

# 3M

# Polyester Tape

## 854

### Technical Data

**Product Description** 3M™ Polyester Tape 854 is an opaque, cream-colored polyester tape with excellent chemical resistance in precious metal plating, especially gold.

Product Construction	Backing	Adhesive	Color	Standard Roll Length
	Polyester	Rubber	Cream	72 yds. (66 m)

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

		ASTM Test Method
Adhesion to Steel:	59 oz./in. width (64 N/100 mm)	D-3330
Tensile Strength at Break:	29 lbs./in. width (509 N/100 mm)	D-3759
Elongation at Break:	123%	D-3759
Backing Thickness:	1.0 mil (0.03 mm)	D-3652
Total Tape Thickness:	2.7 mils (0.065 mm)	D-3652
Water Vapor Transmission Rate:	1.6 gms H <sub>2</sub> O/100 sq. in./24 hrs. (24.8 g/m <sup>2</sup> 24 h)	

### Features

- Polyester film backing imparts excellent chemical and thermal stability.
- Remains flexible at -60°F (-50°C) and retains dimensional stability up to 300°F (149°C).
- Resists many solvents typically found in photographic, electroplating and chemical milling processes. **Note:** Hot caustics will weaken the backing after prolonged immersion.
- Extended periods of exposure to elevated temperatures or outdoor conditions will cause an increase in bond strength. During this exposure, however, the film can become brittle and lose its tensile strength.
- Roll stability is excellent up to one year.

### Application Ideas

- Chemical resistance in precious metal plating, especially gold.
- Protection in sodium hydroxide etching of aluminum.
- Protection of substrates during chemical milling.
- General splicing.

# 3M™ Polyester Tape

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**Storage** Store under normal conditions of 70°F (21°C) and 50% R.H. in the original carton.

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**Shelf Life** To obtain best performance, use this product within 18 months from date of manufacture.

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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.

**3M**

**Industrial Business  
Industrial Adhesives and Tapes Division**

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