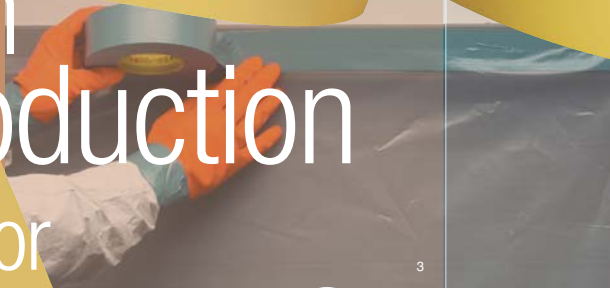


3M™ Masking, Packaging,
Surface Protection,
and Specialty Products



Design
& Production
Guide for
Application Success



Masking, protecting, enhancing,
shielding, splicing, cushioning,
case sealing



Bringing better ideas to the surface through science and service

3M Industrial Adhesives and Tapes Division helps companies worldwide apply the science of adhesion to the practicalities of improved product design and manufacturing. The end results are solutions for managers, engineers, marketers and other decision makers who need to get a more competitive product to market while improving the process of getting it there.

In this guide, 3M adhesive science is typically applied to protecting, masking, enhancing, or in other ways modifying surfaces to improve appearance, function, and productivity. You will also find ideas for splicing, manual and automatic case sealing, and temporary holding applications such as bundling pipes or hanging poly drapes. Here are just a few application ideas:

- Protect against marring and scratches

- Mask for painting or sandblasting
- Splice paper or film
- Securely seal boxes exposed to moisture and cold temperatures
- Quickly apply high strength L-clips to seal full overlap cartons
- Resist abrasion or flame
- Conduct heat or electricity
- Repel sticky materials
- Enhance glass with optical accents
- Mark to identify or differentiate
- Color-code for attention
- Cover to stop moisture
- Quiet noise

Many 3M adhesive solutions are also available for product assembly – bonding or holding product components together with strength that ranges from permanent

to repositionable. You can find assembly solutions in the *Adhesives and Tapes Design Guide for Bonding, Attaching, and Fastening*.

Solutions through service...

3M representatives are located throughout the United States, Canada, and 50 other countries for sales assistance.

For technical service, a highly trained team is ready to help you evaluate tapes for specific applications.

A national authorized distributor network provides sales assistance and local product availability. Authorized converters can also help you adapt 3M tapes to meet special requirements for shape, size, and production.

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Get connected with all 3M technologies.
Download data pages and product-specific literature.
Request samples for evaluation.

Or call with questions: **1-800-362-3550**

Selecting the right product for the job

To help you make sure you find the optimum 3M tape or other adhesive-backed product for your particular application, you'll want to consider several factors:

- Backing material
- Adhesive type
- Application time and temperature
- Surface characteristics (eg., roughness, surface energy, contours, etc.)
- End use conditions (eg., temperature, UV exposure, abrasion, etc.)

The information on these two pages integrates those factors to help you narrow your selection to fewer products for a more in-depth evaluation.

3M Backing Materials

In many applications, 3M backings add a second surface that affects how the underlying surface relates to the environment.

To optimize that relationship, 3M backings offer a wide choice of performance and handling characteristics.

