



444 Double Coated Film Tape

Product Data Sheet

Updated : June 1998
Supersedes : April 1987

Product Description

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 most plastics.

Physical Properties

Not for specification purposes

Adhesive Type	Medium-firm Acrylic	3M ref : A-60
Carrier	Polyester Film	
Thickness (ASTM D-3652) Tape Liner Total	0.10 mm 0.08 mm 0.18 mm	
Release Liner	Off-White 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	6.6 N/10mm	
Temperature Performance Max : Minutes / Hours Max : Days / Weeks	82 °C 65 °C	
Solvent Resistance	Medium	
UV Light Resistance	Not recommended for direct exposure to sunlight or other sources of ultra violet light.	

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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.	surfaces must be clean dry and well unified. Some typical surface cleaning solvents are isopropyl alcohol or heptane. Follow manufacturers precautionary warnings and suggested handling procedures when using solvents.	Initial tape application to surfaces at temperatures below 10°C (50°F) is not recommended because the adhesive becomes too firm to adhere readily. However once properly applied low temperature holding is generally satisfactory.
	2. To obtain optimum adhesion, the bonding	3. Ideal tape application temperature range is 21°C to 38°C (70°F to 100°F).	

Applications	A-60 adhesive is well suited for attaching a wide variety of similar and dissimilar materials where an aggressive adhesive with high initial adhesion is desired. Some typical applications are :	<ol style="list-style-type: none"> 1. Splicing of film, foils, fabrics etc. 2. Laminating adhesive for foams, photos, fabrics, metal or plastic nameplates. 	3. General purpose holding and mounting applications.
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Additional Product Information	A-60 is a "long-ageing" adhesive in the sense that it does not degrade when sandwiched between two surfaces in normal use.	The adhesive has relatively good resistance to moderate amounts of plasticisers. Applications may be subjectively evaluated by testing the tape in contact with the materials at conditions of 150°F (66°C) for a period of 5-7 days.	Test data presented has been determined by standard test methods and are typical values and are not to be used for specification purposes.
	The ultra violet resistance of this adhesive is fair. Applications where the adhesive mass is directly exposed to U.V. through glass, clear plastic etc should be avoided. Edge exposure is generally satisfactory.	This adhesive will not bleed into most paper stocks, thus minimising possible discolouration of posters, business forms etc.	

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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.



Tapes & Adhesives

3M United Kingdom PLC
3M House,
28 Great Jackson Street,
Manchester,
M15 4PA

Customer Service :
Tel [3MUKP1]0161 236 8500
Fax 0161 237 1105

3M Ireland
3M House, Adelphi Centre,
Upper Georges Street,
Dun Laoghaire, Co. Dublin,
Ireland

Customer Service :
Tel (01) 280 3555
Fax (01) 280 3509

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