

March, 2018

# 3M™ Adhesive Transfer Tape 9627

## Product Description

Finite Element Analysis (FEA) data is available for this product at: [3m.com/FEA](http://3m.com/FEA)

3M™ Adhesive Transfer Tapes with 3M™ Quick Bonding Adhesive 360 provides high bond strength to most surfaces, including many low surface energy plastics such as polypropylene and powder coated paints.

## Product Features

- Excellent adhesion to difficult to bond to surfaces such as HDPE, LDPE, and PP.
- Super quick stick.
- Higher adhesion from a thinner tape.
- Excellent solvent resistance.





**Typical Performance Characteristics (continued)**

180° Peel Adhesion		Test Name	Dwell/Cure Time	Dwell Time Units	Substrate
20 N/cm	179 oz/in	Backside	72	hr	Polypropylene (PP)
18 N/cm	162 oz/in	Backside	72	hr	ABS
18 N/cm	161 oz/in	Backside	72	hr	Stainless Steel
20 N/cm	179 oz/in	Backside	72	hr	Polycarbonate (PC)
13 N/cm	119 oz/in	Backside	72	hr	Polyethylene (PE)

Property: 180° Peel Adhesion

Method: ASTM D3330

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH

Backing: Aluminum Foil

notes: 12 in/min (300 mm/min)

**Typical Environmental Performance****Environmental Resistance**

Humidity Resistance: High humidity has minimal effect on adhesive performance.

No significant reduction in bond strength is observed after exposure for 72hrs at 150°F (65°C) and 90% relative humidity.

UV Resistance: When properly applied, nameplates and decorative trim parts are not adversely affected by exposure.

Water Resistance: Immersion in water has no appreciable effect on the bond strength. After 100 hours at room temperature, the high bond strength is maintained.

Temperature Cycling Resistance: High bond strength is maintained after cycling six times through:

8 hours at -4°F (-20°C)

8 hours at 150°F (65°C) /90% RH

Chemical Resistance: When properly applied, nameplate and decorative trim parts will hold securely after exposure to numerous chemicals including oil, mild acids, and alkalis.

**Handling/Application Information****Application Examples**

- Foam to powder coated painted surfaces.
- Low surface energy plastic adhesion.

**Application Techniques**

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application will assist the adhesive in developing intimate contact with the bonding surface.

To obtain optimum adhesion, the bonding surfaces must be clean, dry, and well unified. Typical surface cleaning solvents are methyl ethyl ketone for metals or isopropyl alcohol for plastics.\*

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.

\*When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturers precautions and directions for use. These cleaning recommendations may not be compliant with the rules of certain Air Quality Management Districts in California; consult applicable rules before use.

**Handling/Application Information (continued)****Application Equipment**

To apply adhesives in a wide web format, lamination equipment is required to ensure acceptable quality. To learn more about working with pressure-sensitive adhesives please refer to technical bulletin, 3M™ Lamination Techniques for Converters of Laminating Adhesives (70-0704-1430-8).

For additional dispenser information, contact your local 3M sales representative, or the toll free 3M sales assistance number at 1-800-362-3550.

**Storage and Shelf Life**

Store in original cartons at 70°F (21°C) and 50% relative humidity.

If stored under proper conditions, product retains its performance and properties for 24 months from date of manufacture.

**Trademarks**

3M is a trademark of 3M Company.

**References**

Property	Values
3m.com Product Page	<a href="https://www.3m.com/3M/en_US/company-us/all-3m-products/~/~3M-Adhesive-Transfer-Tape-9627X/?N=5002385+3293241360&amp;rt=rud">https://www.3m.com/3M/en_US/company-us/all-3m-products/~/~3M-Adhesive-Transfer-Tape-9627X/?N=5002385+3293241360&amp;rt=rud</a>
Safety Data Sheet SDS	<a href="https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=9627">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=9627</a>

**Family Group**

	9626	9627
Long Term Temperature Resistance (°F) Test Condition: Long Term (day, weeks)	200	200
Short Term Temperature Resistance (°C) Test Condition: Short Term (minutes, hour)	176.6667	176.6667
Liner Color Test Name: Primary	Natural	Natural
Long Term Temperature Resistance (°C) Test Condition: Long Term (day, weeks)	93.33333	93.33333
Total Tape Thickness (mm)	0.05	0.13
Adhesive Type	Acrylic	Acrylic
Liner	60# Glassine	60# Glassine
Liner Thickness (mm)	0.08	0.08

## ISO Statement

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

## Information

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