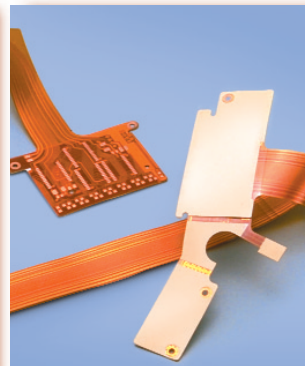
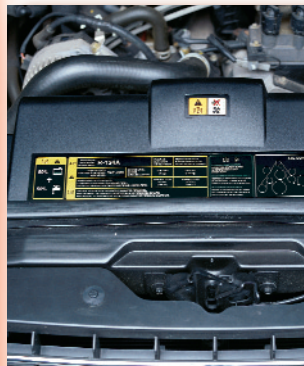
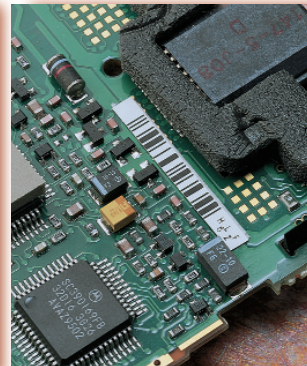
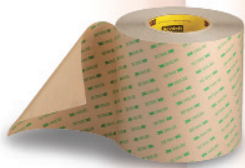




High Temperature Laminating Adhesives

*Brake pads,
flex circuits,
labels, and
more...*

*efficient
attachment
with the
strength
to take the
stress and
the heat*



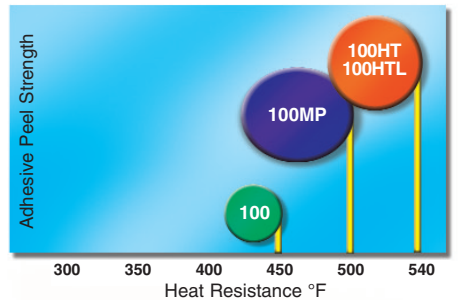
Reliable high performance attachment for high te

3M™ Adhesive Series 100: choice of characteristics for performance at temperatures ranging from 450°F to 540°F

Series 100 Adhesives are pressure sensitive formulations that perform reliably at various high temperatures. Each combines different characteristics for specific end use and processing requirements.

All attach immediately and invisibly without the work and appearance of mechanical fasteners or the dripping and drying of liquid adhesives.

Peel strength and Temperature resistance



Application Ideas

- Flexible circuit assembly and rigidizing
- Attachment of heat-generating components and heat sinks to PCBs



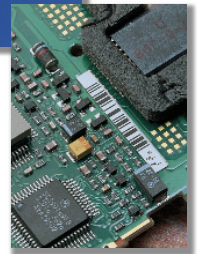
- Appliance electronics



- High temperature labels for appliances and under the hood in vehicles



- High temperature performance for military applications



- PCB tracking labels

- Battery pack assembly and labels
- Fixture assemblies for automotive and other lighting

- LED back planes
- Automotive brake pad and shim assembly



- Audio system electronics and speaker assembly

- Window blind attachment
- Machine bearing gasket attachment

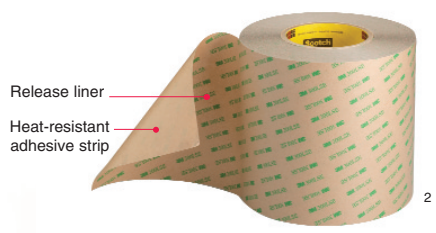
See more on back cover

100 High Temperature Acrylic

- Up to 450°F short term heat resistance
- Excellent solvent resistance
- High peel strength compared to other acrylic formulations
- Exceptional shear strength even at high temperatures
- Low outgassing

3M™ Adhesive Transfer Tape with 100, 100MP, or 100HT

3M™ Adhesive Transfer Tapes are rolls of pressure sensitive adhesive pre-applied to a release liner. For bonding, the tape is simply pressed, adhesive side down, to a surface and the release liner is peeled off. The exposed adhesive is ready to hold the mating surface.

