



Adhesive Transfer Tape

F-9465PC

Technical Data

January, 2004

Product Description 3M™ Adhesive Transfer Tape F-9465PC is a 5 mil thick adhesive transfer tape which has been formulated for bonding to many flexible vinyls and to resist the effects of plasticizer migration in flexible vinyls.

Construction	Product	3M Tape F-9465PC
	Adhesive Type:	Medium-Firm Acrylic
	Release Liner:	Printed Tan Polycoated Paper Liner
	Approximate Thickness:	
	Release Liner:	.004 in. (0.10 mm)
	Tape Only:	.005 in. (0.13 mm)
	Tape Color:	Clear, slight amber tint

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.

Adhesion to Steel: (ASTM D3330 72 hr. dwell)	85 oz./in. width (88 N/100 mm)
Relative High Temperature Operating Ranges:	
Short Term: (minutes, hours)	200°F (94°C)
Long Term: (days, weeks)	160°F (74°C)
Relative Solvent Resistance:	Good
UV Resistance:	Excellent

Available Sizes

Available Lengths:	
Minimum	60 yds. (54.9 m)
Maximum	360 yds. (329.4 m)
Available Widths:	
Minimum	3/8 in. (9.5 mm)
Maximum	54 in. (1371.6 mm)
Normal Slitting Tolerance:	± 1/32 in. (0.8 mm)
Core Size (ID):	3.0 in. (76.2 mm)

Application Techniques

- Bond strength is dependent on 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

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General Information	<p>Note: Vinyl formulations differ and plasticizer types and amounts can vary. The most common types of plasticized vinyl contain low molecular weight materials (plasticizers) which tend to migrate out of the vinyl. In the case of adhesive bonding, these plasticizers migrate into the adhesive which can cause softening of the adhesive and loss of bond strength over time.</p> <ul style="list-style-type: none">• The possible effect of plasticizer migration on an adhesive bond can be predicted by accelerated aging for 5 days at elevated temperature (150°F [65°C]). Note: Due to the variability of vinyl formulations, we strongly recommend that the user test each vinyl substrate to determine suitability of the tape for the particular application.• Natural and synthetic rubber materials such as neoprene and EPDM are also formulated with fillers and plasticizers. Note: 3M™ Adhesive Transfer Tape F-9465PC does not resist the effects of these particular fillers and plasticizers and is not recommended for use in bonding these materials.
Storage	Store in original cartons at 70°F (21°C) and 50% relative humidity.
Shelf Life	When stored under proper conditions, product retains its performance and properties for two years from date of manufacture.
Precautionary Information	Refer to Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.
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.
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ISO 9001

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



**Industrial Business
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