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Technical Data Sheet

3M™ Adhesive Transfer Tape 468MP

English-US

Last Revision Date: June, 2024

Supersedes: March, 2024

Product Details

Regulatory Info/SDS

Product Description

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

3M™ High Performance Acrylic Adhesive 200MP is a popular choice for graphic attachment and general industrial joining applications. It provides outstanding adhesion to metal and high surface energy plastics. This adhesive provides some initial repositionability for placement accuracy when bonding to plastics. It also performs well after exposure to humidity and hot/cold cycles.

Product Features

- Up to 400°F short-term heat resistance
- Excellent solvent resistance
- Excellent shear strength to resist slippage and edge lifting

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

Attribute Name	Test Method	Value
Adhesive Type		200MP Acrylic
Total Tape Thickness	ASTM D3652	0.13 mm (5.2 mil)
Liner		58# Polycoated Kraft Paper (PCK)
Liner Thickness		0.11 mm (4.2 mil)
Primary Liner Color		Clear

Typical Performance Characteristics

Dwell Time: 72 h
Backing: 2 mil Aluminum Foil
Test Method: ASTM D3330

Attribute Name	Temperature	Substrate	Value
90° Peel Adhesion	22 °C (72 °F)	Stainless Steel	11.8 N/cm (108 oz/in) [1]
90° Peel Adhesion	70 °C (158 °F)	Stainless Steel	20 N/cm (183 oz/in) [1]
180° Peel Adhesion	22 °C (72 °F)	Stainless Steel	15.1 N/cm (139 oz/in) [1]
90° Peel Adhesion	22 °C (72 °F)	ABS	3 N/cm (27 oz/in) [1]
90° Peel Adhesion	22 °C (72 °F)	Acrylic (PMMA)	8.9 N/cm (81 oz/in) [1]
90° Peel Adhesion	22 °C (72 °F)	Aluminum	9.2 N/cm (84 oz/in) [1]
90° Peel Adhesion	22 °C (72 °F)	Glass	12.3 N/cm (112 oz/in) [1]
90° Peel Adhesion	22 °C (72 °F)	Polycarbonate (PC)	9.6 N/cm (88 oz/in) [1]

[1] 12 in/min (300 mm/min)

Static Shear

Test Condition: 1000g

Temperature	Value
22 °C (72 °F)	10000+ min [1]
70 °C (158 °F)	10000+ min [1]

[1] 1 in x 1 in sample area, test terminated after 10,000 minutes

Substrate: Stainless Steel
Temperature: 22 °C (72 °F)
Dwell Time: 72 h
Backing: 2 mil Aluminum Foil
Test Method: ASTM D3654

Attribute Name	Environmental Condition	Test Condition	Value
Short Term Temperature Resistance	204°C (400°F)	500g wt for at least 60 min	60 min [1]
Long Term Temperature Resistance	149°C (300°F)	500g wt for at least 10,000 min	10,000 min [1]

[1] 6.5cm² (1in²) Sample area

Substrate: Aluminum
Temperature: 22 °C (72 °F)
Dwell Time: 72 h

Attribute Name	Test Method	Value
Overlap Shear Strength	ASTM D1002, ISO 4587	19.0 N/cm (174 lb/in²) [1]

[1] Pressure was obtained via a Mechanical Press set at 20psi for 15 seconds on 1 x 1 sample Crosshead speed 12 in/min

Typical Environmental Characteristics

Environmental Resistance

Humidity Resistance – High humidity has a minimal effect on adhesive performance. Bond strength shows no significant reduction after exposure for 7 days at 90°F (32°C) and 90% relative humidity.

UV Resistance – When properly applied, nameplates and decorative trim parts are not adversely affected by outdoor 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, nameplate and decorative trim parts will hold securely after exposure to numerous chemicals including oil, mild acids and alkalis.

Bond Build-up: The bond strength of 3M™ High Performance Acrylic Adhesive 200MP increases as a function of time and temperature

Temperature/Heat Resistance: 3M™ High Performance Acrylic Adhesive 200MP is usable for short periods (minutes, hours) at temperatures up to400°F (204°C) and for intermittent longer periods (days, weeks) up to 300°F (149°C).