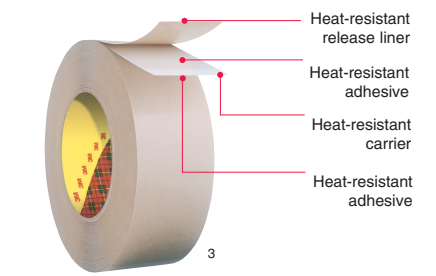


100MP High Performance Acrylic

- Up to 500°F short term heat resistance
- Outstanding solvent resistance
- Higher peel strength than 100
- Exceptional shear strength even at elevated temperatures

3M™ Double-coated Tape with 100HTL

Double-coated tape features adhesive on both sides of a heat-resistant carrier. The carrier provides stability for handling. The liner used with 100HTL is also heat resistant for use in processing such as lead-free solder reflow.



100HT Ultra High Temp Acrylic

- Similar to 100MP but with up to 540°F heat resistance and higher peel strength

100HTL Ultra High Temp Acrylic

- Similar to 100HT but with high temperature resistant liner and carrier

Temperature applications and processes

Product Selection Guide

| 3M™ Adhesive Transfer Tapes | | | | | | | | | | | | | | |
|---|---------|--|-----------------------|----------------|--------------|--------------|-------------------|----------|-------------|-------------|------|---------------|-------------|---------|
| Adhesive Family | Product | Description/Application Ideas | Adhesive Caliper Mils | Liner | | Master Size | Specs | Adhesion | | | | Chem. Resist. | Temp. Range | |
| | | | | Type | Caliper Mils | | | Metal | HSE Plastic | LSE Plastic | Foam | | Low °F | High °F |
| 100 High Temperature Acrylic | 941 | Graphic attachment for low odor appliance applications. | 2 | 58# PCK | 4.2 | 48" x 180 yd | UL | 9 | 8 | 1 | 2 | 9 | -40 | 450 |
| | 941N | Same as 941 on a heavy, lay-flat liner for kiss-cutting. | 2 | 83# PCK | 6.2 | 48" x 180 yd | | | | | | | | |
| | 965 | Fuel line labels, excellent chemical resistance. Aerospace. | 2 | 55# DK | 3.2 | 48" x 180 yd | | | | | | | | |
| | 966 | Meets NASA low volatility specs. Flex circuit attachment. High temp. | 2 | 62# DK | 3.8 | 48" x 180 yd | UL M ¹ | | | | | | | |
| | 9461P | Thinner version of laminating adhesive 9462P. | 1 | 55# DK | 3.2 | 48" x 360 yd | | | | | | | | |
| | 9462P | Laminating adhesive 966 on a caliper-controlled liner for rotary die-cutting. | 2 | 55# DK | 3.2 | 48" x 360 yd | UL | | | | | | | |
| 100MP High Performance Acrylic | F9460PC | High performance for flex circuit rigidizing, aerospace and industrial joining, and high temp labels. | 2 | 58# PCK | 4.2 | 60" x 180 yd | UL | 10 | 7 | 1 | 2 | 10 | -40 | 500 |
| | F9469PC | High performance for PCB component and heat sink attachment, flex circuit assembly, brake shims, battery pack assembly, window blind labels. | 5 | 58# PCK | 4.2 | 60" x 180 yd | UL | | | | | | | |
| | F9473PC | High performance for gasket attachment, metal fabrication, brake pads, LED back planes, lighting fixtures, PCB component attachment. | 10 | 58# PCK | 4.2 | 60" x 180 yd | UL | | | | | | | |
| 100HT Ultra High Temperature Acrylic | 9082 | Excellent heat resistance in high temp environments. For applications that require both higher processing and operating temperatures. | 2 | White DK Liner | 3.2 | 48" x 180 yd | | 10 | 7 | 1 | 2 | 10 | -40 | 540 |
| | 9085 | Thicker version of 9082 | 5 | White DK Liner | 3.2 | 48" x 180 yd | | | | | | | | |

