

Scotch[®] ATG Tapes

924 • 926 • 928 • 969 • 976 • 987

Technical Data

April, 2011

Product Description	Tape 924	0.05 mm thick adhesive transfer tape
	Tape 926	0.13 mm thick high performance adhesive transfer tape
	Tape 928	0.05 mm thick high-tack/low-tack double coated tape
	Tape 969	0.13 mm thick high-tack adhesive transfer tape
	Tape 976	0.05 mm thick high-tack adhesive transfer tape
	Tape 987	0.04 mm thick adhesive transfer tape

Tapes are reverse wound on 1-inch diameter cores for use in Scotch ATG dispensers.

Construction

Products	Tape 924	Tape 926	Tape 928	Tape 969	Tape 976	Tape 987
Adhesive Type:*	400	350	400/1000	300	300	400
Adhesive Carrier:	None	None	Tissue	None	None	None
Release Liner:	Tan Paper *DK	Tan Paper *DK	White Paper *PCK	Tan Paper *DK	Tan Paper *DK	Tan Paper *DK
Approximate Thickness: Release Liner	0.10 mm	0.10 mm	0.15 mm	0.13 mm	0.10 mm	0.09 mm
Tape Only	0.05 mm	0.13 mm	0.05 mm	0.13 mm	0.05 mm	0.04 mm
Tape Color:	Clear	Clear	White	Clear	Clear	Clear

*DK = densified kraft PCK = polycoated kraft

*Adhesive System 350 is a firm acrylic pressure-sensitive adhesive system. It features very high adhesion to a variety of surfaces, excellent shear holding power, high temperature resistance and excellent UV resistance.

Adhesive System 400 is a medium-firm acrylic pressure-sensitive adhesive system. It features an excellent balance of good initial adhesion (quick stick) and good shear holding power.

Adhesive System 400 is a medium-firm acrylic pressure sensitive adhesive system. It features high initial adhesion to a wide variety of materials and good shear holding power.

Adhesive System 300 is a soft acrylic pressure-sensitive adhesive system. It features very high initial adhesion and good shear holding power to a wide variety of materials including most plastics.

Adhesive System 1000 is a low-tack, repositionable acrylic pressure-sensitive adhesive.

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Typical Physical Properties and Performance Characteristics

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

Products	Tape 924	Tape 926	Tape 928	Tape 969	Tape 976	Tape 987
Adhesion to Steel: (ASTM D3330)	27 N/100 mm	163 N/100 mm	3 N/100mm. low-tack side high-tack side 13 N/100 mm	82 N/100 mm	66 N/100 mm	22 N/100 mm
Relative High Temperature Operating Ranges: Long Term (days, weeks)	82°C	149°C	49°C	82°C	82°C	82°C
Short Term (minutes, hours)	121°C	232°C	82°C	121°C	121°C	121°C
Relative Solvent Resistance:	Good	Very Good	Fair	Medium	Medium	Good
U.V. Resistance:	Excellent	Good	Good	Not recommended for direct exposure to sunlight or other sources of U.V. light.		Excellent
Shelf Life of Tape in Roll Form:	24 months from date of manufacture when stored in original cartons at 21°C and 50% relative humidity.					

Available Sizes

Available Lengths:	32.9 m 54.9 m	16.5 m 32.9 m	16.5 m 32.9 m	16.5 m 32.9 m	32.9 m 54.9 m	32.9 m 54.9 m
Available Widths:	6.4mm, 12.7mm. 19mm, 50.8mm.	6.4mm, 12.7mm. 19mm, 50.8mm.	6.4mm, 12.7mm.	6.4mm, 12.7mm. 19mm, 50.8mm.	6.4mm, 12.7mm. 19mm.	6.4mm, 12.7mm.
Normal Slitting Tolerance:	0.8 mm					
Core Size (ID)	25.4 mm	25.4 mm	25.4 mm	25.4 mm	25.4 mm	25.4 mm

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. Typical surface cleaning solvents are isopropyl alcohol and water (rubbing alcohol) or heptane. **Note:** Be sure to follow the manufacturer's precautions and directions for use when using solvents.
- Ideal tape application temperature range is 21°C to 38°C. Initial tape application to surfaces at temperatures below 10°C is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

General Information

- Tape 928 is a low-tack adhesive which allows removal from many papers, foils, and films without adhesive residue and will not cause delamination of most paper stocks. In many cases, the tape can be reused numerous times.
- Tape 928 will not bleed into most paper stocks which helps minimize possible discoloration or staining.
- Flexible materials will adhere better to tape 928 than will rigid materials (e.g., paper vs. cardboard). It may also be necessary to remove curl from certain materials to avoid having them pull away from the low-tack adhesive of tape 928 over a period of time.
- ATG tapes are a reverse wound version of standard 3M Adhesive Transfer and Double Coated tapes for use in the Scotch® ATG hand-held dispensers.

Comparable 3M tapes are: ATG Tape Comparable 3M ATT/DC Tape

924	465(9665)
926	9485
928	9416
969	950
987	9498
976	927

Note: The user should carefully evaluate the product under actual use conditions to determine whether it is fit for a particular purpose and suitable for the user’s method of application.

Application Ideas

- **Tape 924**
 Tape 924 is ideal for bonding a wide variety of similar and dissimilar materials such as metals, glass, wood, papers, paints, and many plastics. Some application ideas include:
 - Mounting promotional items, posters, etc.
 - Core starting.
 - Mounting picture frame mat boards and dust covers.
- **Tape 926**
 Tape 926 is ideal for applications requiring high bond strength, high shear strength and high temperature performance. Some application ideas are:
 - Nameplates on award plaques.
 - Bonding foam insulation.
 - Bonding folders and boxes that have a higher degree of memory.
- **Tape 928**
 Many repositionable, reusable, or reclosable uses such as:
 - Reclosable bags or envelopes
 - Core starting and end tabbing of papers, foils, and films
 - Novelty items
 - Removable stickers and labels
 - Point of purchase displays
 - Book inserts
 - Mounting promotional items
 - Removable/changeable advertisements
 - Temporary hold for protective packaging materials, such as foam or cardboard, used during shipment of manufactured goods

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Application Ideas (continued)

• Tapes 969 and 976

Tapes 969 and 976 are ideal for bonding materials with glossy coatings where an aggressive adhesive with high initial adhesion is desired. Some application ideas are:

- Folders and boxes
- Attach fabric swatches in sample books
- Assemble point-of-purchase displays

• Tape 987

This adhesive is ideal for adhesion to many paper materials but also works well on many surfaces. Some application ideas are:

- Pressure-sensitive edges for posters and point of purchase sales advertising.
- Mounting photos pre-press, prior to color scanning in lithography
- Mounting of novelty items, photographs, note pads, etc.

Certification/ Recognition

MSDS: 3M has not prepared a MSDS for these products which 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, these 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.

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

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/bonding. Address correspondence to: 3M Engineered Adhesives Division, 3M Center, Building 220-7E-01, St. Paul, MN 55144-1000. Our fax number is 651-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

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ISO 9002

This Engineered Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

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©3M 2000 70-0705-7564-5 (8/01)