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3M™ Adhesive Transfer Tape 9372DKW

Product Description

3M™ Adhesive Transfer Tapes are acrylic based and specially formulated to provide a permanent bond between substrates in environments requiring regulatory compliance with flame retardant standards such as Federal Aviation Regulation 25.853.

Product Features:

Flame Retardant

3M™ Adhesive Transfer Tape 9372DKW

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		Attribute Modifier
Color	Off White (opaque)		
Thickness Tolerance	±15 %		
Adhesive Type	Tackified Acrylic, 300FR Series		
Adhesive Carrier	None		
Adhesive Thickness	0.051 mm	2 mil	
Areal Density	75 g/m²		
Liner	DK		
Liner Color	White, unprinted		Primary
Liner Thickness	0.1 mm	4 mil	
Net Weight	55 lb/Ream		

Typical Performance Characteristics

90° Peel Adhesion		Dwell/Cure Time	Temp C	Temp F	Substrate	Backing	Notes	Dwell Time Units	Environmental Condition
7.7 N/cm		Initial	22C	72F	Stainless Steel	2 mil PET	12 in/min (300 mm/min)		
70 oz/in		Initial	72F	52%RH	Stainless Steel	2 mil PET		22C	
98 oz/in	8.5 N/cm	72	70C	158F	Stainless Steel	2 mil Aluminum Foil	12 in/min (300 mm/min)	hr	52%RH
5.3 N/cm	48 oz/in	72	22C	72F	Polypropylene (PP)	2 mil PET	12 in/min (300 mm/min)	hr	52%RH
72 oz/in	7.9 N/cm	72	22C	72F	Stainless Steel	2 mil PET	12 in/min (300 mm/min)	hr	52%RH
5.6 N/cm	51 oz/in	72	22C	72F	High Density Polyethylene (HDPE)	2 mil PET	12 in/min (300 mm/min)	hr	52%RH
6.8 N/cm	62 oz/in	72	22C	72F	ABS	2 mil PET	12 in/min (300 mm/min)	hr	52%RH

Table continued on next page

Typical Performance Characteristics (continued)

90° Peel Adhesion		Dwell/Cure Time	Temp C	Temp F	Substrate	Backing	Notes	Dwell Time Units	Environmental Condition
6.9 N/cm	63 oz/in	72	22C	72F	Polycarbonate (PC)	2 mil PET	12 in/min (300 mm/min)	hr	52%RH

Property: 90° Peel Adhesion
Method: ASTM D3330

Relative High Temperature Operating Ranges		Test Condition
121 °C	250 °F	Short Term (minutes, hours)
82 °C	180 °F	Long Term (days, weeks)

Property: Relative High Temperature Operating Ranges

Property	Values		Notes	Method	Test Condition	Dwell/Cure Time	Dwell Time Units	Temp C	Temp F	Environmental Condition	Substrate
Short Term Temperature Resistance	121 °C	250 °F	No change in room temperature dynamic shear properties following 4 hours conditioning at indicated temperature with 100 g/static load. (Represents minutes, hours in a process type temperature exposure).								
Long Term Temperature Tolerance	82 °C	180 °F	Maximum temperature where tape supports at least 250 g load per 0.5 in² in static shear for 10,000 minutes. (Represents continuous exposure for days or weeks).								
Static Shear	>10,000 min		1 in² sample size	ASTM D3654	1000 g @ Room Temperature						
Static Shear	>10,000 min		1 in² sample size	ASTM D3654	500 g @ 70°C (158°F)						
Solvent Resistance	Very Good										
UV Resistance	Very Good										
180° Peel Adhesion	12.8 N/cm	115 oz/in	12 in/min (300 mm/min)	ASTM D3330		72	hr	22C	72F	52%RH	Stainless Steel

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Available Sizes

Property	Values		Notes	Attribute Modifier
Standard Roll Length	180 m			
Maximum Available Width	60 in			
Normal Slitting Tolerance	±0.8 mm	±1/32 in		
Precision Slitting Tolerance	±0.1 mm	±0.004 in	Precision slitting is available on select products with minimum order of full web increments.	
Core Size	76.2 mm	3 in		ID

Available Sizes:

Minimum Slit Width:		1" up to 3"	1/2" up to 3"	2" up to 3"
	minimum length	60 yards	60 yards	60 yards
	maximum length	180 yards	180 yards	180 yards
3" to 30"	minimum length	60 yards	60 yards	60 yards
	maximum length	720 yards	720 yards	720 yards
31" to 48"	minimum length	–	–	60 yards
	maximum length	–	–	500 yards
31" to 60"	minimum length	60 yards	60 yards	–
	maximum length	500 yards	500 yards	–

Certifications/Standards

Property	Values
Federal Aviation Regulations, FAR 25.853	Yes
Underwriter Laboratories 94, UL-94 (V-2)	No

Handling/Application Information

Application Ideas

This family of products has been formulated for applications requiring flame retardancy and high bond strength to a wide variety of substrates.

These attributes and choice of three product thicknesses make the products ideally suited to applications in aerospace, maritime, electronic, automotive and building construction applications on both smooth and textured substrates.

Handling/Application Information (continued)

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. 15 psi momentary pressure is typical.

Ideal tape application temperature range is 70°F to 100°F (21°C to 37°C). Initial tape application to surface at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once applied, low temperature holding is generally satisfactory.

Surfaces should be clean and dry prior to bonding. We recommend a final surface cleaning with a mixture of 50% isopropyl alcohol* and water.

Two liner options facilitate wide array of application techniques. Densified kraft liner ideal for roll to roll lamination and subsequent rotary die cutting. Heavy caliper, layflat, polycoated kraft liner, minimizes surface asperities, minimizes distortion of pre-laminated substrates in variable humidity conditions and provide convenient backing for kiss cutting operations.

*Carefully read and follow the manufacturer's precautions and directions for use when using cleaning solvents.

Application Equipment

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.

Storage and Shelf Life

Store under normal conditions of 70°F (21°C) and 50% relative humidity in the original carton. To obtain best performance, use this product within 18 months from date of manufacture.

Industry Specifications

FAR 25.853

Trademarks

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-Flame-Retardant-Adhesive-Transfer-Tape-9372DKW?N=5002385+3293241958&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=9372DKW

3M™ Adhesive Transfer Tape 9372DKW

Family Group

	9372W	9372DKW	9375W
Relative High Temperature Operating Ranges (°C) Test Condition: Short Term (minutes, hours)	121	121	121
Relative High Temperature Operating Ranges (°C) Test Condition: Long Term (days, weeks)	82	82	82
Liner Color Attribute Modifier: Primary	Tan, unprinted	White, unprinted	Tan, unprinted
Color	Off White (opaque)	Off White (opaque)	Off White (opaque)
Adhesive Type	Tackified Acrylic, 300FR Series	Tackified Acrylic, 300FR Series	Tackified Acrylic, 300FR Series
Adhesive Carrier	None	None	None
Adhesive Thickness (mm)	0.051	0.051	0.127
Liner	PCK	DK	PCK
Liner Thickness (mm)	0.17	0.1	0.17

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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3M United States
3M Center
St. Paul, MN 55144-1000
800-362-3550
www.3M.com

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