or too hard
- Conformability to stretch and adhere around curves



Use 3M™ Value Masking Tape 101+ for light-duty attaching.



Use 3M™ General Masking Tape 201+ to quickly bundle parts.



3M™ Performance Yellow Masking Tape 301+ is ideal for labeling and identifying applications.

## 3M™ Masking Tapes — Crepe Paper

Product Number	Color	Adhesive Type	Backing Material	Total Thickness mils (mm)	Adhesion to Steel oz./in (N/100 mm)	Tensile Strength lb./in (N/100 mm)	Elongation at Break %	Maximum Operating Temperature °F (°C)	Time at Maximum Temperature (minutes)	Can be Certified to Specification	Industrial Cross Reference	Comments
<b>ASTM Test Method:</b>				D-3652	D-3330	D-3759	D-3759					
<b>Industrial Masking Tapes</b>												
101+	Tan	Rubber	Crepe Paper	5.1 (0.13)	34 (37)	22 (385)	9	150 (66)	30	—	2214	Indoor use. Light-duty applications.
201+	Tan	Solvent-Free Rubber	Crepe Paper	4.4 (0.11)	25 (27)	19 (333)	8	200 (93)	30	—	200, 203	General indoor use. Light-to-medium duty. Clean removal.
301+	Yellow	Solvent-Free Rubber	Crepe Paper	6.3 (0.16)	30 (33)	22 (385)	12	225 (107)	30	—	2307, 2308	Good conformability to irregular surfaces. Good paint lines.
401+	Green	Solvent-Free Rubber	Crepe Paper	6.7 (0.17)	36 (39)	25 (438)	10	250 (121)	30	—	—	Highly conformable to many surfaces. Superior adhesion to metal, rubber, glass and plastic. Great paint lines.
501+	Purple	High Temperature Rubber	Crepe Paper Treated with a Heat Resistant Saturant	7.3 (0.185)	37 (40)	31 (543)	11	300 (149)	30	—	231, 2693	Exceptionally conformable to irregular surfaces. Superior adhesion to metal, rubber, glass and plastic. Removes cleanly in one piece with no residue. Great paint lines.

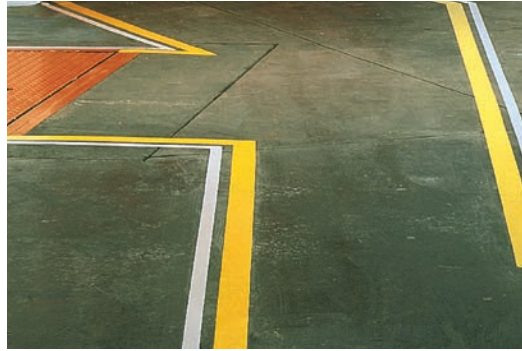
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# 3M™ Vinyl and Polyethylene Tapes

## Mark, identify, color-code, seal seams and more

These rugged tapes adhere aggressively and remove cleanly from most surfaces for a wide variety of applications in Automotive, MRO (Maintenance and Repair), Construction, Marine, Commercial Vehicle and other industries.

- “Color throughout” construction resists scrapes, wear, weathering and chemicals
- Wide variety of colors plus transparent
- Flexible backing with aggressive adhesive bonds, conforms and seals even on irregular surfaces
- Removes cleanly without leaving adhesive behind to clean up
- Stretches to mold to contours



3M™ Vinyl Tapes clearly mark lanes, corridors and hazardous or no-go areas in factories, warehouses and hospitals. Durable vinyl backing resists abrasion, scuffing, moisture, weathering, acids and alkaline chemicals for long service life.



Red 3M™ Vinyl Tape immediately identifies fire protection equipment and apparatus, including fire extinguishers, alarm boxes and blanket boxes.



To highlight low hanging objects, protruding equipment, or steps, 3M™ Vinyl Tape 5702 combines yellow and black for a striped combination that calls for attention.



Orange 3M™ Vinyl Tape identifies dangerous machine parts that may cause injury when enclosure doors are open or guards removed.