Lower Temperature Service Limit: The glass transition temperature for 3M™ High Performance Acrylic Adhesive 200MP is -31°F (-35°C). Many applications survive below this temperature (factors affecting successful applications include: materials being bonded, dwell at RT before cold exposure, and stress below the TG [i.e. expansion/contraction stresses, impact]). Optimum conditions are: bonding high surface energy materials, longer time at RT before cold exposure, and little or no stress below the TG. The lowest service temperature is -40°F (-40°C).

Electrical and Thermal Properties

Temperature: 43 °C (109 °F)

Attribute Name	Test Method	Value
Thermal Conductivity	ASTM C518	0.19 W/m/K (1.24 (btu-in)/(h-ft²-°F)) [1]

[1] results listed are at 109ºF

Attribute Name	Test Method	Temperature	Test Condition	Value
Dielectric Constant	ASTM D150	22 °C (72 °F)	1 KHz	3.32
Dissipation Factor				0,0253
Dielectric Strength	ASTM D149		500 vac, rms[60 hz/sec]	674 V/mil
Insulation Resistance	Mil-I-46058C		test voltage = 100 VDC	>1.3 x 10^{15} Ω
Breakdown Voltage				4,500 V

Handling/Application Information

Application Examples

• Long term bonding of graphic nameplates and overlays (“subsurface” printed polycarbonate or polyester) to metal and high surface energy plastics in the aerospace, medical and industrial equipment, automotive, appliance and electronics markets.
• Bonding metal nameplates and rating plates in the aerospace, medical and industrial equipment, automotive, appliance and electronics markets.
• Bonding graphic overlays for membrane switches and for bonding the complete switch to the equipment surface.
• High speed processing of parts in the medical, telecommunications and electronics markets (medical components, durable labels, and flexible circuits).
• Lamination to industrial foams for rotary die-cutting of small gaskets for industrial and electronics markets.

Application Techniques

For maximum bond strength (during installation of the final part) the surface should be thoroughly cleaned and dried. Typical cleaning solvents are heptane (for oily surfaces) or isopropyl alcohol for plastics. Use reagent grade solvents since common household materials like rubbing alcohol frequently contain oils to minimize the drying affect on skin and can interfere with the performance of a pressure-sensitive adhesive.

*Note: Carefully read and follow the manufacturer’s precautions and directions for use when working with solvents. These cleaning recommendations may not be in compliance with the rules of certain air quality management districts in California; consult applicable rules before use.

It is necessary to provide pressure during lamination (1.5-20 pli recommended) and during final part installation (10-15 psi) to allow the adhesive to come into direct contact with the substrate. Using a hard edged plastic tool, which is the full width of the laminated part, helps to provide the necessary pressure at the point of lamination. Heat can increase bond strength when bonding to metal parts (generally this same increase is observed at room temperature over longer times, weeks). For plastic parts, the bond strength is not enhanced with the addition of heat.

The ideal adhesive application temperature range is 60°F (15.6°C) to 100°F (38°C). Application is not recommended if the surface temperature is below 50°F (10°C) because the adhesive becomes too firm to adhere readily. Once properly applied, at the recommended application temperature, low temperature holding is generally satisfactory (please refer to section VII of the Typical Physical Properties and Performance Characteristics).

When bonding a thin, smooth, flexible material to a smooth surface, it is generally acceptable to use 2 mils of 3M™ Adhesive 200MP. If a texture is visible on one or both surfaces, the 5 mil 3M adhesive 200MP would be suggested. If both materials are rigid, it may be necessary to use a thicker adhesive to successfully bond the components. 3M™ VHB™ Acrylic Foam Tapes may be required (please refer to the data page 70-0709-3830-6).

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 16° to 27°C (60° to 80°F) and 40 to 60% relative humidity in the original packaging, out of direct sunlight. For best performance, use this product within 24 months from date of manufacture.

Recognition/Certification

TSCA: This product is defined as an article under the Toxic Substances Control Act and therefore, it is exempt from inventory listing requirements

MSDS:3M has not prepared a MSDS for this product which is not subjected 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, this product should not present a health and safety hazard. However, use or processing of the product in a manner not in accordance with the directions for use may affect its performance and present potential health and safety hazards.

UL: These products have been recognized by Underwriters Laboratories, Inc. under Ul 746C and UL 969. For more information on the UL Certification, please visit the website at http://www.3M.com/converter, select UL Recognized Materials, then select the specific product area.

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, USCPSI, California Proposition 65, READY and RoHS, can be found at 3M.com/regs.

Automotive Disclaimer

Select Automotive Applications:
This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

Information

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ISO Statement

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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