

March, 2018

## 3M™ Adhesive Transfer Tape 9627

### Product Description

Finite Element Analysis (FEA) data is available for this product at: [3m.com/FEA](http://3m.com/FEA)

3M™ Adhesive Transfer Tapes with 3M™ Quick Bonding Adhesive 360 provides high bond strength to most surfaces, including many low surface energy plastics such as polypropylene and powder coated paints.

### Product Features

- Excellent adhesion to difficult to bond to surfaces such as HDPE, LDPE, and PP.
- Super quick stick.
- Higher adhesion from a thinner tape.
- Excellent solvent resistance.



## 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		Attribute Modifier
Adhesive Thickness	0.13 mm	5 mil	
Liner	60# Glassine		
Liner Color	Natural		Primary
Liner Thickness	0.08 mm	3.2 mil	

## Typical Performance Characteristics

Relative High Temperature Operating Ranges		Test Condition
121 °C	250 °F	Short Term (minutes, hours)
93 °C	200 °F	Long Term (days, weeks)

Property: Relative High Temperature Operating Ranges

180° Peel Adhesion		Attribute Modifier	Dwell/Cure Time	Dwell Time Units	Substrate
19 N/cm	174 oz/in	Faceside	30	sec	Polypropylene (PP)
19 N/cm	174 oz/in	Faceside	15	min	Polypropylene (PP)
20 N/cm	182 oz/in	Faceside	72	hr	Polypropylene (PP)
20 N/cm	185 oz/in	Faceside	72	hr	ABS
17 N/cm	159 oz/in	Faceside	72	hr	Stainless Steel
18 N/cm	169 oz/in	Faceside	72	hr	Polycarbonate (PC)
15 N/cm	134 oz/in	Faceside	72	hr	Polyethylene (PE)
18 N/cm	162 oz/in	Backside	30	sec	Polypropylene (PP)
18 N/cm	162 oz/in	Backside	15	min	Polypropylene (PP)
20 N/cm	179 oz/in	Backside	72	hr	Polypropylene (PP)
18 N/cm	162 oz/in	Backside	72	hr	ABS
18 N/cm	161 oz/in	Backside	72	hr	Stainless Steel
20 N/cm	179 oz/in	Backside	72	hr	Polycarbonate (PC)
13 N/cm	119 oz/in	Backside	72	hr	Polyethylene (PE)

Property: 180° Peel Adhesion  
 Method: ASTM D3330  
 Temp C: 23C  
 Temp F: 72F  
 Environmental Condition: 50%RH  
 Backing: Aluminum Foil  
 notes: 12 in/min (300 mm/min)

## Typical Performance Characteristics (continued)

**Static Shear:** >10,000 min

### Conditions

Test Condition : 1000 g @ Room Temperature

### Methods

ASTM D3654

### Additional Information

Notes: 1 in<sup>2</sup> sample size

## Environmental Resistance

**Humidity Resistance:** High humidity has minimal effect on adhesive performance.

No significant reduction in bond strength is observed after exposure for 72hrs at 150°F (65°C) and 90% relative humidity.

**UV Resistance:** When properly applied, nameplates and decorative trim parts are not adversely affected by exposure.

**Water Resistance:** Immersion in water has no appreciable effect on the bond strength. After 100 hours at room temperature, the high bond strength is maintained.

**Temperature Cycling Resistance:** High bond strength is maintained after cycling six times through:

8 hours at -4°F (-20°C)

8 hours at 150°F (65°C) /90% RH

**Chemical Resistance:** When properly applied, nameplate and decorative trim parts will hold securely after exposure to numerous chemicals including oil, mild acids, and alkalis.

## Handling/Application Information

### Application Ideas

- Foam to powder coated painted surfaces.
- Low surface energy plastic adhesion.

### Application Techniques

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application will assist the adhesive in developing intimate contact with the bonding surface.

To obtain optimum adhesion, the bonding surfaces must be clean, dry, and well unified. Typical surface cleaning solvents are methyl ethyl ketone for metals or isopropyl alcohol for plastics.\*

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.

\*When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturers precautions and directions for use. These cleaning recommendations may not be compliant with the rules of certain Air Quality Management Districts in California; consult applicable rules before use.

### Application Equipment

To apply adhesives in a wide web format, lamination equipment is required to ensure acceptable quality. To learn more about working with pressure-sensitive adhesives please refer to technical bulletin, 3M™ Lamination Techniques for Converters of Laminating Adhesives (70-0704-1430-8).

For additional dispenser information, contact your local 3M sales representative, or the toll free 3M sales assistance number at 1-800-362-3550.

### 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.

### Trademarks

3M is a trademark of 3M Company.

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## 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=9627](https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=9627)

### Family Group

	9626	9627
Relative High Temperature Operating Ranges (°C) Test Condition: Short Term (minutes, hours)	121	121
Relative High Temperature Operating Ranges (°C) Test Condition: Long Term (days, weeks)	93	93
Liner Color Attribute Modifier: Primary	Natural	Natural
Adhesive Thickness (mm)	0.05	0.13
Liner	60# Glassine	60# Glassine
Liner Thickness (mm)	0.08	0.08

### ISO Statement

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

## Information

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