

June, 2003

## 3M™ Splicing Tape 415

### Product Description

3M™ Splicing Tapes utilize an acrylic pressure sensitive adhesive system that offers a balance of initial adhesion and good holding power.



### 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 Performance Characteristics

Property	Values		Method	Substrate
Peel Adhesion	2.7 N/cm	25 oz/in	ASTM D3330	Stainless Steel
Solvent Resistance	Good			
UV Resistance	Excellent			

Relative High Temperature Operating Ranges		Test Condition
82 °C	180 °F	Short Term (minutes, hours)
65 °C	150 °F	Long Term (days, weeks)

Property: Relative High Temperature Operating Ranges

### Available Sizes

Property	Values	
Note	Subject to Minimum Order Requirements	
Standard Length	32.9 m	36 yd
Minimum Available Width	6.35 mm	1/4 in
Maximum Available Width	1219 mm	48 in
Normal Slitting Tolerance	± 0.8 mm	± 1/32 in
Core Size (ID)	76.2 mm	3 in

Maximum Length		Width
165 m	180 yd	1/4 in to 3/8 in widths
165 m	180 yd	3/8 in to 1/2 in width
329 m	360 yd	1/2 to 2 in widths
329 m	360 yd	2 in and greater

Property: Maximum Length

### Handling/Application Information

#### Application Ideas

- 3M™ Splicing Tape 415 can be used for high-speed flying splices and zero speed splices on most grades of paper such as newsprint, clay coated, corrugated stocks.

## Handling/Application Information (continued)

### 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.
- To obtain optimum adhesion, the bonding surfaces must be clean, dry, and well unified.
- 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 because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

### Storage and Shelf Life

Store in original cartons at 70°F (21°C) and 50% relative humidity.  
If stored under proper conditions, product retains its performance and properties for 24 months from date of manufacture.

### 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=415](https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=415)

### Family Group

	415	465	469	9420	9497	9499
Relative High Temperature Operating Ranges (°C) Test Condition: Short Term (minutes, hours)	82	121	180	82	177	260
Relative High Temperature Operating Ranges (°C) Test Condition: Long Term (days, weeks)	65	82	94	65	121	149

### ISO Statement

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

### For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550 or visit [www.3M.com/adhesives](http://www.3M.com/adhesives). Address correspondence to: 3M Industrial Adhesives and Tapes Division, Building 21-1W-10, 900 Bush Avenue, St. Paul, MN 55144-1000. Our fax number is 651-778-4244. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

### Product Selection and Use

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

## Warranty, Limited Remedy, and Disclaimer

Unless stated otherwise in 3M's product literature, packaging inserts or product packaging for individual products, 3M warrants that each 3M product meets the applicable specifications at the time 3M ships the product. Individual products may have additional or different warranties as stated on product literature, package inserts or product packages. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If the 3M product is defective within the warranty period, your exclusive remedy and 3M's and seller's sole obligation will be, at 3M's option, to replace the product or refund the purchase price.

## Limitation of Liability

Except where prohibited by law, 3M and seller will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability

