



# 465 and 924 Transfer Tapes

## Product Data Sheet

Updated : October 2004  
Supersedes: February 1996

**Product Description**      **465 Transfer Tape**  
**924 Reverse Wound Transfer Tape** for use with 3M 'ATG' Tape Dispensers.  
 A-40 is a medium-firm acrylic adhesive system. It features an excellent balance of high initial adhesion (quick stick) and good shear holding power.

Bond strength generally increases somewhat with natural ageing.  
 924 is used exclusively in ATG hand dispensers. The ATG conveniently applies the tape to surfaces giving speed and control.

**Physical Properties**  
Not for specification purposes

<b>Adhesive Type</b>	Medium Firm Acrylic	<b>3M ref</b> : A-40
<b>Thickness</b> (ASTM D-3652) Tape Liner Total	50 µm 100 µm 150 µm	
<b>Release Liner</b>	Tan Paper	
<b>Tape Colour</b>	Clear	
<b>Shelf Life</b>	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

**Performance Characteristics**  
Not for specification purposes

<b>Adhesion to Stainless Steel</b> ASTM D-3330	2.7 N/10mm	
<b>Shear Resistance</b>	Medium	
<b>Temperature Performance</b> Max : Minutes / Hours Max : Days / Weeks Minimum		120 °C 80 °C -30 °C
<b>Solvent Resistance</b>	High	
<b>UV Light Resistance</b>	Excellent	

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<b>Additional Product Information</b>	This is a "permanent" adhesive in the sense that it does not degrade when sandwiched between two impermeable surfaces in normal use. This adhesive will not bleed into most paper stocks, thus minimising possible discolouration of business forms, posters etc.		
<b>Application Techniques</b>	<p>1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact &amp; 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. 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.
<b>Applications</b>	<p>A-40 adhesive is well suited for bonding together a wide variety of similar and dissimilar materials such as metals, glass, wood, papers, paints, and many plastics.</p> <p>High speed flying splices on most grades of paper such as newsprint, clay coated, corrugated stocks.</p>	<p>Splicing of foils, films and fabrics.</p> <p>Attaching labels or instructions to bottles.</p> <p>Laminating adhesive for foams.</p> <p>Attaching metal or plastic nameplates.</p> <p>Core starting.</p>	<p>Mounting promotional items posters, etc.</p> <p>Mounting rubber or photopolymer printing plates.</p> <p>Reclosable plastic bags.</p> <p>Miscellaneous joining and holding where high initial adhesion, easy liner release and a thin, long ageing bond is required.</p>
<b>Specifications</b>	465 meets the requirements of U.S. Government specification MIL-P-19834B, Type 1.		

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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.



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