

Technical Data Sheet

3M™ Adhesive Transfer Tape 468MP

Product Description

Finite Element Analysis (FEA) data is available for this product at: [3m.com/FEA](https://www.3m.com/FEA)

3M™ Adhesive Transfer Tape 468MP utilizes 3M High Performance Acrylic Adhesive 200MP, which makes it a popular choice for graphic attachment and general industrial joining applications. It provides outstanding adhesion to metal and high surface energy plastics. This adhesive provides some initial repositionability for placement accuracy when bonding to plastics. It also performs well after exposure to humidity and hot/cold cycles.


Product Features

- Up to 400°F short-term heat resistance
- Excellent solvent resistance
- Excellent shear strength to resist slippage and edge lifting

Technical Information Note

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

Typical Physical Properties

Property	Values	Additional Information
Adhesive Type	Acrylic	
Liner	58# Polycoated Kraft Paper (PCK)	
Liner Thickness	0.11 mm	
Liner Color	Tan	
View		
Test Name	Primary	

Total Tape Thickness (mil)


5.2 mil

View 

Test Method: ASTM D3652

Total Tape Thickness (mm)

0.13 mm

View 

Test Method: ASTM D3652

Liner Print

468MP

Liner Thickness

4.2 mil

Typical Performance Characteristics

Property

Values

Additional Information

90° Peel Adhesion

6 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 15.0

Dwell Time Units: min

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH

Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

55 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 15.0

Dwell Time Units: min

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH


Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

11.8 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH

Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

108 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH


Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

20 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 70C

Temp F: 158F

Environmental Condition: 50%RH

Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

183 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr


Temp C: 70C

Temp F: 158F
Environmental Condition: 50%RH
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

9.2 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Aluminum
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

84 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Aluminum
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

3 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: ABS
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

27 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: ABS
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

8.9 N/cm

[View](#) 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Acrylic (PMMA)
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

81 oz/in

[View](#) 


Test Method: ASTM D3330

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Acrylic (PMMA)
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

12.3 N/cm

[View](#) 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Glass
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

112 oz/in

[View](#) 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH


Substrate: Glass

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

5 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH


Substrate: Polyvinyl chloride (PVC)

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

46 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH

Substrate: Polyvinyl chloride (PVC)

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

9.6 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH

Substrate: Polycarbonate (PC)

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

88 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH

Substrate: Polycarbonate (PC)

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Tensile Lap Shear – Peak Load

174 lb

View 

Test Method: ASTM D1002

Substrate: Aluminum

Notes: 0.5 in² sample size

Short Term Temperature Resistance

400 °F

View 

Test Condition: Short Term (minutes, hour)

Short Term Temperature Resistance

204 °C

View 

Test Condition: Short Term (minutes, hour)

Long Term Temp C

149 °C

View 

Test Condition: Long Term (day, weeks)

Long Term Temp F

300 °F

View 

Test Condition: Long Term (day, weeks)

Static Shear

10000+ min

View 

Test Condition: 1000 g @ Room Temperature

Notes: 1in x 1in size; test terminated after 10,000 minutes

Static Shear

10000+ min


View 

Test Condition: 1000 g @ 70°C (158°F)

Notes: 1in x 1in size; test terminated after 10,000 minutes

Static Shear

10000+ min

View 

Test Condition: 1000 g @ 93°C (200°F)

Notes: 1in x 1in size; test terminated after 10,000 minutes

Static Shear

10000+ min


View 

Test Condition: 500 g @ 177°C (350°F)

Notes: 1in x 1in size; test terminated after 10,000 minutes

Static Shear

2645 min

View 

Test Condition: 400 g @ 232°C (450°F)

Notes: 1in x 1in size; test terminated after 10,000 minutes

Static Shear

10000+ min


View 

Test Condition: 200 g load @ 232°C (450°F)

Notes: 1in x 1in size; test terminated after 10,000 minutes

180° Peel Adhesion

15.2 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH

Substrate: Stainless Steel

Backing: Aluminum Foil

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion

139 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH


Substrate: Stainless Steel

Backing: Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

10 N/cm

View 

Test Name: 90° Peel Adhesion

Dwell/Cure Time: 24.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: Control

Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

94 oz/in

View 

Test Name: 90° Peel Adhesion

Dwell/Cure Time: 24.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: Control


Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

8.7 N/cm

View 

Test Name: 90° Peel Adhesion

Dwell/Cure Time: 1.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: Gasoline


Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

79 oz/in


View 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 1.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: Gasoline
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

9 N/cm


View 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 1.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: MEK
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

82 oz/in


View 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 1.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: MEK
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

10 N/cm

View 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 1.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: Weak Acid (pH 4)
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

95 oz/in


View 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 1.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: Weak Acid (pH 4)
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

9.4 N/cm

[View](#) 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 1.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: Weak Base (pH 10)
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

86 oz/in


[View](#) 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 1.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: Weak Base (pH 10)
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

17.7 N/cm

[View](#) 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 49C
Temp F: 120F
Environmental Condition: Oil 10W30
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