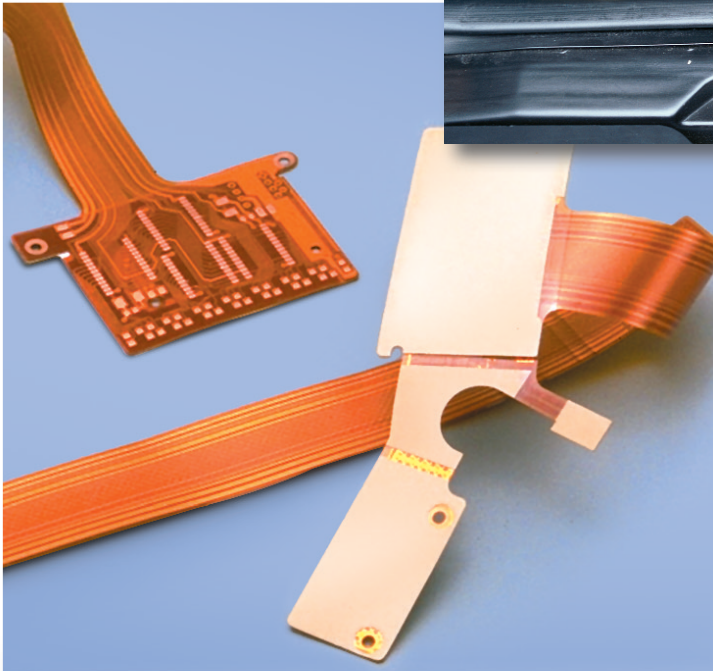
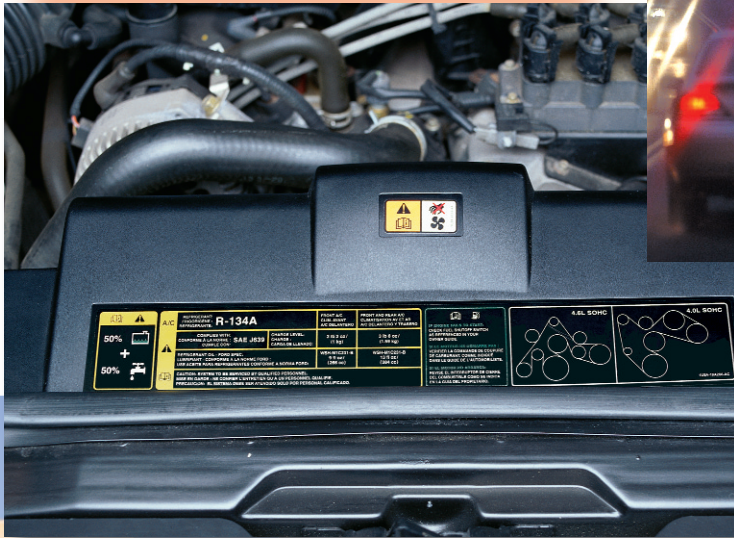
| 3M™ Double-coated Tape | | | | | | | | | | | | | | |
|--|------|--|---|----------------|-----|--------------|--|----|---|---|---|----|-----|-----|
| 100HTL Ultra High Temperature Acrylic | 9077 | Same as 9082 but with heat-resistant liner and carrier for use in lead-free solder reflow. | 2 | White DK Liner | 3.2 | 48" x 180 yd | | 10 | 7 | 1 | 2 | 10 | -40 | 530 |

| 3M™ Performance Label Materials | | | | | | | | |
|---------------------------------|---------|---|--------------|-------------------------------|--|--------------|----------|---------------------|
| Facestock | Product | Typical Performance Characteristics | Construction | | Roll Width Minimum Pre-Slit sizes (shown in red) | Print Method | Specs | |
| | | | Caliper Mils | Facestock Adhesive Type Liner | | | | |
| Polyimide White | 7811 | Offers ultra-high temperature performance. Easy readability of variable information and bar codes. | 2.0 | Matte Kapton® TC | 12" | DMI | UL | |
| | | | 2.0 | | | | | 100 |
| | | | 3.0 | 50# Densified Kraft | 6" | | CSA RoHS | |
| | 7812 | Offers ultra-high temperature performance. Easy readability of bar codes. Thermal transfer printable. | 3.0 | Kapton®, Matte White | 12" | TT | UL | |
| | | | 2.0 | | | | | 100 |
| | | | 3.2 | | | | | 50# Densified Kraft |

Note: The technical information and data provided here should be considered representative or typical only and should not be used for specification purposes.



More Application Ideas



Clockwise from upper left:

- 3M™ Adhesive Transfer Tape F9473PC with 100MP High Performance Acrylic bonds brake pads
- 3M™ Performance Label Material 7811 combines 3M™ Adhesive 100 with a Kapton™ backing for labeling in the temperatures under the hood of a vehicle
- For automotive lighting, lighting fixtures, and LED back planes, 3M™ Adhesive Transfer Tape F9473PC bonds many substrates and resists from -40°F to 500°F
- Liner, carrier, and adhesive of 3M™ Adhesive Double-coated Tape 9077 withstand the high temperatures of flex circuit processing.

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