

June, 2003

3M™ Splicing Tape 415

Product Description

3M™ Splicing Tapes utilize an acrylic pressure sensitive adhesive system that offers a balance of initial adhesion and good holding power.



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 Performance Characteristics

Property	Values		Method	Dwell/Cure Time	Dwell Time Units	Substrate	Backing	Notes
180° Peel Adhesion	2.7 N/cm	25 oz/in	ASTM D3330	72	hr	Stainless Steel	2 mil Aluminum Foil	12 in/min (300 mm/min)
Solvent Resistance	Good							
UV Resistance	Excellent							

Relative High Temperature Operating Ranges	Test Condition
82 °C	180 °F Short Term (minutes, hours)
65 °C	150 °F Long Term (days, weeks)

Property: Relative High Temperature Operating Ranges

Available Sizes

Property	Values	Attribute Modifier
Note	Subject to Minimum Order Requirements	
Standard Roll Length	32.9 m	36 yd
Minimum Available Width	6.35 mm	1/4 in
Maximum Available Width	1219 mm	48 in
Normal Slitting Tolerance	± 0.8 mm	± 1/32 in
Core Size	76.2 mm	3 in ID

Maximum Length	Width
165 m	180 yd 1/4 in to 3/8 in widths
165 m	180 yd 3/8 in to 1/2 in width
329 m	360 yd 1/2 to 2 in widths
329 m	360 yd 2 in and greater

Property: Maximum Length

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Handling/Application Information

Application Ideas

- 3M™ Splicing Tape 415 can be used for high-speed flying splices and zero speed splices on most grades of paper such as newsprint, clay coated, corrugated stocks.

Application Techniques

- Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure helps develop better adhesive contact and improve bond strength.
- To obtain optimum adhesion, the bonding surfaces must be clean, dry, and well unified.
- Ideal tape application temperature range is 70°F to 100°F (21°C to 38°C). Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

Storage and Shelf Life

Store in original cartons at 70°F (21°C) and 50% relative humidity.

If stored under proper conditions, product retains its performance and properties for 24 months from date of manufacture.

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-Double-Coated-Tape-415?N=5002385+3293242049&rt=rud
Safety Data Sheet (SDS)	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=415

Family Group

	415	465	469	9420	9497	9499
Relative High Temperature Operating Ranges (°C) Test Condition: Short Term (minutes, hours)	82	121	180	82	177	260
Relative High Temperature Operating Ranges (°C) Test Condition: Long Term (days, weeks)	65	82	94	65	121	149

ISO Statement

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

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550 or visit www.3M.com/adhesives. Address correspondence to: 3M Industrial Adhesives and Tapes Division, Building 21-1W-10, 900 Bush Avenue, St. Paul, MN 55144-1000. Our fax number is 651-778-4244. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

Information

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