



Adhesive Transfer Tapes with Adhesive 300LSE

8132LE • 8153LE • 9453LE • 9471LE •
9472LE • 9653LE • 9671LE • 9672LE

Technical Data

September 2017

Product Description 3M™ Adhesive Transfer Tapes with 3M™ Low Surface Energy Acrylic Adhesive 300LSE provides high bond strength to most surfaces, including many low surface energy plastics such as polypropylene and powder coated paints. The acrylic adhesive also provides excellent adhesion to surfaces contaminated lightly with oil typically used with machine parts.

| Product Construction | Product Number | Adhesive (Solvent Free) | Liner |
|----------------------|-----------------------------------|--|--|
| | 3M™ Adhesive Transfer Tape 8132LE | 2.3 mils (58 microns) 3M High Strength Acrylic Adhesive 300LSE | 4.0 mils (102 microns) 58# Polycoated kraft 6.2 mils (157 microns) 83# Polycoated kraft |
| | 3M™ Adhesive Transfer Tape 8153LE | 3.6 mils (91 microns) 3M High Strength Acrylic Adhesive 300LSE | 4.0 mils (102 microns) 58# Polycoated kraft 6.2 mils (157 microns) 83# Polycoated kraft |
| | 3M™ Adhesive Transfer Tape 9453LE | 3.6 mils (91 microns) 3M High Strength Acrylic Adhesive 300LSE | 4.2 mils (107 microns) 58# Polycoated kraft |
| | 3M™ Adhesive Transfer Tape 9471LE | 2.3 mils (58 microns) 3M High Strength Acrylic Adhesive 300LSE | 4.0 mils (102 microns) 58# Polycoated kraft |
| | 3M™ Adhesive Transfer Tape 9472LE | 5.2 mils (132 microns) 3M High Strength Acrylic Adhesive 300LSE | 4.2 mils (107 microns) 58# Polycoated kraft |
| | 3M™ Adhesive Transfer Tape 9653LE | 3.6 mils (91 microns) 3M High Strength Acrylic Adhesive 300LSE | 6.2 mils (157 microns) 83# Polycoated kraft |
| | 3M™ Adhesive Transfer Tape 9671LE | 2.3 mils (58 microns) 3M High Strength Acrylic Adhesive 300LSE | 6.2 mils (157 microns) 83# Polycoated kraft |
| | 3M™ Adhesive Transfer Tape 9672LE | 5.2 mils (132 microns) 3M High Strength Acrylic Adhesive 300LSE | 6.2 mils (157 microns) 83# Polycoated kraft |

3M™ Adhesive Transfer Tapes with Adhesive 300LSE

8132LE • 8153LE • 9453LE • 9471LE • 9472LE • 9653LE • 9671LE • 9672LE

Typical
Adhesion
Properties

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

Peel Adhesion - ounces/inch (Newtons/100 mm) ASTM D3330, modified:
90° peel, 2 mil aluminum backing.

Typical Adhesion Chart

| | 3M™ Adhesive Transfer Tape | 15 Minute Room Temperature | | 72 Hour Room Temperature | |
|-----------------|----------------------------|----------------------------|----------|--------------------------|----------|
| | | Oz./In. | N/100 mm | Oz./In. | N/100 mm |
| Stainless Steel | 8132LE | 71 | 78 | 75 | 82 |
| | 8153LE | 90 | 98 | 100 | 109 |
| ABS | 8132LE | 70 | 77 | 79 | 86 |
| | 8153LE | 80 | 88 | 113 | 124 |
| Polypropylene | 8132LE | 69 | 75 | 74 | 81 |
| | 8153LE | 89 | 97 | 103 | 113 |
| Stainless Steel | 9453LE | 90 | 98 | 100 | 109 |
| | 9471LE | 71 | 78 | 75 | 82 |
| | 9472LE | 109 | 119 | 140 | 153 |
| ABS | 9453LE | 80 | 88 | 113 | 124 |
| | 9471LE | 70 | 77 | 79 | 86 |
| | 9472LE | 102 | 112 | 128 | 140 |
| Polypropylene | 9453LE | 89 | 97 | 103 | 113 |
| | 9471LE | 69 | 75 | 74 | 81 |
| | 9472LE | 115 | 126 | 136 | 149 |
| Stainless Steel | 9653LE | 90 | 98 | 100 | 109 |
| | 9671LE | 71 | 78 | 75 | 82 |
| | 9672LE | 109 | 119 | 140 | 153 |
| ABS | 9653LE | 80 | 88 | 113 | 124 |
| | 9671LE | 70 | 77 | 79 | 86 |
| | 9672LE | 102 | 112 | 128 | 140 |
| Polypropylene | 9653LE | 89 | 97 | 103 | 113 |
| | 9671LE | 69 | 75 | 74 | 81 |
| | 9672LE | 115 | 126 | 136 | 149 |

3M™ Adhesive Transfer Tapes with Adhesive 300LSE

8132LE • 8153LE • 9453LE • 9471LE • 9472LE • 9653LE • 9671LE • 9672LE

Typical Adhesion Properties
(continued)

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

The properties defined are based on the attachment of impervious faceplate materials (such as aluminum) to a stainless steel test surface.

Bond Build-up: The bond strength of 3M™ Adhesive 300LSE increased as a function of time and temperature, and has very high initial adhesion.

Humidity Resistance: High humidity has a minimal effect on adhesive performance. No significant reduction in bond strength is observed after exposure for 7 days at 90°F (32°C) and 90% relative humidity.

