



365 Thermosetting Glass Cloth Tape

Product Data Sheet

Updated : March 1996
Supersedes : October 1993

Product Description White woven glass cloth has high tensile strength and good ageing properties. The addition of a rubber resin adhesive gives excellent adhesion performance over a wide temperature range.

Physical Properties
Not for specification purposes

Adhesive Type	Rubber resin thermosetting.	
Backing	Glass cloth	
Thickness (ASTM D-3652)	165 µm	
Tape Colour	White	
Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

Performance Characteristics
Not for specification purposes

Adhesion to Stainless Steel ASTM D-3330	3.8 N/10mm	
Tensile Strength ASTM D-3759	262.5 N/10mm	
Elongation at Break ASTM D-3759	6.0 %	
Temperature Range Maximum	150 °C	

Additional Product Information

Thermosetting adhesive provides high tack and initial adhesion. After cure, adhesive bond will be increased up to twice the initial adhesion.

Curing rate depends upon temperature. Normal curing cycle is three hours at 120°C, two hours at 135°C, or one hour at 150°C. Doubling the time of cure at 120°C or 150°C further increases the already excellent solvent resistance of the tape.

Under normal operating conditions, No. 365 will withstand 120°C continuously, 150°C for several weeks, and 205°C for several hours. Above 120°C the tape discolours slightly and the adhesive bond will not withstand continuous physical stress.

Date : March 1996
365 Thermosetting Glass
Cloth Tape

Application Techniques	<p>1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact & thus improves bond strength.</p> <p>2. To obtain optimum adhesion, the bonding</p>	<p>surfaces must be clean dry and well unified. A typical surface cleaning solvent is isopropyl alcohol & water. Use proper safety precautions for handling solvents.</p> <p>3. Ideal tape application temperature range is 21°C to 38°C (70°F to 100°F).</p>	<p>Initial tape application to surfaces at temperatures below 10°C (50°F) is not recommended because the adhesive becomes too firm to adhere readily. However once properly applied low temperature holding is generally satisfactory.</p>
Applications	<p>Splicing or insulating applications requiring high tensile strength and resistance to elevated temperatures.</p>	<p>As a corrosion resistant wrap on stainless steel hot air ducts.</p>	<p>Splicing materials with rough surfaces or poor internal strength such as roofing felt.</p>
Specifications	MIL-T-4053B		

Features	Advantages	Benefits
Glass cloth backing.	Excellent heat and solvent resistance.	High productivity.
Rubber resin (thermosetting).	Firm at high temperature. Good solvent resistance.	High productivity.

3M is a trademark of the 3M Company.

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

© 3M United Kingdom PLC 1996

3M United Kingdom PLC
3M House,
28 Great Jackson Street,
Manchester,
M15 4PA

Customer Service :
Tel 0161 236 8500
Fax 0161 237 1105

3M Ireland
3M House, Adelphi Centre,
Upper Georges Street,
Dun Laoghaire, Co. Dublin,
Ireland

Customer Service :
Tel (01) 280 3555
Fax (01) 280 3509