



# 855 High Temperature Nylon Tape

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## Product Data Sheet

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Updated : March 1996  
Supersedes : October 1993

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### Product Description

A cream coloured nylon film coated with a unique high temperature rubber adhesive which contains no silicone. The thinness and high temperature performance provide a masking tape capable of

high quality stop-off lines in high temperature applications. The conformability and strength of nylon combine to enable the tape to break cured adhesive flashes.

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### Physical Properties

Not for specification purposes

<b>Adhesive Type</b>	Cured Blended Adhesive (non-silicone)	
<b>Backing</b>	Nylon	
<b>Thickness</b> (ASTM D-3652)	76 µm	
<b>Tape Colour</b>	Translucent cream	
<b>Shelf Life</b>	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

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### Performance Characteristics

Not for specification purposes

<b>Adhesion to Stainless Steel</b> ASTM D-3330	3.2 N/10mm	
<b>Tensile Strength</b> ASTM D-3759	44.0 N/10mm	
<b>Elongation at Break</b> ASTM D-3759	400 %	
<b>Temperature Range</b> Maximum	200 °C	

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**Additional Product Information**

High temperature performance is achieved without the use of silicone adhesive. This eliminates the problem of silicone residue which normally interferes with cleaning operations and anchorage of adhesives and paints.

This tape is designed to provide clean removal during masking operations in applications involving high temperature and pressure.

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Tape

<b>Application Techniques</b>	Best results are attained when applied to a clean, dry and non dusty surface above 0°C.	To improve adhesion ensure firm and even application pressure is applied.
<b>Applications</b>	<u>Advanced composite and metal bond masking</u> - non-silicone adhesive allows use on parts where subsequent painting or bonding is necessary. Removes cleanly after 205°C autoclave exposure.	High temperature - clean removal from bake cycles. Clean removal from metal has been experienced after 24 hours at 175°C. In shorter cycles the tape can be expected to provide satisfactory performance in 200°C bake cycles. The high stretch and thinness offer excellent conformability and clean sharp edges.

#### FEATURES

Thin nylon backing.

Cured adhesive.

Firm adhesive.

Non-silicone adhesive.

#### ADVANTAGES

1. Toughness.
2. High elongation.
3. Very conformable.
4. High temperature performance.
5. Low shrinkage.

High temperature performance.

No edge bleed.

Eliminates possible silicone contamination of forms, moulds and parts.

#### BENEFITS

Quick removal.  
Ease of application.

Reduced clean-up saves time.

Clean removal.

Reduced clean-up saves time.

Facilitates superior bond strength.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



#### Specialty Tapes & Adhesives

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