



8402 Polyester Tape

Product Data Sheet

Updated : March 1996
Supersedes : October 1993

Product Description Polyester film backing with a translucent green pigmented silicone adhesive.

Physical Properties
Not for specification purposes

Adhesive Type	Translucent green pigmented silicone.	
Backing	25 µm Polyester film.	
Total Thickness (ASTM D-3652)	50 µm	
Tape Colour	Green	
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

Adhesion to Stainless Steel ASTM D-3330	2.6 N/10mm	
Tensile Strength ASTM D-3759	57.8 N/10mm	
Elongation at Break ASTM D-3759	120 %	
Temperature Range Maximum Minimum	177 °C - 50 °C	

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Additional Product Information	Not recommended to exceed one year under normal storage conditions at 21°C and 50% R.H.		
Application Techniques	Best results are attained when applied to a clean, dry and non dusty surface above 0°C.	To improve adhesion ensure firm and even application pressure is applied.	
Applications	Masking edges of overlap seams in metal bonding process. Excess epoxy ("flash") flows onto tape. Clean-up is complete upon tape removal. No. 8403 should also be considered for this use where a thicker backing is required. Protective overall mask on	panels subject to mild caustic or acid bath etching. Prevents scratches during handling and provides desired masking during metal bonding and fabrication operations. Holding parts or vacuum bags during bonding process.	Mask for metal in acid or caustic chemical milling baths. Excellent masking material for parts in anodising processes. Splicing of films subject to high temperatures.

FEATURES	ADVANTAGES	BENEFITS
Polyester film.	Abrasion, chemical and thermal resistance.	Reduces failures from backing breakdown or shrinkage.
	Retains flexibility from -50 °C to 204°C.	Reduces failures due to cracking.
Silicone adhesive.	Higher heat resistance as compared with acrylics.	Reduces failures due to softening, oozing, adhesive transfer and high temperature splice slippage.
	Chemical resistance.	Reduces failure due to undercutting.

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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