Backings	Characteristics
Paper	
Crepe	Conformable, easy tear.
Flatback	Strong, smooth, good for straight line masking.
Kraft	Strong, some versions are repulpable.
Tissue	Thin, porous to allow adhesive penetration of sheet.
Plastic	
Polyester	Strong even when thin, chemical resistant, high temperature resistance.
Polypropylene	Resistant to most solvents, conformable, tear resistant.
Polyethylene	Conformable, easy to stretch, chemical/acid/moisture resistant, economical.
Polyethylene/ Polypropylene Co-polymer	Conformable, chemical/acid/moisture resistant.
UHMW – Polyethylene	High abrasion resistance, low coefficient of friction, antistick surface easy to clean.
Polyvinyl Chloride (Vinyl)	Conformable, abrasion resistant, resistant to most chemicals.
Polyimide (eg., Kapton®)	High temperature resistance, excellent dimensional stability, good insulation properties.
Polyamide (Nylon)	High temperature resistance, high strength and toughness, good chemical resistance but can absorb moisture.
Polytetrafluoroethylene (PTFE)	Low coefficient of friction, excellent high temperature and chemical resistance, antistick/release properties.
Polyvinyl Alcohol (PVA)	Water-soluble, organic solvent resistant, high temperature resistance.
Polyurethane	Abrasion/scratch resistant, impact/puncture resistant, UV and corrosion resistant.
Polyvinyl Fluoride (eg., Tedlar®)	Excellent weather resistance, excellent long-term UV resistance, thin yet stiff feel.
Cloth	
Cotton	Strong, easy tear by hand, soft and drapable.
Glass Cloth	Strong, high temperature resistance, flame-resistant.
Polyethylene Coated	Strong yet hand tearable, abrasion resistant, water-resistant, conformable.
Non-woven	
Fiber	Air permeable, strong enough to hold expanding foams.
Metals	
Aluminum	Heat and light reflective, moisture and chemical resistant, flame-resistant, outdoor weather resistant, conformable.
Lead	Electrically conductive, acid resistant, high conformability, x-ray opacity.
Rubber	
Neoprene	Abrasion resistant, die-cuttable.
Combination (Laminates)	
Paper/Polyethylene	Weather and chemical resistant, hand tearable, stretch resistant.
Metalized/Polyester	Reflective, decorative.
Glass Cloth/PTFE	High temperature resistance, high strength.
Glass Cloth/Aluminum	Very high temperature resistance, high strength.
Non-woven/Aluminum	High heat and cold resistance.

3M Pressure Sensitive Adhesives

Most of the products in this guide feature a 3M pressure sensitive

adhesive that bonds the backing to another surface on contact. Each adhesive

has different characteristics that affect production and end use performance.

Adhesives			
Rubber	Standard Acrylic	Modified Acrylic	Silicone
High initial bond	Moderate initial bond	Bonds to wider variety than standard acrylic	Fair initial bond
Softer	Firmer	Softer	Very firm
Widest variety of surfaces including low surface energy materials*	High surface energy*	Many surfaces	Fewer surfaces
Up to 350°F	Up to 450°F	Up to 300°F	Up to 600°F, excellent low temperature performance
Fair chemical resistance	Excellent chemical resistance	Good chemical resistance	Excellent chemical resistance
Fair UV resistance	Excellent UV resistance	Moderate UV resistance	Excellent UV resistance
Poor aging	Excellent aging	Durable	Excellent aging
Removable	Permanent	Various	Removable
Good solvent resistance	Excellent solvent resistance	Good solvent resistance	Excellent solvent resistance

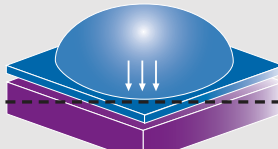
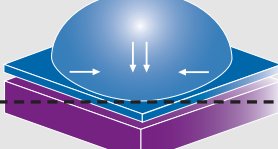
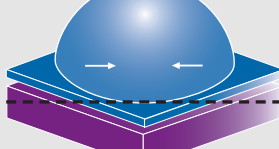
***Surface energy** ranges from high to low. To illustrate the concept of surface energy, think of water on the unwaxed hood of a car. The unwaxed hood has high surface energy and water on the hood flows into puddles. In comparison, a waxed hood has low surface energy and the water beads up rather than flows out. Similar to water, adhesive on

a high surface energy surface flows and “wets out” the surface. “Wetting out” is required to form a strong bond.

As a rule of thumb, the higher the surface energy, the greater the strength of adhesion.

Specially formulated adhesives are available for low surface energy surfaces. The following illustrations and surface rankings give you an idea of relative surface energy.

Regardless of surface energy, the substrate must be unified, dry, and clean to maximize adhesive contact.