162 oz/in

[View](#) 

Test Name: 90° Peel Adhesion

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 49C
Temp F: 120F
Environmental Condition: Oil 10W30
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

10 N/cm

View 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 100.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: Water
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

95 oz/in


View 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 100.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: Water
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

13.4 N/cm

View 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: Salt water (5 wt% in water)
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

122 oz/in

View 


Test Name: 90° Peel Adhesion
Dwell/Cure Time: 72.0

Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: Salt water (5 wt% in water)
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

16.5 N/cm

[View](#) 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 7.0
Dwell Time Units: day
Temp C: 32C
Temp F: 90F
Environmental Condition: 90%RH
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

151 oz/in

[View](#) 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 7.0
Dwell Time Units: day
Temp C: 32C
Temp F: 90F
Environmental Condition: 90%RH
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

17.4 N/cm

[View](#) 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 2000.0
Dwell Time Units: hr
Environmental Condition: UV Conditions - ASTM G-154 Cycle 1
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

158 oz/in

[View](#) 

Test Name: 90° Peel Adhesion
Dwell/Cure Time: 2000.0
Dwell Time Units: hr
Environmental Condition: UV Conditions - ASTM G-154 Cycle 1
Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

15.2 N/cm

View 

Test Name: 90° Peel Adhesion

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Environmental Condition: Temperature Cycling: 4 Hours at 158°F (70°C). 4 Hours at -20°F (-29°C). 16 Hours at Room Temperature. Repeat three times

Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Environmental Resistance

139 oz/in

View 

Test Name: 90° Peel Adhesion

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Environmental Condition: Temperature Cycling: 4 Hours at 158°F (70°C). 4 Hours at -20°F (-29°C). 16 Hours at Room Temperature. Repeat three times

Substrate: Stainless Steel

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

Electrical and Thermal Properties

Property

Values


Additional Information

Breakdown Voltage

4500 V

Insulation Resistance

>2.79 x 10¹³ Ω

View 

Test Method: ASTM D257-14

Test Condition: test voltage = 100 VDC

Dielectric Constant 1KHz

3,74

View 

Test Method: ASTM D150

Temp C: 23C

Temp F: 72F

Test Condition: 1 KHz

Dissipation Factor

0,0253

Dielectric Strength

36,9 V/mil

View 

Test Method: ASTM D150

Test Condition: 500 vac, rms[60 hz/sec]

Thermal Conductivity

0,155 W/m/K

View 

Test Method: ASTM C518

Test Condition: 109°F(43°C)

Notes: results listed are at 109°F

Coefficient of Thermal Expansion

278 ppm/°C

Typical Environmental Performance

Humidity Resistance – High humidity has a minimal effect on adhesive performance. Bond strength shows no significant reduction after exposure for 7 days at 90°F (32°C) and 90% relative humidity.

UV Resistance – The adhesive is not adversely affected by outdoor exposure when covered by a nameplate or decorative trim part.

Water Resistance – Immersion in water has no appreciable effect on the bond strength. After 100 hours at room temperature, the high bond strength is maintained.

Temperature Cycling Resistance – High bond strength is maintained after cycling four times through:

4 hours at 158°F (70°C)

4 hours at -20°F (-29°C)

4 hours at 73°F (22°C)

Chemical Resistance – When properly applied, nameplate and decorative trim parts will hold securely after exposure to numerous chemicals including oil, mild acids and alkalis.

Bond Build-up: The bond strength of 3M™ High Performance Acrylic Adhesive 200MP increases as a function of time and temperature.

Temperature/Heat Resistance: 3M™ High Performance Acrylic Adhesive 200MP is usable for short periods (minutes, hours) at temperatures up to 400°F (204°C) and for intermittent longer periods (days, weeks) up to 300°F (149°C).

Lower Temperature Service Limit: The glass transition temperature for 3M™ High Performance Acrylic Adhesive 200MP is -31°F (-35°C). Many applications survive below this temperature (factors affecting successful applications include: materials being bonded, dwell at room temperature before cold exposure, and stress below the glass transition temperature [i.e. expansion/contraction stresses, impact]). Optimum conditions are: bonding high surface energy materials, longer time at room temperature before cold exposure, and little or no stress below the glass transition temperature. The lowest service temperature is -40°F (-40°C).

Storage and Shelf Life

It is suggested that products are stored at room temperature conditions of 70°F (21°C) and 50% relative humidity.

When handled and stored correctly, product has a shelf life of 24 months after date of manufacture.

Recognition/Certification

TSCA: This product is defined as an article under the Toxic Substances Control Act and therefore, it is exempt from inventory listing requirements.

SDS: 3M has not prepared a SDS for this product which is not subjected to the SDS requirements of the Occupational Safety and Health Administration's Hazard Communication Standard, 29 C.F.R.1910.1200(b)(6)(v). When used under reasonable conditions or in accordance with the 3M directions for use, this product should not present a health and safety hazard. However, use or processing of the product in a manner not in accordance with the directions for use may affect its performance and present potential health and safety hazards.

