



Double Coated Paper Tapes

401M • 410M

Technical Data

July, 2008

Product Description 3M™ Double Coated Paper Tapes 401M and 410M utilize a natural rubber adhesive system that offers good to excellent adhesion to many types of surfaces.

Environmental Advantage These products use a solvent free manufacturing process.

Construction	Products	3M™ Double Coated Paper Tape	
		401M	410M
Adhesive Family:		860	860
Adhesive Type:		Natural Rubber	Natural Rubber
Adhesive Carrier:		Treated Paper	Treated Paper
Tape Color:		Off-white	Off-white
Liner Color:		Green Plaid Paper	Green Plaid Paper
Approximate Thickness:			
Tape Thickness <i>(without the liner)</i>		0.009 in. (0.23 mm)	0.006 in. (0.13 mm)
Liner Thickness		0.003 in. (0.075 mm)	0.003 in. (0.075 mm)

3M™ Adhesive 860 is a soft rubber-resin pressure-sensitive adhesive system and features high initial adhesion and good holding power to a wide variety of materials.

Typical Physical Properties and Performance Characteristics **Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.**

Products	3M Double Coated Paper Tape	
	401M	410M
Adhesion to Steel: ASTM D 3330 modified 90° peel, 72 hr. RT dwell	65 oz./in. (71 N/100 mm)	50 oz./in. (60 N/100 mm)
Relative High Temperature Operating Ranges:		
Long Term (days, weeks)	150°F (65°C)	150°F (65°C)
Short Term (minutes, hours)	180°F (82°C)	200°F (93°C)
Relative Solvent Resistance:	Medium	Medium
U.V. Resistance:	Good	Good

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Application Techniques	<p>Bond strength is dependent upon the amount of adhesive-to-surface contact. Firm application pressure helps ensure better adhesive contact and improve bond strength.</p> <p>To obtain optimum adhesion, the bonding surfaces must be clean, dry, and uniform. Some typical surface cleaning solvents are isopropyl alcohol or heptane.*</p> <p>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.</p> <p>*Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.</p>
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Application Ideas	<ul style="list-style-type: none">• Splicing and core starting of papers, foils, films, fabrics etc.• Mounting rubber or photopolymer printing plates to print cylinders.• Attaching of golf club grips.• Temporary holding while parts are being finished in the milling process.
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Application Equipment	<p>For additional dispenser information, contact your local 3M sales representative, or the toll free 3M sales assistance number at 1-800-362-3550.</p>
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Available Sizes	<p>Please contact your 3M sales representative or contact 3M customer service at 1-800-362-3550 for details on available sizes.</p>
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Storage	<p>Store in original cartons at 70°F (21°C) and 50% relative humidity.</p>
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Shelf Life	<p>If stored under proper conditions, product retains its performance and properties for one year from date of manufacture.</p>
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Certification/ Recognition

MSDS: 3M has not prepared MSDSs for these products which are not subject to the MSDS 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, these products should not present a health and safety hazard. However, use or processing of the products in a manner not in accordance with the directions for use may affect their performance and present potential health and safety hazards.

TSCA: These products are defined as articles under the Toxic Substances Control Act and therefore, are exempt from inventory listing requirements.

Product Use

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.