Metal Surfaces (High Surface Energy)				High Surface Energy Plastics (HSE)				Low Surface Energy Plastics (LSE)			
											
mJ/m²	Surfaces	mJ/m²	Surfaces	mJ/m²	Surfaces	mJ/m²	Surfaces	mJ/m²	Surfaces	mJ/m²	Surfaces
1103	Copper	526	Tin	50	Kapton®	43	Polyurethane	37	PVA	31	Polyethylene
840	Aluminum	458	Lead		Industrial Film		Paint	36	Polystyrene	29	Polypropylene
753	Zinc	700-1100	Stainless Steel	47	Phenolic	42	ABS	36	Acetal	28	Polyvinyl Fluoride Film
		250-500	Glass	46	Nylon	42	Polycarbonate	33	EVA	18	PTFE
				45	Alkyd Enamel	39	PVC Rigid				Fluoropolymer
				43	Polyester	38	Noryl® Resin				
				43	Epoxy Paint	38	Acrylic				

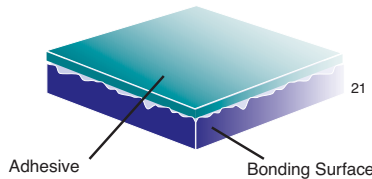
Note: These values are provided as a guide. Formulation modifications can substantially alter surface energies.

Adhesive Surface Contact

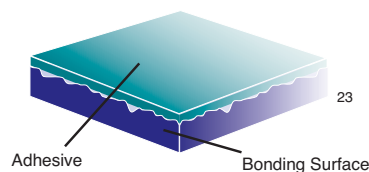
Applying firm pressure to the bond increases adhesive flow and contact for more secure bonding.

Time and temperature will typically further increase contact and adhesion values.

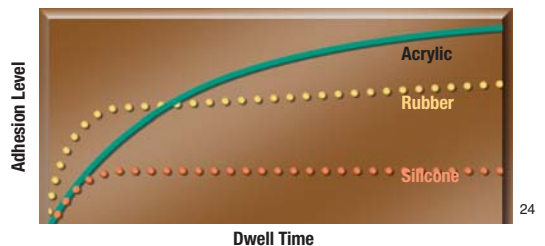
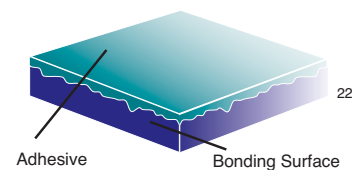
1. Initial Contact (Minimal Contact)



2. After Rubdown (More Contact)



3. After Dwell Time (Excellent Contact)



3M™ Masking Tapes – Crepe

Holding power, line sharpness, and removal the way you want

In this simplified line, you will find a range of such characteristics as adhesive holding power, line sharpness, and clean removal to meet different application requirements for virtually every industrial and consumer application. 3M products also feature...

- Instant adhesion at a touch
- Easy tear without stretching or pulling
- Controlled unwind...not too easy or too hard
- Conformability to stretch and adhere around curves



For best-in-class holding power for critical lines and clean removal, 3M™ Masking Tape 231 offers an optimum combination of characteristics for highly valued products or processes.



A quick easy wrap of 3M™ Masking Tape bundles plastic or metal pipes and other items. Select from wide range of temperature resistance to meet storage or transport conditions.



For attaching production records during assembly, warranty cards, or other temporary communications, 3M™ Masking Tapes 203, 2307, 200, and 2214 are cost-effective options.



For composite masking, 3M fine line (see page 8) overtapes 3M crepe masking tape for gelcoat color separation.

Streamlined selection

In the guide below you will quickly find solutions for most industrial applications. If not, many other 3M masking tapes are available for more specialized requirements (see the following pages).

Five questions to make 3M™ Masking Tape selection as easy as I, II, III

1. What is your application?
2. To what temperature will the tape be exposed during use?
3. Do you need maximum holding power during use?
4. Do you need maximum paint edge sharpness when the tape is removed?
5. Do you want to remove the tape without slivering and adhesive residue?



Increasing Holding Power, Line Sharpness, and Clean Removal

Tapes with best-in-class holding power for critical paint lines and clean removal on high valued products or processes.

Product number	Temperature Resistance
2693	up to 325°F (163°C)
231	up to 300°F (149°C)
232	up to 250°F (121°C)

Tapes with reliable masking and clean removal on surfaces for functional coatings or paints; splicing; heavy duty maintenance.

Product number	Temperature Resistance
2380	up to 325°F (163°C)
2364	up to 300°F (149°C)
234	up to 250°F (121°C)

Tapes with clean removal for light duty bundling, attaching, and labeling.