U.V. 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 four times through:

- 4 hours at 158°F (70°C)
- 4 hours at -20°F (-29°C)
- 4 hours at 73°F (22°C)

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

Temperature Resistance: 3M™ Adhesive 300LSE is usable for short periods (minutes, hours) at temperatures up to 300°F (148°C) and for intermittent longer periods of time (days, weeks) up to 200°F (93°C).

Lower Service Temperature: -40°F (-40°C).

Available Sizes

Width and Length (subject to minimum order requirements):

| | 3M™ Adhesive Transfer Tapes 8132LE, 8153LE* | 3M™ Adhesive Transfer Tapes 9453LE, 9471LE, 9472LE, 9653LE, 9671LE, 9672LE |
|----------------------------|--|--|
| Standard Sheet Size: | 24 in. x 36 in. | – |
| Limitations: | Maximum 360 yards | 1/2 in. to 63/64 in.: Maximum 180 yards 1 in. to 54 in.: Maximum 360 |
| Minimum Slit Width: | 12 in. | 1/2 in. |
| Maximum Slit Width: | 48 in. | 54 in. |
| Normal Slitting Tolerance: | ± 1/32 in. | ± 1/32 in. |
| Core | 6.0 in. | 3.0 in. |

*Custom sheets are available.

3M™ Adhesive Transfer Tapes with Adhesive 300LSE

8132LE • 8153LE • 9453LE • 9471LE • 9472LE • 9653LE • 9671LE • 9672LE

- Features
- 3M™ Adhesive 300LSE is a hi-strength acrylic adhesive that provides a very high bond strength to most surfaces.
 - Excellent bond to low surface energy plastics such as polypropylene and powder coatings.
 - Excellent adhesion to lightly oiled surfaces typical of machine parts.
 - Thickness range of 2.0 mils, 3.5 mils, 5.0 mils and 8.5 mils for use on smooth, or rough surfaces.
 - Extremely smooth adhesive for excellent graphics appearance.
 - Double lined for selective die-cutting.
 - Polycoated kraft liner for die-cutting end tabs and waste removed nameplates on a common carrier.
 - 3M™ Adhesive Transfer Tapes 8132LE and 8153LE are double lined for selective die-cutting.
-

Application Techniques

For maximum bond strength, the surface should be thoroughly cleaned and dried. Typical cleaning solvents are heptane or isopropyl alcohol. Carefully read and follow manufacturer's precautions and directions for use when using cleaning solvents.

Bond strength can also be improved with firm application pressure and moderate heat, from 100°F to 130°F (38°C to 54°C), causing the adhesive to develop intimate contact with the bonding surface.

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 for most pressure-sensitive adhesives because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

- Application Ideas
- Plastic nameplates or graphic overlays for use on low surface energy plastics.
 - Waste removed nameplates on a common sheet for ease of application.
 - Attaching membrane switch assemblies to powder coated surfaces and low surface energy plastics.
 - Graphic overlays with end tabs for easy liner removal.
 - Graphic application to surfaces such as wood, fabric, plastic, where very high bond strength is required.
 - Attaching identification material to lightly oily surfaces typical of machine parts.
-

General Information

Processing:

Slitting and die-cutting: This adhesive is very aggressive and may be difficult to convert depending on your application requirements. Chilling the adhesive between 35°F and 50°F will improve the processability. In addition, dies can be lubricated with Laminoleum evaporative stamping oil, which is available from Metal Lubricants Company (708-333-8900), or with Lubri-Blade 907 from Ceramic Technologies Inc. (800-258-8495). You may also refer to our Technical Bulletin on 3M™ Adhesive 300LSE converting. (70-0707-6205-2)

Roll Laminating: A combination of metal and rubber rollers with moderate pressure is recommended. Note: Please refer to the Technical Bulletin on slitting. (70-0709-3905-6)

3M™ Adhesive Transfer Tapes with Adhesive 300LSE

8132LE • 8153LE • 9453LE • 9471LE • 9472LE • 9653LE • 9671LE • 9672LE

Storage Store at room temperature conditions of 70°F (21°C) and 50% relative humidity.

Shelf Life If stored properly, product retains its performance and properties for 18 months from date of shipment.

**Recognition/
Certification**

TSCA: These products are defined as articles under the Toxic Substances Control Act and therefore, are exempt from inventory listing requirements.

MSDS: These products are not subject to the MSDS requirements of the Occupational Safety and Health Administration's Hazard Communication Standard, 29 C.F.R. 1910.1200(b)(6)(v). When used under reasonable conditions or in accordance with the 3M directions for use, the products should not present a health and safety hazard. However, use or processing of the products in a manner not in accordance with the directions for use may affect their performance and present potential health and safety hazards.

Note: One of 3M's core values is to respect our social and physical environment. 3M is committed to comply with ever-changing, global, regulatory and consumer environmental, health, and safety (EHS) requirements. As a service to our customers, 3M is providing information on the regulatory status of many 3M products. Further regulation information including that for OSHA, USCPPI, FDA, California Proposition 65, REACH and RoHS, can be found at 3M.com/regs.

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.

Product Selection and Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy and Disclaimer

Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability

Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.



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



Industrial Adhesives and Tapes Division
Converter Markets
3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-223-7427 • 651-778-4244 (fax)
www.3M.com/converter

3M is a trademark of 3M Company.
©3M 2017 E70-0709-3795-1 (9/17)