



468MP Transfer Tape

Product Data Sheet

Updated : April 2004
Supersedes : November 2001

Product Description

A-30 is a firm acrylic pressure-sensitive adhesive system. It features high ultimate bond strength with excellent high temperature performance and excellent

solvent resistance. Bond strength increases substantially with natural ageing.

468 is a long ageing and resistant product used extensively by the nameplate industry.

Physical Properties

Not for specification purposes

Adhesive Type	Firm Acrylic	3M ref : A-30
Thickness (ASTM D-3652) Tape Liner Total	130 µm 5 Thou 100 µm 230 µm	
Release Liner	Tan printed polycoated paper.	
Tape Colour	Clear	
Shelf Life	24 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	7.6 N/10mm	
Shear Resistance	High	
Temperature Performance Max : Minutes / Hours Max : Days / Weeks Minimum	204 °C 149 °C -30 °C	
Solvent Resistance	Excellent. When the adhesive is properly applied to impervious materials, it will resist solvent attack and adhesive softening through edge contact with mild acids and alkalines, oils, grease, gasoline kerosene, JP-4 fuel, and many other standard aromatic and aliphatic solvents. However, it is not recommended for uses where continuous immersion is required.	

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Performance Characteristics (Cont..) Not for specification purposes	UV Light Resistance	Excellent. Will not oxidise when exposed to air or sunlight UV.
	Water Resistance	Excellent. There are no evident adverse effects on the bond of properly applied materials after immersion in 21°C water for about 100 hours.

Additional Product Information	468MP is designed with a moisture resistant release liner which resists cockling or wrinkling from high humidity. Hi Performance No 468 is printed on the liner.	The 130 micron thick adhesive is ideally suited for joining materials that are relatively rough or thick materials with a small degree of residual stress. The peel strength of 468MP	is typically 30% higher than the 50 micron thick adhesive when measured on the same flat surface. It can be many times higher on embossed or textured surfaces.
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Application Techniques	<p>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.</p> <p>2. To obtain optimum adhesion, the bonding</p>	<p>surfaces must be clean dry and well unified. A typical surface cleaning solvent is isopropyl alcohol & water. Use proper safety precautions for handling solvents.</p> <p>3. Ideal tape application temperature range is 21°C to 38°C (70°F to 100°F).</p>	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.
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Applications	468MP is well suited for bonding together a wide variety of similar and dissimilar materials such as metals, paints, wood, glass and some plastics.	<p>An excellent adhesive for mounting nameplates and decorative trim.</p> <p>Miscellaneous joining and holding where a thin, long ageing bond is required.</p>	Automotive Industry.
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Specifications	This tape meets the requirements of U.S. Government specification MIL-P-19834, Amendment 1, Type 1.	468MP is a UL and AGA recognised product.
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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 Group

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