Product number	Temperature Resistance
2307	up to 200°F (93°C)
200	up to 200°F (93°C)
2214	up to 150°F (66°C)

Increasing Temperature Performance*

*30-min. bake

Product Information:

Product	Tape Structure (Backing/Adhesive)	Color	Total Thickness mils (mm)	Adhesion oz./in. (N/100 mm)	Tensile Strength lbs./in. width (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)	Comments
Low Temperature (Holding, Bundling and Sealing)								
200	Crepe Paper/Rubber	Tan	4.4 (0.11)	25 (27)	19 (333)	8	Up to 200°F (93°C)*	Good instant adhesion.
203 ¹	Crepe Paper/Rubber	Tan	4.7 (0.12)	28 (31)	22 (385)	8	Up to 200°F (93°C)**	Good price/value relationship.
2209	Crepe Paper/Rubber	Tan	5.1 (0.13)	22 (24)	23 (403)	10	Up to 150°F (66°C)*	Most economical light duty holding and sealing.
2214	Crepe Paper/Rubber	Tan	5.2 (0.13)	22 (24)	22 (385)	9	Up to 150°F (66°C)*	Good for holding and bundling.
2307 ¹	Crepe Paper/Rubber	Tan	5.2 (0.13)	28 (31)	23 (403)	8	Up to 200°F (93°C)*	Solvent-free construction; non-critical paint masking.
¹ Meets ASTM D6123/D6123M-97 *Up to 30 minutes **Up to 60 minutes								
Medium Temperature (Paint Masking)								
202 ¹	Crepe Paper/Rubber	Tan	6.3 (0.16)	41 (44)	27 (472)	8	Up to 250°F (121°C)*	Good holding power.
232 ¹	Crepe Paper/Rubber	Tan	6.3 (0.16)	41 (44)	27 (472)	8	Up to 250°F (121°C)*	Good paint lines.
234 ¹	Crepe Paper/Rubber	Tan	6.0 (0.15)	34 (37)	27 (472)	8	Up to 250°F (121°C)*	Excellent control unwind.
2308 ¹	Crepe Paper/Rubber	Tan	5.3 (0.13)	35 (38)	22 (385)	10	Up to 250°F (121°C)*	Good transfer resistance.
¹ Meets ASTM D6123/D6123M-97 *Up to 30 minutes								
High Temperature (Paint Masking)								
213 ¹	Crepe Paper/Rubber	Tan	6.5 (0.16)	41 (45)	30 (525)	9	Up to 350°F (177°C)*	Good on anodized aluminum.
214 ¹	Crepe Paper/Rubber	Tan	6.7 (0.17)	27 (29)	24 (420)	10	Up to 350°F (177°C)*	Stain resistant.
231/231A ¹	Crepe Paper/Rubber	Tan	7.6 (0.19)	38 (41)	28 (490)	10	Up to 300°F (149°C)*	Best all-purpose paint masking tape.
2364 ¹	Crepe Paper/Natural Synthetic/Rubber Blend	Tan	6.5 (0.165)	36 (39)	30 (525)	10	Up to 300°F (149°C)*	Cost effective, high temp performance.
2380 ¹	Crepe Paper/Natural Synthetic/Rubber Blend	Tan	7.5 (0.19)	43 (47)	27 (472)	10	Up to 325°F (163°C)*	High temperature. Best holding to widest variety of surfaces.
2393 ¹	Mini-Crepe Paper/Rubber	Tan	7.6 (0.185)	32 (36)	28 (490)	11	Up to 325°F (163°C)*	Low holding; use where clean removal is a problem.
2693 ¹	Mini-Crepe Paper/Synthetic	Tan	8.5 (0.21)	46 (50)	26 (455)	10	Up to 325°F (163°C)*	Very aggressive holding; excellent for multi-bake paint cycles.

¹Meets ASTM D6123/D6123M-97 *Up to 30 minutes

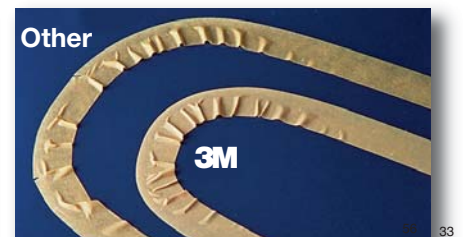
Note: This technical information and data should be considered representative or typical only and should not be used for specification purposes.



