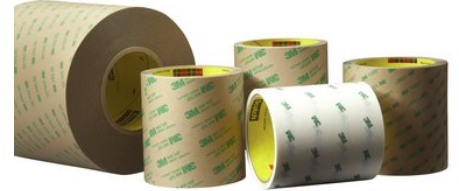


May, 2017

3M™ Adhesive Transfer Tape 9372DKW

Product Description

3M™ Adhesive Transfer Tapes are acrylic based and specially formulated to provide a permanent bond between substrates in environments requiring regulatory compliance with flame retardant standards such as Federal Aviation Regulation 25.853.



Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Physical Properties

Property	Values	
Color	Off White (opaque)	
Thickness Tolerance	±15 %	
Adhesive Type	Tackified Acrylic, 300FR Series	
Adhesive Carrier	None	
Adhesive Thickness	0.051 mm	2 mil
Areal Density	75 g/m ²	
Liner	Densified Kraft, "DK" suffiz, Designed for Rotary Die Cutting	
Liner Thickness	0.1 mm	4 mil
Liner Color	White, unprinted	
Net Weight	55 lb/Ream	

Typical Performance Characteristics

Relative High Temperature Operating Ranges		Test Condition
121 °C	250 °F	Short Term (minutes, hours)
82 °C	180 °F	Long Term (days, weeks)

Property: Relative High Temperature Operating Ranges

90° Peel Adhesion		Dwell/Cure Time	Substrate
7.7 N/cm	70 oz/in	Initial	Stainless Steel
7.9 N/cm	72 oz/in	72 hr @ Room Temperature	Stainless Steel
6.9 N/cm	63 oz/in	72 hr @ Room Temperature	Polycarbonate (PC)
5.3 N/cm	48 oz/in	72 hr @ Room Temperature	Polypropylene (PP)
5.6 N/cm	51 oz/in	72 hr @ Room Temperature	High Density Polyethylene (HDPE)
6.8 N/cm	62 oz/in	72 hr @ Room Temperature	ABS
8.5 N/cm	98 oz/in	Ultimate (72 hr, 158°F)	Stainless Steel

Property: 90° Peel Adhesion
Method: ASTM D3330

Typical Performance Characteristics (continued)

Property	Values		Method	Test Condition	Notes	Dwell/Cure Time
Static Shear	>10,000 min		ASTM D3654	1000 g @ Room Temperature	1 in ² sample size	
Static Shear	>10,000 min		ASTM D3654	500 g @ 70°C (158°F)	1 in ² sample size	
Solvent Resistance	Very Good					
UV Resistance	Very Good					
180° Peel Adhesion	12.8 N/cm	115 oz/in				72 hr @ Room Temperature

Available Sizes

Property	Values	
Normal Slitting Tolerance	±0.8 mm	±1/32 in
Precision Slitting Capability	±0.1 mm	±0.004 in
Core Size (ID)	76.2 mm	3 in

Available Sizes:

Minimum Slit Width:	1" up to 3"	1/2" up to 3"	2" up to 3"
minimum length	60 yards	60 yards	60 yards
maximum length	180 yards	180 yards	180 yards
3" to 30"	60 yards	60 yards	60 yards
maximum length	720 yards	720 yards	720 yards
31" to 48"	–	–	60 yards
maximum length	–	–	500 yards
31" to 60"	60 yards	60 yards	–
maximum length	500 yards	500 yards	–

Certifications/Standards

Property	Values
Federal Aviation Regulations, FAR 25.853	Yes
Underwriter Laboratories 94, UL-94 (V-2)	No

Handling/Application Information

Application Ideas

This family of products has been formulated for applications requiring flame retardancy and high bond strength to a wide variety of substrates. These attributes and choice of three product thicknesses make the products ideally suited to applications in aerospace, maritime, electronic, automotive and building construction applications on both smooth and textured substrates.

Application Techniques

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure helps develop better adhesive contact and improve bond strength. 15 psi momentary pressure is typical.

Ideal tape application temperature range is 70°F to 100°F (21°C to 37°C). Initial tape application to surface at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once applied, low temperature holding is generally satisfactory.

Surfaces should be clean and dry prior to bonding. We recommend a final surface cleaning with a mixture of 50% isopropyl alcohol* and water.

Two liner options facilitate wide array of application techniques. Densified kraft liner ideal for roll to roll lamination and subsequent rotary die cutting. Heavy caliper, layflat, polycoated kraft liner, minimizes surface asperities, minimizes distortion of pre-laminated substrates in variable humidity conditions and provide convenient backing for kiss cutting operations.

*Carefully read and follow the manufacturer's precautions and directions for use when using cleaning solvents.

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, 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 under normal conditions of 70°F (21°C) and 50% relative humidity in the original carton.

To obtain best performance, use this product within 24 months from date of manufacture.

Industry Specifications

FAR 25.853

Information

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

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Trademarks

3M is a trademark of 3M Company.

References

Safety Data Sheet (SDS)

https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=9372DKW

Family Group

	9372W	9372DKW	9375W
Relative High Temperature Operating Ranges (°C) Test Condition: Short Term (minutes, hours)	121	121	121
Relative High Temperature Operating Ranges (°C) Test Condition: Long Term (days, weeks)	82	82	82
Color	Off White (opaque)	Off White (opaque)	Off White (opaque)

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3M™ Adhesive Transfer Tape 9372DKW

Family Group (continued)

	9372W	9372DKW	9375W
Adhesive Type	Tackified Acrylic, 300FR Series	Tackified Acrylic, 300FR Series	Tackified Acrylic, 300FR Series
Adhesive Carrier	None	None	None
Adhesive Thickness (mm)	0.051	0.051	0.127
Liner	Polycoated Kraft, Layflat and Moisture Stable Liner	Densified Kraft, "DK" suffiz, Designed for Rotary Die Cutting	Polycoated Kraft, Layflat and Moisture Stable Liner
Liner Thickness (mm)	0.17	0.1	0.17
Liner Color	Tan, unprinted	White, unprinted	Tan, unprinted

ISO Statement

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

