

**3M Type 200 Transfer Tapes**

No. **467MP** (2.0 mil thickness)

No. **468MP** (5.0 mil thickness)

3M No. 467 and 468 Laminating Adhesives with #200 Hi-Performance Acrylic Adhesive are designed for the attachment of name plates to a variety of products. They have a high bond strength, are long lasting and have excellent temperature and chemical resistance.

**Environmental Performance:**

**Bond Build-Up:** The bond strength increases as a function of time and temperature.

**Humidity Resistance:** High humidity has a minimal effect on adhesive performance. Bond strengths are generally higher after exposure for 7 days at 38°C (100°F) and 100% relative humidity.

**U.V. Resistance:** Ultraviolet light has very little effect on the adhesion performance. Bond strengths are generally higher after exposure to 1 year of Florida sunlight.

**Water resistance:** Immersion in water has no appreciable effect on the bond strength. After 100 hours in 65°C (150°F) water, the bond actually shows an increase in strength.

**Chemical Resistance:** When properly applied, data plates will hold securely after exposure to numerous chemicals including gasoline, oil, kerosene, JP4 fuel, grease, mild acids and alkalies and most aromatic and aliphatic solvents.

**Heat Resistance:** The #200 adhesive is serviceable for short periods (minutes, hours) at temperatures up to 177°C (350°F) and for intermittent longer exposure (days, weeks) up to 121°C (250°F).

**Application Techniques**

For bond strength of data plates, the surface should be cleaned and dried. A typical cleaning solvent is Heptane or Isopropyl alcohol. Consult solvent manufacturers MSDS for proper handling and storage instructions.

It is necessary to provide pressure during application to allow the adhesive to come in contact with the substrate. Heat can increase bond strength to metal parts (generally the same increase is observed at room temperature over time).

The ideal adhesive application temperature range is 21°C (70°F) to 38°C (100°F). Application is not recommended if the surface temperature is below 10°C (50°F) because the adhesive becomes too firm to adhere readily. Once properly applied at the recommended application temperature, low temperature holding is generally satisfactory.

When bonding to a smooth surface, it is generally acceptable to use 2 mils of adhesive. If a texture is visible, the 5 mil adhesive is recommended.

**3M Type 300 Transfer Tapes**

No. **9471** (2.0 mil thickness)

No. **9472** (5.0 mil thickness)

3M #300 Adhesive offers excellent adhesion to a wide variety of surfaces, including metals, low surface energy plastics (Polypropylene) and high surface energy plastics (Polycarbonate).

**Environmental Performance:**

**Bond Build-Up:** The bond strength increases as a function of time and temperature and has a very high initial adhesion.

**Humidity Resistance:** High humidity has a minimal effect on adhesive performance. Bond strengths are generally higher after exposure for 7 days at 32°C (90°F) and 90% relative humidity.

**U.V. Resistance:** When properly applied, data plates are not adversely effected by exposure.

**Water resistance:** Immersion in water has no appreciable effect on the bond strength. After 100 hours at room temperature, the bond actually shows an increase in strength.

**Chemical Resistance:** When properly applied, data plates will hold securely after exposure to numerous chemicals including oil, mild acids and alkalies.

**Heat Resistance:** The #300 adhesive is usable for short periods (minutes, hours) at temperatures up to 121°C (250°F) and intermittent longer periods of time (days, weeks) up to 66°C (150°F).

**Application Techniques**

For maximum bond strength of data plates, the surface should be thoroughly cleaned and dried. Typical cleaning solvents are Heptane (for oil surfaces) or Isopropyl alcohol (for plastics). Use reagent grade solvents since common household materials like rubbing alcohol frequently contain oils to minimize the drying effect on skin. These oils can interfere with the performance of a pressure-sensitive adhesive. Consult solvent manufacturers MSDS for proper handling and storage instructions. Also, use disposable wipes that do not contain oils to remove cleaning solvents.

It is necessary to provide pressure during application to allow the adhesive to come in direct contact with the substrate. Heat can increase bond strength to metal parts (generally the same increase is observed at room temperature over time). For plastic parts, the bond strength is not enhanced with the addition of heat.

The ideal adhesive application temperature range is 21°C (70°F) to 38°C (100°F). Application is not recommended if the surface temperature is below 10°C (50°F) because the adhesive becomes too firm to adhere readily. Once properly applied at the recommended application temperature, low temperature holding is generally satisfactory.

When bonding to a smooth surface, it is generally acceptable to use 2 mils of adhesive. If a texture is visible, the 5 mil adhesive is recommended.

**3M Type 300 Transfer Tapes**

No. **9471LE** (2.0 mil thickness)

No. **9472LE** (5.0 mil thickness)

3M High Strength Acrylic Adhesive 300LSE provides very high bond strength to most surfaces, including low surface energy plastics such as Polypropylene and Powder Coatings. Excellent adhesion to lightly oiled surfaces typical of machine parts.

**Environmental Performance:**

**Bond Build-Up:** The bond strength increases as a function of time and temperature and has a very high initial adhesion.

**Humidity Resistance:** High humidity has a minimal effect on adhesive performance. Bond strengths are generally higher after exposure for 7 days at 32°C (90°F) and 90% relative humidity.

**U.V. Resistance:** When properly applied, data plates are not adversely effected by exposure.

**Water resistance:** Immersion in water has no appreciable effect on the bond strength. After 100 hours at room temperature, the bond actually shows an increase in strength.

**Chemical Resistance:** When properly applied, data plates will hold securely after exposure to numerous chemicals including oil, mild acids and alkalies.

**Heat Resistance:** The Adhesive 300LSE is usable for short periods (minutes, hours) at temperatures up to 148°C (300°F) and intermittent longer periods of time (days, weeks) up to 93°C (200°F).

**Application Techniques**

For maximum bond strength of data plates, the surface should be thoroughly cleaned and dried. Typical cleaning solvents are Heptane or Isopropyl alcohol for plastics. Consult solvent manufacturers MSDS for proper handling and storage instructions.

It is necessary to provide pressure during application to allow the adhesive to come in direct contact with the substrate. Heat can increase bond strength when bonding to metal parts (generally the same increase is observed at room temperature over longer times). For plastic parts, the bond strength is not enhanced with the addition of heat.

The ideal adhesive application temperature range is 21°C (70°F) to 38°C (100°F). Application is not recommended if the surface temperature is below 10°C (50°F) because the adhesive becomes too firm to adhere readily. Once properly applied at the recommended application temperature, low temperature holding is generally satisfactory.

When bonding to a smooth surface, it is generally acceptable to use 2 mils of adhesive. If a texture is visible, the 5 mil adhesive is recommended.