Some masking tapes leave a ragged paint edge that may require rework. 3M™ Masking Tapes feature a thin, smooth backing for a sharp paint line.



With sliver-resistant crepe backing, 3M™ Masking Tapes peel off neatly without breaking into pieces. Saves time and work for removal.



With an engineered balance of crepe and adhesive, 3M™ Masking Tapes conform to compound surfaces and around curves without tearing the backing.

3M™ Masking Tapes – Fine Line, Flatback, and Specialty

Holding power, line sharpness, and removal the way you want

With a core capability of coating technology, 3M combines paper or film backings with different adhesives for demanding applications.

3M™ Fine Line Tapes

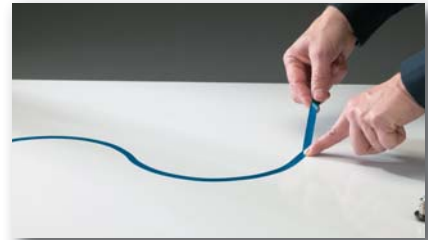
- Sharpest possible paint lines
- Conformability to stretch and adhere around sharp curves
- Film or vinyl backings flex easily for creating curved paint edges
- Resist edge lifting

3M™ Flatback Tapes

- High strength paper backing for surface protection when applying thick-coat paint or caulk
- Versatile for many holding, edging, binding, and splicing applications requiring easy visibility



A combination of 3M™ Fine Line Masking Tape and 3M™ Crepe Masking Tape readies a motorcycle gas tank for custom painting that creates a sharp, high impact graphic image.



With blue vinyl backing and rubber adhesive, 3M™ Fine Line Masking Tape 4737S offers best-in-class conformability and line sharpness for curves in high value processes.



For splicing paper or fabric, 3M™ Flatback Tapes provide high machine direction tensile strength and easy cross tear. Rubber adhesive holds securely on materials ranging from kraft paper to nonwoven fabric.



With a specialty processed film backing, 3M™ Fine Line Masking Tape 218 tapes over fresh paint sooner than crepe tapes with less chance of imprint damage.

Streamlined selection

In the guide below you will quickly find fine line and flatback solutions for most industrial applications. If not, other 3M masking tapes are available for more specialized requirements. See the next page.



	Fine line tapes for sharpest possible paint lines	Flatback paper tapes with high strength backing for surface protection	
	Best-in-class for conformability on sharper curves in high value processes <i>Product number</i> 4737T up to 325°F (163°C) 4737S up to 325°F (163°C) 4735 up to 300°F (149°C)	Best-in-class holding power and backing strength for thick-coat paint or caulk <i>Product number</i> 2525 up to 300°F (149°C)	
		Holding power and backing strength for thick-coat paint or caulk <i>Product number</i> 2517 up to 300°F (149°C)	
		General purpose splicing, holding and bundling <i>Product number</i> 2515 up to 200°F (93°C)	
Increasing conformability and clean removal	Increasing temp performance*	Increasing holding power and backing strength	Increasing temp performance*

*30 min. bake

Product Information:

