904 (ATG Version) Transfer Tape

Product Data Sheet

Updated : February 1996
Supersedes : July 1994

Product Description

General purpose clear acrylic adhesive Transfer Tape on white polycoated paper liner, with good temperature performance.

Physical Properties
Not for specification purposes

Adhesive Type		**3M ref :**
Thickness (ASTM D-3652) Tape Liner Total	 0.05 mm 0.10 mm 0.15 mm	
Release Liner	White Polycoated Silicone Paper	
Tape Colour	Clear	
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	904 adheres well to most high energy surfaces and plastic materials (ABS, PP, etc). Well suited for bonding a wide variety of similar or dissimilar materials.	
Solvent Resistance	Relative high solvent resistance	
Temperature Resistance	Relative high temperature operating range. Continuous exposure: 120°C. Short term: 200°C. (up to 240°C for minutes).	
UV Light Resistance	Excellent UV resistance	
Peel Adhesion (AFERA 4001)	5 N/10 mm.	

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Application Techniques

1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact & thus improves bond strength.

2. To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Typical surface cleaning solvents are isopropyl alcohol and water (rubbing alcohol) or heptane. Use proper safety precautions for handling solvent.

3. ATG System is the cleaner, easier, more precise way to lay down a strip of 904 adhesive transfer tape.

4. Ideal tape application temperature range is 20°C to 40°C. Initial tape application to surfaces at temperatures below 10°C is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

Applications

Web splicing (paper, foil, film, fabrics.
Core starting.
Miscellaneous joining and holding where high initial adhesion and long ageing bond is required.

Foams, pictures, posters, etc. laminations.

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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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