# 904 (ATG Version) Transfer Tape

## Product Data Sheet

Updated : June 2000
Supersedes : Fenruary 1996

**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** | Acrylic | **3M ref :** |
| **Thickness** (ASTM D-3652)<br>Tape<br>Liner<br>Total | <br>0.05 mm<br>0.10 mm<br>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**<br>ASTM D-3330 | 904 adheres well to most high energy surfaces and plastic materials (ABS, PP, etc).<br>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.<br>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.