Product	Tape Structure (Backing/Adhesive)	Color	Total Thickness mils (mm)	Adhesion oz./in. (N/100 mm)	Tensile Strength lbs./in. width (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)	Comments
Fine Line Masking Tapes								
215	Plastic Film/Rubber	Blue	4.7 (0.12)	42 (46)	10 (175)	830	Up to 250°F (121°C) Up to 30 min.	Medium temperature. Excellent conformability.
218	Matte Finish, Polypropylene Film/Rubber	Green	5.0 (0.13)	37 (40)	13 (228)	720	Up to 250°F (121°C) Up to 30 min.	Medium temperature. conformability yet good for straight.
222	Polyester Film/Acrylic	White	2.4 (0.06)	24 (26)	26 (455)	127	Up to 325°F (163°C) Up to 1 hour	High temperature. Thin low profile lines.
265	Matte Finish, Polypropylene	Green	5.1 (0.13)	21 (23)	21 (368)	881	Up to 200°F (121°C) Up to 30 min.	In-mold composite masking where sharp, clean, gel-coat color separation lines are desired.
4735	Vinyl Film/Rubber	Orange	5.5 (0.14)	15 (16)	15 (260)	130	Up to 300°F (149°C) Up to 30 min.	High temperature. More comfortable than 4737.
4737S	Vinyl Film/Rubber	Blue (opaque)	5.1 (0.13)	14 (15)	14 (245)	150	Up to 325°F (163°C) Up to 1 hour	High temperature.
4737T	Vinyl Film/Rubber	Blue (translucent)	5.1 (0.13)	14 (15)	16 (280)	150	Up to 325°F (163°C) Up to 30 min.	High temperature. Good conformability.
Flatback Tapes								
250	Flat Stock Paper/Rubber	Tan	5.9 (0.15)	70 (77)	58 (1016)	4	Up to 200°F (93°C) Up to 30 min.	Meets ASTM D6123M-97* Used in paint adhesion testing.
256	Flat Stock Paper/Rubber	Red/White/Green	6.7 (0.17)	25 (27)	20 (350)	5	Up to 200°F (93°C) Up to 30 min.	Printable, accepts marking inks.
2515	Flat Stock Paper/Rubber	Tan	6.7 (0.17)	55 (60)	36 (630)	3	Up to 200°F (93°C) Up to 30 min.	General purpose splicing, holding and bundling applications.
2517	Flat Stock Paper/Rubber	Tan	6.4 (0.16)	78(85)	35 (543)	2	Up to 300°F (149°C) Up to 30 min.	Excellent splicing, holding and bundling applications.
2525	Flat Stock Paper/Rubber	Orange	9.5 (0.241)	69 (75)	49 (858)	2	Up to 300°F (149°C) Up to 30 min.	Premium splicing, bright color.
2526	Flat Stock Paper/Rubber	White	9.8 (0.242)	69 (75)	50 (858)	4	Up to 300°F (149°C) Up to 30 min.	Excellent adhesion and strength for textile applications.
Specialty Masking Tapes								
225	Crepe Paper/Rubber		5.8 (0.15)	33 (36)	21 (368)	9	Up to 200°F (93°C) Up to 30 min.	Outdoor
226	Polyethylene Saturated Crepe Paper/Rubber	Tan	10 (0.25)	40 (43)	30 (526)	8	Up to 250°F (121°C) Up to 30 min.	Outdoor
2510	Black Crepe Paper/Rubber	Tan	5.6 (0.14)	35 (37)	20 (350)	9	Up to 200°F (93°C) Up to 1 hour	Indoor
2497ST	Polyester/Rubber	Transparent	3.3 (0.09)	17 (18)	52 (910)	112	Up to 300°F (149°C) Up to 30 min.	High temperature. Tear-resistant backing.
5903	Polyethylene/Synthetic rubber	Red	7.0 (0.18)	81 (89)	23 (403)	72	Up to 200°F (93°C)	UV and weather resistant for outdoor masking, holding, patching, bundling, marking and more. 30-day clean removal.

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

3M™ Masking Tapes – Large Area Masking Systems

Gross masking for large area protection against overspray and incidental direct spray

For large area coverage, 3M provides a choice of tape types and sizes and gross masking materials. Combine your choice of components into a reliable, cost-effective system for applications in aerospace, automotive, farm implement, buses, marine, and more.

3M™ Masking Tapes

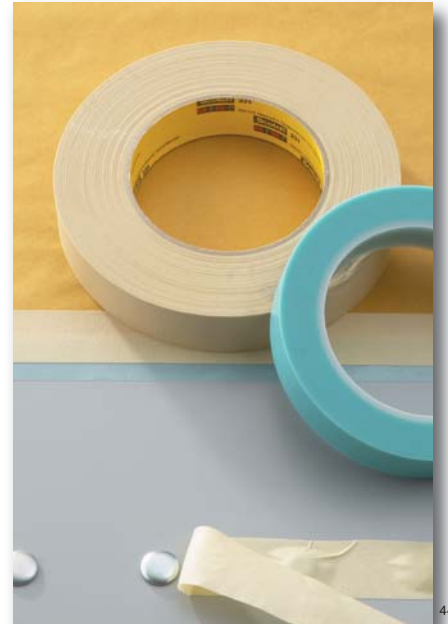
- Crepe tapes ranging in widths from 1/2" to 3" to hold gross masking in place
- Fine line vinyl or film tapes in widths from 1/4" to 4" for a sharp paint line at the edge of gross masking

3M™ Gross Masking Materials

- Paper or film sheets for applications less than 36" wide
- Film sheeting for applications up to 240" wide
- Film bags up to 96" wide



With the robust paint system and process for farm implements, 3M™ Large Area Masking Paper 6700 offers best-in-class protection for no bleed through and paint flaking.



