Electroplating Tape

470 • 470L

Technical Data **February, 2011**

Product Description

3M™ Electroplating Tape 470 is a conformable and abrasion-resistant vinyl tape with excellent resistance to most chemicals used in typical electroplating processes. 3M™ Electroplating Tape 470L is a linered version of 3M vinyl tape 470 that may be used for die-cutting or large area applications.

Product Construction

Backing	Adhesive	Liner	Color	Standard Roll Length
Pigmented vinyl	Rubber	Tape 470 - none Tape 470L - white paper	Tan	36 yds. (33 m)

Typical Physical Properties

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

		ASTM Test Method
Adhesion to Steel:	37 oz./in. width (40.4 N/100 mm)	D-3330
Tensile Strength at Break:	20 lbs./in. width (350 N/100 mm)	D-3759
Elongation at Break:	180%	D-3759
Backing Thickness:	6.3 mils (0.16 mm)	D-3652
Total Tape Thickness (without liner):	7.1 mils (0.18 mm)	D-3652
Liner Thickness:	6.1 mils (0.15 mm)	D-3652
Temperature Use Range:	Up to 250°F (121°C)	

Features

- Excellent resistance to most chemicals used in typical electroplating operations.
- Prolonged exposure to elevated temperatures (above 250°F/121°C) and hot caustics may cause weakening of the adhesive bond.
- Can be qualified to meet Federal Specification HH-T-0025 (GSA-FSS) Ammendment 2.
- Resists most common solvents, care should be taken to avoid ketones, chlorinated hydrocarbons, and esters, found in lacquer thinners, degreasers, paint strippers, etc., which may cause the backing to swell or curl.
- Vinyl backing is conformable
- Backing accepts marker ink and is printable in using the thermal transfer process.

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Application Ideas

- Masking during many electroplating operations, including both flat strip and overlapping masks.
- Wrapping, patching, coated racks and masking many irregular surfaces.
- Labeling.
- Sealing containers from water intrusion.

Storage

Store under normal conditions of 60° to 80°F (16° to 27°C) and 40 to 60% R.H. in the original carton.

Shelf Life

To obtain best performance, use this product within 18 months from date of manufacture.

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use

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ISO 9001:2008

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2008 standards.

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