

September, 2008

3M™ Extended Liner Tape 920XL

Product Description

3M™ Extended Liner Tapes have a liner that extends beyond the width of the adhesive to provide easy liner starting and removal. The liners (with the exception of 3M™ Extended Liner Tapes 450EK and 9934XL) are printed with the message, "Remove to Expose Adhesive".

Product Features

- The extended liner provides a dry edge on each side of the tape for easy liner removal. Stated product widths include the dry edge of the liner.
- 3M™ Extended Liner Tape 920XL is ideal for adhesion to paper materials but also work well on many other surfaces. Some application ideas are:
 - Pressure-sensitive edges for posters and point of purchase sales advertising.
 - Permanent mounting of novelty items, note pads, literature, posters and labels.
 - Pressure-sensitive edging on business forms.
- 3M™ Extended Liner Tape 920XL is ideal for pharmaceutical outsert attachment. 3M tape 450XL has a heavier liner than 3M tape 920XL to help reduce liner breakage during application.



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

| Property | Values | |
|------------------------------------|--|---------|
| Color | Clear | |
| Total Tape Thickness without liner | 0.025 mm | 1 mil |
| Adhesive | 400 Acrylic | |
| Liner | 43# Densified Kraft White Paper Red Printing | |
| Liner Thickness | 0.065 mm | 2.5 mil |
| *Note | 3M™ Adhesive 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. | |

Typical Performance Characteristics

| Property | Values | | Method | Substrate |
|--------------------|-------------|----------|------------|-----------------|
| Peel Adhesion | 2.2 N/cm | 20 oz/in | ASTM D3330 | Stainless Steel |
| Solvent Resistance | Medium/High | | | |
| UV Resistance | Excellent | | | |

| Relative High Temperature Operating Ranges | | Test Condition |
|--|--------|-----------------------------|
| 121 °C | 250 °F | Short Term (minutes, hours) |
| 82 °C | 180 °F | Long Term (days, weeks) |

Property: Relative High Temperature Operating Ranges

Available Sizes

| Property | Values | |
|-----------------|---------------------------------------|----------------|
| Note | Subject to Minimum Order Requirements | |
| Minimum Length | 914 m | 1000 yd |
| Maximum Length | 914 m | 1000 yd |
| Available Width | 12.7, 19.1, 25.4 mm | 1/2, 3/4, 1 in |

Table continued on next page

Available Sizes (continued)

| Property | Values | |
|-----------------------------------|----------|-----------|
| Normal Slitting Tolerance | ± 0.8 mm | ± 1/32 in |
| Liner Extension Width (each side) | 2.4 mm | 3/32 in |
| Core Size (ID) | 76.2 mm | 3.0 in |

Handling/Application Information**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. Some typical surface cleaning solvents are isopropyl alcohol and heptane.*
 - 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.
- *Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

Storage and Shelf Life

24 months from date of manufacture when stored in original cartons at 70°F (21°C) and 50% relative humidity.

Trademarks

3M is a trademark of 3M Company.

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=920XL

Family Group

| | 450EK | 450XL | 465XL | 466XL | 476XL | 920XL | 9925XL | 9926XL | 9934XL |
|--|-------|-------|-------|-------|-------|-------|-----------------------|--------|--------------------------|
| Relative High Temperature Operating Ranges (°C) Test Condition: Short Term (minutes, hours) | 121 | 121 | 121 | 121 | 65 | 121 | 65 | | 66 |
| Relative High Temperature Operating Ranges (°C) Test Condition: Long Term (days, weeks) | 82 | 82 | 82 | 82 | 50 | 82 | 41 | | 49 |
| Color | Clear | Clear | Clear | Clear | Clear | Clear | Off-White Translucent | Clear | Clear - slight amber hue |
| Total Tape Thickness without liner (mm) | 0.025 | 0.025 | 0.05 | 0.05 | 0.16 | 0.025 | 0.065 | 0.025 | 0.1 |

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Family Group (continued)

| | 450EK | 450XL | 465XL | 466XL | 476XL | 920XL | 9925XL | 9926XL | 9934XL |
|----------------------|----------------------------|--|--|--|--|--|--|--|-------------------------|
| Adhesive | 400 Acrylic | 400 Acrylic | 400 Acrylic | 340 Acrylic | 760 Rubber | 400 Acrylic | 770 Rubber | *400 Acrylic | *600 |
| Liner | 70# White Extensible Kraft | 60# Kraft Glassine, Tan Green Printing | 60# Densified Kraft Tan Paper Green Printing | 62# Densified Kraft Off-White Paper Black Printing | 43# Densified Kraft White Paper Red Printing | 43# Densified Kraft White Paper Red Printing | 43# Densified Kraft White Paper Black Printing | 43# Densified Kraft White Paper Red Printing | 60# Semi-bleached Kraft |
| Liner Thickness (mm) | 0.146 | 0.09 | 0.09 | 0.11 | 0.08 | 0.065 | 0.05 | 0.065 | 0.09 |

ISO Statement

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

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