



3M™ Laminating Adhesives 467MP & 468MP

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DESCRIPTION

Adhesive Transfer Tape 467MP and 468MP are popular choices for graphic attachment and membrane switch applications because they have excellent quality, consistency and durability.

These products offer the following excellent performance characteristics: Clarity (virtually free of vapor inclusions that are commonly found in adhesives produced by the traditional solvent coating technique); Excellent high temperature performance as well as excellent shear strength (that minimizes edge lifting and slippage of parts); Excellent resistance to harsh environments: the adhesive can withstand splashes of organic solvents, weak acids and bases and salt water, cleaning solutions, germicidals, disinfectants, oils, etc.

In addition, these perform well after exposure to humidity and hot/cold cycles and provides some initial repositionability when bonding to plastic parts (not metal) which allows graphic parts to be lifted and repositioned if initial alignment is incorrect.

INTENDED APPLICATIONS

Application to high surface energy substrates (HSE). On an HSE substrate, adhesive spreads out to “wet” the surface to be bonded. The higher the surface energy, the better the bond performance. Most popular applications are for appliance, transportation and automotive, electronics and general industrial for name plates, graphic overlaps:

- 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 electronic markets.
- Bonding metal nameplates and rating plates in the aerospace, medical and industrial equipment, automotive, appliance and electronic 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, 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.

When bonding a thin, smooth, flexible material to a smooth surface, it is generally acceptable to use 3M 467MP. If a texture is visible on one or both surfaces, the 3M 468MP would be suggested. If both materials are rigid, it may be necessary to use a thicker adhesive to successfully bond the components.

PHYSICAL PROPERTIES

Product Number	Adhesive Type/Color	Adhesive Thickness (mils, mm)	Liner Color, Type, Print	Liner Caliper / Liner Release
3M Adhesive Transfer Tape 467MP	200MP/Clear	2.3 mils (0.06 mm)	Tan, 58#, Polycoated Kraft, "3M 467MP 200MP Adhesive"	4.2 mils 50 grams/inch
3M Adhesive Transfer Tape 468MP	200MP/Clear	5.2 mils (0.13 mm)	Tan, 58#, Polycoated Kraft, "3M 468MP 200MP Adhesive"	4.2 mils 50 grams/inch

SHELF LIFE AND STORAGE

Laminating adhesives should be used within 24 months from the manufacturing date and must be stored at 70° F (21° C) and at 50% relative humidity.

RELATED LITERATURE

Refer to Product Bulletins of relevant foils and materials for product-specific handling, production, and finishing information.

CONTACT INFORMATION

For help with questions concerning Gerber products, please call your distributor or Gerber Customer Service at 1-800-222-7446 or (860) 644-1551. Visit us on the Internet at www.gspinc.com to learn more about our many other foils, materials and equipment.

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