



# Splicing Tapes

415 • 465 • 469 • 9420 • 9497 • 9499

Technical Data

June, 2003

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

## Construction

Products	3M™ Splicing Tape 415	3M™ Splicing Tape 465	3M™ Splicing Tape 469	3M™ Splicing Tape 9420	3M™ Splicing Tape 9499	3M™ Splicing Tape 9497
Adhesive Type:*	400	400	330	400	430	430
Adhesive Carrier:	Polyester Film	None	Tissue	Polyester Film	None	None
Release Liner:	Tan Paper	Tan Paper	White Silicone Coated Paper	Tan Paper	Tan Paper	Tan Paper
Approximate Thickness: Release Liner	0.004 in. (0.10 mm)	0.004 in. (0.10 mm)	0.005 in. (0.13 mm)	0.004 in. (0.10 mm)	0.003 in. (0.08 mm)	0.003 in. (0.08 mm)
Tape Only	0.004 in. (0.10 mm)	0.002 in. (0.05 mm)	0.0055 in. (0.14 mm)	0.004 in. (0.10 mm)	0.002 in. (0.05 mm)	0.002 in. (0.05 mm)
Tape Color:	Double Coated Film Clear	Adhesive Transfer Clear	Double Coated Film Light Red	Double Coated Film Red	Adhesive Transfer Clear	Adhesive Transfer Light Red
Liner:	Tan 60#, Densified Kraft	Tan 60#, Densified Kraft	72# Densified Kraft	Tan 60#, Densified Kraft	Tan 60#, Densified Kraft	Tan 60#, Densified Kraft

\*3M™ Adhesive 430 is a firm acrylic pressure sensitive adhesive which features both high initial adhesion and good high temperature holding power.

3M™ Adhesive 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.

# 3M™ Splicing Tapes

415 • 465 • 469 • 9420 • 9497 • 9499

## 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	3M™ Splicing Tape 415	3M™ Splicing Tape 465	3M™ Splicing Tape 469	3M™ Splicing Tape 9420	3M™ Splicing Tape 9497	3M™ Splicing Tape 9499
Adhesion to Steel: (ASTM D3330)	25 oz./in. (27 N/100 mm)	25 oz./in. (27 N/100 mm)	60 oz./in. (52 N/100 mm)	25 oz./in. (27 N/100 mm)	45 oz./in. (50 N/100 mm)	45 oz./in. (50 N/100 mm)
Relative High Temperature Operating Ranges:						
Long Term (days, weeks)	150°F (65°C)	180°F (82°C)	200°F (94°C)	150°F (65°C)	250°F (121°C)	300°F (149°C)
Short Term (minutes, hours)	180°F (82°C)	250°F (121°C)	350°F (180°C)	180°F (82°C)	350°F (177°C)	500°F (260°C)
Relative Solvent Resistance:	Good	Good	Medium/High	Good	Good	Good
U.V. Resistance:	Excellent	Excellent	Excellent	Excellent	Excellent	Excellent

## Available Sizes

Available Lengths (Subject to Minimum Order Requirements):	3M tape 415	3M tape 465	3M tape 469*	3M tape 9420	3M tape 9497	3M tape 9499
Standard	36 yds. (32.9 m)	60 yds. (54.9 m)	60 yds. (54.9 m)	36 yds. (32.9 m)	60 yds. (54.9 m)	60 yds. (54.9 m)
Maximum In:						
1/4" to 3/8" widths	180 yds. (165 m)	60 yds. (54.9 m)	60 yds. See note below	180 yds. (165 m)	60 yds. (54.9 m)	60 yds. (54.9 m)
3/8" to 1/2" widths	180 yds. (165 m)	60 yds. (54.9 m)	60 yds. See note below	180 yds. (165 m)	60 yds. (54.9 m)	60 yds. (54.9 m)
1/2" to 2" widths	360 yds. (329 m)	360 yds. (329 m)	60 yds. See note below	360 yds. (329 m)	360 yds. (329 m)	360 yds. (329 m)
2" and greater	360 yds. (329 m)	360 yds. (329 m)	60 yds. See note below	360 yds. (329 m)	360 yds. (329 m)	360 yds. (329 m)

\*3M tape 469 only comes in 1/2", 3/4", 1" and 1 1/2".

Available Widths (Subject to Minimum Order Requirements):	3M tape 415	3M tape 465	3M tape 469*	3M tape 9420	3M tape 9497	3M tape 9499
Minimum	1/4 in. (6.35 mm)	1/4 in. (6.35 mm)	1/2 in. (12.70 mm)	1/4 in. (6.35 mm)	1/4 in. (6.35 mm)	1/4 in. (6.35 mm)
Maximum	48 in. (1219 mm)	48 in. (1219 mm)	2 in. (50.8 mm)	48 in. (1219 mm)	48 in. (1219 mm)	48 in. (1219 mm)
Normal Slitting Tolerance:	± 1/32 in. (0.8 mm)	± 1/32 in. (0.8 mm)	± 1/32 in. (0.8 mm)	± 1/32 in. (0.8 mm)	± 1/32 in. (0.8 mm)	± 1/32 in. (0.8 mm)
Core Size (ID):	3.0 in. (76.2 mm)	3.0 in. (76.2 mm)	3.0 in. (76.2 mm)	3.0 in. (76.2 mm)	3.0 in. (76.2 mm)	3.0 in. (76.2 mm)

# 3M™ Splicing Tapes

415 • 465 • 469 • 9420 • 9497 • 9499

---

## Features

- The red color of 3M™ Splicing Tape 9420 may cause some discoloration. The user should evaluate the tape to determine whether it is fit for the user's particular purpose.
- 3M™ Splicing Tape 465 meets the requirements of U.S. Government specification MIL-P-19834B, Type I.
- 3M™ Splicing Tape 469 has high initial adhesion, high contact heat resistance and good adhesion to a variety of paper grades and thicknesses and is ideal for bonding a variety of similar or dissimilar materials.

---

## 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.

---

## Application Ideas

- 3M™ Splicing Tapes 415 and 465 can be used for high-speed flying splices and zero speed splices on most grades of paper such as newsprint, clay coated, corrugated stocks.
- 3M tape 469 is a high tack, high temperature double coated tissue tape which is light red in color for visible splices. The medium firm adhesive features good quick stick for high-speed flying splices on most grades of paper and excellent heat resistance for many high temperature drying ovens.
- 3M tape 9420 can be used for flying splices on paper and film where easy visibility for removal of spliced area is desirable.
- 3M™ Splicing Tape 9497 is designed for resistance to high temperatures and is ideal for splicing many paper medians used by corrugators.
- 3M™ Splicing Tape 9499 is ideal for printers who require especially high drying temperatures or who utilize long ovens. This specialty tape has extremely high air heat (oven) resistance and is ideal for zero speed automatic splicing.

# 3M™ Splicing Tapes

415 • 465 • 469 • 9420 • 9497 • 9499

---

**Storage** Store in original cartons at 70°F (21°C) and 50% relative humidity.

---

**Shelf Life** 24 months from date of manufacture.

---

**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 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 and Limited Remedy** 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.

---



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



**Industrial Business  
Industrial Adhesives and Tapes Division**  
3M Center, Building 21-1W-10, 900 Bush Avenue  
St. Paul, MN 55144-1000



*Recycled Paper  
40% pre-consumer  
10% post-consumer*

Printed in U.S.A.  
©3M 2003 70-0709-3850-4 (6/03)