3M™ Fine Line Masking Tape 4737T applied over the edge of 3M™ Crepe Masking Tape 231, provides a sharp line for painting a truck panel. The crepe tape holds gross masking product in place.



A paint masking system for the plastic fairing of a motorcycle, combines 3M™ Large Area Masking Paper with 3M™ Crepe Masking Tape 231 and 3M™ Fine Line Masking Tape 218.

Streamlined selection

In the guide below, you will quickly find large area masking solutions for most industrial applications. If not, other 3M large area products are available for more specialized requirements. See the next page.

	Paper less than 36" wide	Film less than 36" wide	Film sheeting 60-200" wide	Film bags 60-96" wide
CLASS I MASKING CLASS II MASKING CLASS III MASKING	Best-in-class for no bleed through and flaking with any paint			
	Product number 6700 up to 210°F (99°C)	Product number 7300 up to 310°F (154°C)	Product number 7260M up to 315°F (157°C)	Product number 7260M up to 315°F (157°C)
	Economic protection against low viscosity, low solids paint			
		Product number 7000 up to 310°F (154°C)	Product number 6727 up to 225°F (107°C) 6728 up to 225°F (107°C) 6742 up to 225°F (107°C)	Product number 6730 up to 225°F (107°C)
Economic protection against high viscosity, high solids paint				
	Product number 6537 up to 400°F (204°C)			
	Increasing temp performance*	Temperature*	Increasing temp performance*	Increasing temp performance*

*30 min. bake

Product Information:

Product/ Color	Paper/Film Structure	Basic Weight lbs.	Total Thickness mils (mm)	Machine Direction Tensile Strength lbs./in. width (N/100 mm)	Cross Direction Tensile Strength lbs./in. width (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)
Large Area Masking Paper							
White							
6537 6539 6538 6540	Treated Paper	24	2.2 (0.056)	18 (315)	20 (350)	NA	400°F (204°C)
Gray							
6503 6518 6506 6524 6509 6536 6512	Steel Gray Colored Paper	30	2.6 (0.066)	27 (473)	28 (490)	NA	400°F (204°C)
Gold							
6706 6732 6712 6736 6718 6738	Specially Coated Paper	27	2.0 (0.05)	17 (298)	22 (385)	NA	225°F (107°C) Up to 30 min.
Product/ Color	Paper/Film Structure	Gauge mils (mm)	Emboss Gauge mils (mm)	Machine Direction Tensile Strength lbs./in. width (N/100 mm)	Cross Direction Tensile Strength lbs./in. width (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)
Large Area Masking Film and Bags							
6700 Paint Repair Bags	Low Density Polyethylene	1.0 (0.025)	—	3.0 (52)	3.0 (52)	400	Up to 210°F (100°C)
6727 Film	High Density Polyethylene	0.34 (0.009)	0.34 (0.009)	2.5 (44)	1.8 (32)	300	Up to 225°F (107°C)
6728 Film	High Density Polyethylene	0.34 (0.009)	0.34 (0.009)	2.5 (44)	1.8 (32)	300	Up to 225°F (107°C)
6730 Paint Repair Bags	High Density Polyethylene	0.7 (0.018)	—	6.2 (108)	4.3 (75)	400	Up to 225°F (107°C)
6742 Film	High Density Polyethylene	0.34 (0.009)	0.34 (0.009)	2.5 (44)	1.8 (32)	300	Up to 225°F (107°C)
7000 Film/Tan	Textured Polypropylene	2.7 (0.07)	4.2 (0.11)	11 (190)	10.0 (175)	600	Up to 310°F (155°C)
7260M OEM Paint Repair Bag and Film Sheeting	Soft Polypropylene	1.6 (0.048)	1.8 (0.046)	7.5 (131)	5.0 (88)	700	Up to 315°F (157°C)
7300 Film	Textured Soft Polypropylene	2.0 (0.05)	2.9 (0.07)	8.8 (154)	4.7 (82)	600	Up to 310°F (155°C)

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

3M™ Dispensers For Large Area Masking



Scotch® Cart Masker 06781

Dispenses one apron of any length up to 18 in. wide on each of two levels.



