



927 and 976 Transfer Tapes

Product Data Sheet

Updated : February 1996
Supersedes : October 1993

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| Product Description | 927 Transfer Tape | These tapes use a modified acrylic pressure-sensitive adhesive system. It features very high initial adhesion and good shear holding power to a wide variety of materials including most plastics. | Use of 976 in ATG dispenser assures speed, control, convenience and economy for the user. |
| | 976 Reverse Wound Transfer Tape for use with 3M 'ATG' Tape Dispensers. | | |

Physical Properties
Not for specification purposes

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| Adhesive Type | Modified Acrylic | 3M ref : A-60 |
| Thickness (ASTM D-3652) Tape Liner Total | 50 µm 100 µm 150µm | 2 Thou |
| Release Liner | Tan Paper | |
| Tape Colour | Clear | |
| Shelf Life | 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

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| Adhesion to Stainless Steel ASTM D-3330 | 6.6 N/10mm | |
| Shear Resistance | Medium | |
| Temperature Performance Max : Minutes / Hours Max : Days / Weeks Minimum | 120 °C 80 °C -30 °C | |
| Solvent Resistance | Medium. | |
| UV Light Resistance | Not recommended for direct exposure to sunlight or other sources of UV light. | |

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| Additional Product Information | The ultra violet resistance of this adhesive is fair. Applications where the adhesive mass is directly exposed to U.V. through glass, clear plastic, etc. should be avoided. Edge exposure is generally satisfactory. | This adhesive has relatively good resistance to moderate amounts of plasticisers. Applications may be subjectively evaluated by testing the tape in contact with the materials at conditions of 65 °C for a period of 5 to 7 days. | This adhesive will not bleed into most paper stocks, thus minimising possible discolouration of posters, business forms. |
| 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. 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. |
| Applications | These tapes are well suited for attaching a wide variety of similar and dissimilar materials where an aggressive adhesive with high initial adhesion is desired. | <p>Splicing of film, foils, fabrics, coated papers.</p> <p>Laminating adhesive for foams, photos, fabrics, metal or plastic nameplates.</p> | <p>927 is used to bond lead strip to glass in the glazing industry.</p> <p>General purpose holding and mounting applications.</p> |
| Specifications | Tape 927 meets the requirements of U.S. Government specification MIL-P-19824B, Amendment 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.



Specialty Tapes & Adhesives

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