UL: These products have been recognized by Underwriters Laboratories, Inc. under Standard UL 969, Marking and Labeling Systems Materials Component. For more information on the UL Certification, please visit the website at <http://www.3M.com/converter>, select UL Recognized Materials, then select the specific product area.

Military: Meets MIL-DTL-19834C (WITH EXCEPTION)

Note: One of 3M's core values is to respect our social and physical environment. 3M is committed to comply with ever-changing, global, regulatory and consumer environmental, health, and safety (EHS) requirements. As a service to our customers, 3M is providing information on the regulatory status of many 3M products. Further regulation information including that for OSHA, USCPPI, FDA, California Proposition 65, REACH and RoHS, can be found at 3M.com/regs.

Automotive Disclaimer

Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, including, but not limited to, automotive electric powertrain battery or high voltage applications. This product does not fully adhere to typical automotive design or quality system requirements, such as IATF 16949 or VDA 6.3. This product may not be manufactured in an IATF certified facility and may not meet a Ppk of 1.33 for all properties. The product may not undergo an automotive production part approval process (PPAP). Customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's automotive application and for conducting incoming inspections before use of the product. Failure to do so may result in injury, death, and/or harm to property. No written or verbal statement, report, data or recommendation by 3M related to automotive use of the product shall have any force or effect unless in an agreement signed by the Technical Director of 3M's Automotive Division. Customer assumes all responsibility and risk if customer chooses to use this product in an automotive electric powertrain battery or high voltage application, and 3M will not be liable for any loss or damage arising from or related to the 3M product or customer's use of the product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity or recall costs), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability. In no event shall 3M be liable for any damages in excess of the purchase price paid for the product.

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Bottom Matter

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Trademarks

3M is a trademark of 3M Company.

Industry Specifications

This product might be suitable for use in indirect food contact applications. Please see the applicable Regulatory Data Sheet for more information relating to FDA compliance.

Handling/Application Information

Application Examples

- Long term bonding of graphic nameplates and overlays ("subsurface" printed polycarbonate or polyester) to metal and high surface energy plastics in the aerospace, medical and industrial equipment, automotive, appliance and electronics markets.
- Bonding metal nameplates and rating plates in the aerospace, medical and industrial equipment, automotive, appliance and electronics markets.
- Bonding graphic overlays for membrane switches and for bonding the complete switch to the equipment surface.
- The adhesives bonding characteristics enable high speed processing of parts in the medical, telecommunications and electronics markets (medical components, durable labels, and flexible circuits).
- Bonding in lamination processes to industrial foams for rotary die-cutting of small gaskets for industrial and electronics markets.

Application Techniques

For maximum bond strength (during installation of the final part) the surface should be thoroughly cleaned and dried. Typical cleaning solvents are heptane (for oily surfaces) or isopropyl alcohol for plastics. Use reagent grade solvents since common household materials like rubbing alcohol frequently contain oils to minimize the drying affect on skin and can interfere with the performance of a pressure-sensitive adhesive.

*Note: Carefully read and follow the manufacturer's precautions and directions for use when working with solvents. These cleaning recommendations may not be in compliance with the rules of certain air quality management districts in California; consult applicable rules before use.

It is necessary to provide pressure during lamination (1.5-20 psi recommended) and during final part installation (10-15 psi) to allow the adhesive to come into direct contact with the substrate. Using a hard edged plastic tool, which is the full width of the laminated part, helps to provide the necessary pressure at the point of lamination. Heat can increase bond strength when bonding to metal parts (generally this same increase is observed at room temperature over longer times, weeks). For plastic parts, the bond strength is not enhanced with the addition of heat.

The ideal adhesive application temperature range is 60°F (15.6°C) to 100°F (38°C). Application is not recommended if the surface temperature is below 50°F (10°C) because the adhesive becomes too firm to adhere readily. Once properly applied, at the recommended application temperature, low temperature holding is generally satisfactory (please refer to the Typical Performance Characteristics section).

When bonding a thin, smooth, flexible material to a smooth surface, it is generally acceptable to use 2 mils of 3M™ Adhesive 200MP. If a texture is visible on one or both surfaces, the 5 mil 3M adhesive 200MP would be suggested. If both materials are rigid, it may be necessary to use a thicker adhesive to successfully bond the components. 3M™ VHB™ Acrylic Foam Tapes may be required (please refer to the data page 70-0709-3830-6).

To apply adhesives in a wide web format, lamination equipment is required to ensure acceptable quality. To learn more about working with pressure-sensitive adhesives please refer to technical bulletin, Lamination Techniques for Converters of Laminating Adhesives (70-0704-1430-8). For additional dispenser information, contact your local 3M sales representative, or the toll free 3M sales assistance number at 1-800-362-3550.

References

Property
Values

3m.com Product Page

https://www.3m.com/3M/en_US/p/d/b40071697/

Safety Data Sheet SDS

https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=468MP

ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

Information

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