3M™ Overspray Protective Sheet Masker 06780

Portable masker designed to dispense 3M™ Overspray Protective Sheeting and 3M™ Paintable Plastic Sheeting. Allows for easy hand cutting of plastic sheeting.



Scotch® Slimline Apron Taper 06864

Dispenses three widths of masking paper up to 18 in. wide. Side hooks hold different tape widths for special needs.



Scotch® Apron Taper 18" 06865
Dispenses single aprons up to 18 in. wide.



Scotch® Apron Taper 36" 06866
Dispenses single aprons up to 36 in. wide.

3M Tape Dispenser replacement parts:

Dispenser Parts
241 Venture Drive
Amery, WI 54001
Phone: 1-800-344-9883
Fax: 715-268-8153

Replacement blades:

Atscott Manufacturing Company, Inc.
1150 Holstein Drive N.E.
Pine City, MN 55063
Phone: 320-629-2501, ext. 116
www.atscott.com

3M™ Masking – Specialized applications

Special performance attribute		2209	2214	200	203	2510	2090	2307	2060	235	2308	225	226*	232	234	231	2364	2380	2693	2393	214	213	
Color	Tan	R	R	R	R			R			R			R	R	R	R	R	R	R	R	R	R
	Black					R				R			R										
	Green								R														
	Silver											R											
	Blue						R																
Hold to and clean removal from specialty surfaces	Stainless steel	R	R	R	R	R	R	R	R	R	R	R	R	R	R	R	R	R	R	R	R	R	R
	Anodized aluminum																		R	R			R
	Alodine aluminum													R	R				R				
	Phosphate primer															R	R	R			R		
	Chemlease primer																				R		
	Zinc primer															R	R	R			R		
	Nickel plating																				R		
	Brass																						R
	Copper																						R
	Silver/silver plate																						R
	Polycarbonate plastic						R																
	EPDM rubber						R				R				R	R						R	R
	Most powder coated paints	R	R	R	R	R			R	R	R	R	R	R	R	R	R	R	R	R	R	R	R
Holding strength to common surfaces i.e. steel, paints	Low	R	R				R														R	R	
	Medium			R	R	R		R	R	R	R	R				R	R					R	
	High												R	R	R				R	R			
Paint line	Good	R	R	R	R	R																R	
	Better						R	R	R	R	R	R			R		R					R	
	Best												R	R		R		R	R	R			
Sunlight/outdoor exposure	Up to 7 days on glass						R																
	Up to 3 days opaque surface								R		R				R	R							
	Up to 30 days opaque surface											R											
	Up to 90 days opaque surface												R										
Increasing temperature performance (30 min. bake)	up to 150°F (66°C)																						
	up to 200°F (93°C)																						
	up to 250°F (121°C)																						
	up to 300°F (149°C)																						
	up to 325°F (163°C)																						
	up to 350°F (177°C)																						

“R” is recommended

*Laminate of crepe paper/polyethylene

*NOTE: The technical information and data provided above is a general guide only and should be considered representative or typical only and should not be used for specification purposes.



Environmental Highlights of 3M™ Masking Tapes

Product Name	Environmental Claim/Attribute
3M™ Paper Masking Tape 200	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
3M™ General Purpose Masking Tape 203	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® Paint Masking Tape 231/231A	Greater than 95% of the organic solvents used in manufacturing this product are recovered and used again. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
3M™ Masking Tape 2307	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® Masking Tape 2308	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® General Purpose Masking Tape 234	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.

Product Name	Environmental Claim/Attribute
Scotch® Performance Masking Tape 232	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® Premium High Performance Masking Tape 2393	Greater than 95% of the organic solvents used in manufacturing this product are recovered and used again. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® Performance Masking Tape 2380	Greater than 95% of the organic solvents used in manufacturing this product are recovered and used again. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® Performance Masking Tape 2364	Greater than 95% of the organic solvents used in manufacturing this product are recovered and used again. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® High Performance Masking Tape 2693	Greater than 95% of the organic solvents used in manufacturing this product are recovered and used again. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.

