



# High Tack Adhesive Transfer Tapes

927 • 950 • 950EK

Technical Data

August, 1994

<b>Product Description</b>	<b>927</b>	0.002 in. (0.05 mm) thick Adhesive Transfer Tape
	<b>950</b>	0.005 in. (0.13 mm) thick Adhesive Transfer Tape
	<b>950EK</b>	0.005 in. (0.13 mm) thick Adhesive Transfer Tape with a white extensible polycoated Kraft liner

<b>Construction</b>	<b>Products</b>	<b>927 Tape</b>	<b>950 Tape</b>	<b>950EK Tape</b>
Adhesive Type:*		A-60	A-60	A-60
Adhesive Carrier:		None	None	None
Release Liner:		Tan paper	Tan paper	White extensible Kraft paper
Approximate Thickness:				
Release Liner		0.004 in. (0.10 mm)	0.004 in. (0.10 mm)	0.006 in. (0.15 mm)
Tape only		0.002 in. (0.05 mm)	0.005 in. (0.13 mm)	0.005 in. (0.13 mm)
Tape Color:		Clear	Clear	Clear

\*A-60 is a medium-firm acrylic pressure-sensitive adhesive system. It features very high initial adhesion and good shear holding power to a wide variety of materials, including many plastics.

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## 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	927 Tape	950 Tape	950EK Tape
Adhesion to Steel: (ASTM Test Methods)	60 oz./in. (66 N/100 mm)	75 oz./in. (82 N/100 mm)	75 oz./in. (82 N/100 mm)
Relative High Temperatures Operating Ranges:			
Long Term (days, weeks)	180° F (82° C)	180° F (82° C)	180° F (82° C)
Short Term (minutes, hours)	250° F (121° C)	250° F (121° C)	250° F (121° C)
Relative Solvent Resistance:	Medium	Medium	Medium
U.V. Resistance:	Not recommended for direct exposure to sunlight or other sources of ultra violet (U.V.) light.		
Shelf Life of Tape in Roll Form:	24 months from date of manufacture when stored in original cartons at 70° F (21° C) and 50% relative humidity.		

## Available Sizes

Available Lengths (Subject to Minimum Order Requirements):			
Standard	60 yd. (54.9 m)	60 yd. (54.9 m)	60 yd. (54.9 m)
Maximum in:			
1/8" - 5/16" widths	60 yd. (54.9 m)	60 yd. (54.9 m)	60 yd. (54.9 m)
5/16" - 1/2" widths	180 yd. (165 m)	180 yd. (165 m)	180 yd. (165 m)
1/2" - 1" widths	180 yd. (165 m)	180 yd. (165 m)	180 yd. (165 m)
1" - maximum	360 yd. (330 m)	360 yd. (330 m)	360 yd. (330 m)
Available Widths (Subject to Minimum Order Requirements):			
Minimum	1/8 in. (12.7 mm)	1/8 in. (12.7 mm)	1/8 in. (12.7 mm)
Maximum	48.0 in (1220 mm)	48.0 in (1220 mm)	48.0 in (1220 mm)
Normal Slitting Tolerance:	± 1/32 in. (0.8 mm)		
Core Size (ID):	3.0 in. (76.2 mm)		

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## 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.
- To obtain optimum adhesion, the bonding surfaces must be clean, dry, and well unified. Some typical surface cleaning solvents are isopropyl alcohol or heptane. **Note:** Be sure to follow solvent manufacturer's precautions and directions for use when using solvents.
- Ideal tape application temperature range is 70°F to 100°F (21° 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 satisfactory.

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## General Information

- The resistance of these tapes to ultra violet (U.V.) light is fair. Applications where the adhesive mass is directly exposed to sunlight or other sources of U.V. light through glass, clear plastic, etc. should be avoided. Edge exposure is generally satisfactory.
- The A-60 adhesive has relatively good resistance to moderate amounts of plasticizers. Applications may be subjectively evaluated by the user testing the tape in contact with the materials at conditions of 150°F (66°C) for a period of 5-7 days.
- This adhesive will not bleed into most paper stocks which helps minimize possible discoloration of posters, business forms.
- Tapes 927 and 950 meet the requirements of U.S. Government Specification MIL-P-19834B, Amend 1.

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## Application Ideas

- 927, 950 and 950EK tapes are ideal for attaching a wide variety of similar and dissimilar materials where an aggressive adhesive with high initial adhesion is desired. Some applications ideas are:
- Splicing of film, foils, fabrics.
  - Laminating adhesive for foams, photos, fabrics, metal or plastic nameplates.
  - General purpose holding and mounting applications.

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## For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550. Address correspondence to: 3M Bonding Systems Division, 3M Center, Building 220-7E-01, St. Paul, MN 55144-1000. Our fax number is 612-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-809-750-3000. In Mexico, phone: 5-728-2180.

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ISO 9002

This Bonding Systems Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

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**Bonding Systems Division**

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