## 3M™ Vinyl Tapes

Product Number	Color	Adhesive Type	Backing Material	Backing Thickness mils (mm)	Total Thickness mils (mm)	Adhesion to Steel oz./in. (N/100 mm)	Tensile Strength lb./in. (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)	Comments
<b>Premium Performance Vinyl Tapes</b>										
471	Various	Rubber	Vinyl	4.1 (0.10)	5.2 (0.13)	26 (28)	14 (270)	150	40 to 170 (4 to 77)	Conformable and clean removal. Black, Blue, Brown, Green, Orange, Purple, Red, Transparent, White, Yellow. MIL-STD 2041D (SH).
4712	Various	Rubber	Vinyl	4.1 (0.10)	5.2 (0.13)	23 (25)	14 (270)	150	40 to 170 (4 to 77)	Lined version of 471 tape. MIL-STD 2041D (SH). Colors same as 471.
471+	Indigo	Rubber	Vinyl	4.1 (0.10)	5.3 (0.13)	35 (38.3)	13.9 (243)	191	Up to 250 (Up to 121)	Superior conformability, sharp paint lines, clean removal.
472	Black	Rubber	Vinyl	9.0 (0.23)	10.4 (0.26)	23 (25)	32 (560)	270	Up to 225 (Up to 107)	Abrasion and high temperature resistant.
477	Transparent	Rubber	Vinyl	6.0 (0.15)	7.2 (0.18)	24 (26)	24 (420)	230	40 to 170 (4 to 77)	Abrasion resistant.
<b>General Purpose Vinyl Tapes</b>										
764	Various	Rubber	Vinyl	4.1 (0.10)	5.0 (0.13)	18 (21)	13 (228)	180	60 to 85 (15 to 27)	Non-critical applications. Black, Blue, Brown, Gray, Green, Orange, Purple, Red, Transparent, White, Yellow.
<b>Safety Stripe Tapes</b>										
5700	Black/White	Rubber	Vinyl	4.2 (0.11)	5.5 (0.14)	19 (21)	15 (260)	170	40 to 170 (4 to 77)	Critical applications. Adhesive side printing for long-life.
5702	Black/Yellow	Rubber	Vinyl	4.2 (0.11)	5.5 (0.14)	19 (21)	15 (260)	170	40 to 170 (4 to 77)	Critical applications. Adhesive side printing for long-life.
766	Black/Yellow	Rubber	Vinyl	4.1 (0.10)	5.0 (0.13)	18 (21)	13 (228)	180	60 to 85 (15 to 27)	Non-critical marking applications.
767	Red/White	Rubber	Vinyl	4.1 (0.10)	5.0 (0.13)	18 (21)	13 (228)	180	60 to 85 (15 to 27)	Non-critical marking applications.

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## 3M™ Scotch-Weld™ Threadlockers

3M™ Scotch-Weld™ Threadlockers offer a range of products including temporary, permanent and high temperature resistance. These adhesives conform to most industry recognized standards for torque and strength.



Product Number	Color	Key Features	Typical Viscosity (cps)	Temperature Range °F (°C)	Time to Handling	Full Cure
TL22	Purple	Screwlock. Low removal torque fasteners less than a 1/4" (6mm).	1,200	-65 to 300 (-54 to 149)	< 20 minutes	24 hours
TL42	Blue	Nutlock. Medium strength. General purpose.	1,200	-65 to 300 (-54 to 149)	< 20 minutes	24 hours
TL43	Blue	Oil tolerant. Medium strength. General purpose.	3,300	-65 to 300 (-54 to 149)	< 20 minutes	24 hours
TL62	Red	Studlock. High strength with controlled torque tension.	1,600	-65 to 300 (-54 to 149)	< 20 minutes	24 hours
TL71	Red	Permanent studlock for bolts and studs up to 1" (25mm).	500	-65 to 300 (-54 to 149)	< 20 minutes	24 hours
TL72	Red	High temperature studlock with gap filling for larger diameter coarse threaded parts.	7,000	-65 to 450 (-54 to 232)	< 20 minutes	24 hours
TL77	Red	Heavy duty permanent for fasteners up to 1.5" (38mm) with coarse threads.	7,000	-65 to 300 (-54 to 149)	< 20 minutes	24 hours
TL90	Green	Penetrating adhesive for pre-assembled fasteners and porosity sealing of welds.	20	-65 to 300 (-54 to 149)	< 20 minutes	24 hours

## 3M™ Concrete Repair Products

**Fast, convenient crack and spall repair, expansion joints, custom threading and anchoring, and more**

Repairs are long lasting with strong, flexible bonds that resist weathering, expansion and contraction.

Fast setting allows you and your customers to drive on repaired surfaces in as few as five minutes. You can choose non-sag or self-leveling formulations for repairs on both vertical and horizontal surfaces. Non-sag formulation facilitates step and ledge repair.



50mL and 400mL duo-pak cartridges are available to meet your production volume requirements. Nozzle automatically and precisely meters, mixes, and dispenses two-part urethane formulation. Apply material precisely where needed to conserve material.

Product	Size	Description	Work Life	Initial Cure	Full Cure
DP600 Gray Self-Leveling	400mL	Repair of cracks or spalls and setting anchors in floors or horizontal surfaces.	70 seconds	5 minutes	1 hour
DP600 Gray Non-Sag	400mL	Repair of cracks in walls and setting anchors in vertical surface. Repair chipped or broken steps and ledges.	50 seconds	4 minutes	1 hour
Concrete Repair 600 Gray Self-Leveling	8.4 fl. oz.	Flows smoothly into cleaned cracks and gaps. Hardens in as little as 5 minutes. Use in common caulking guns.	70 seconds	5 minutes	1 hour
DP5106 Gray	400mL	Helps relieve stress in large segments of concrete floors.	4 minutes	40 minutes	24 hour
Manual Dispenser 98073	400mL	Heavy-duty applicator.	n/a	n/a	n/a

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