

3M

Polyester Tape

8402

Technical Data

Product Description 3M™ Polyester Tape 8402 is a film tape with a silicone adhesive for composite bonding and splicing of many silicone release papers.

Product Construction	Backing	Adhesive	Color	Standard Roll Length
	Transparent polyester film	Silicone with a green pigment	Translucent green	72 yds. (66 m)

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

		ASTM Test Method
Adhesion to Steel:	24 oz./in. width (26 N/100 mm)	D-3330
Tensile Strength at Break:	33 lbs./in. width (578 N/100 mm)	D-3759
Elongation at Break:	120%	D-3759
Backing Thickness:	1.0 mils (0.03 mm)	D-3652
Total Tape Thickness:	1.8 mils (0.05 mm)	D-3652
Temperature Use Range:	Removes cleanly and remains flexible after 3 hours, 350°F (177°C), in autoclave.	

- Features**
- Abrasion, chemical and thermal resistant.
 - Retains flexibility from -60° to 350°F (-50° to 177°C).
 - Higher heat resistance as compared with acrylics.
 - Easy and clean removability.

- Application Ideas**
- Masking edges of overlap seams in metal bonding process where the excess epoxy (“flash”) flows onto the tape. Clean-up is complete when the tape is removed.
 - Protective overall mask on panels subject to mild caustic or acid bath etching and to prevent scratches during handling prior to bonding operations.
 - Holding of parts or vacuum bags during bonding operation.
 - Mask for metal in acid or caustic chemical milling baths.
 - Paint mask for areas subject to high temperature bake cycles.
 - Splicing of silicone liners and papers.
 - Splicing of films subject to high temperatures.

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Storage Store under normal conditions of 70°F (21°C) and 50% R.H. in the original carton.

Shelf Life To obtain best performance, use this product within one year from date of manufacture.

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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.

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Industrial Adhesives and Tapes Division**

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Printed in U.S.A.
©3M 70-0709-4592-1 (1999/7/05)