English-US

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Technical Data Sheet

3M™ Anodization Masking Tape 8985L

Product Details

Product Description

3M™ Anodization Masking Tape 8985L is a purple printed polyester tape with a rubber adhesive and non-silicone release liner. Designed specifically for masking parts against chromic anodization bath processes.

Product Features

•Strong backing provides excellent abrasion, tear, scratch, puncture and moisture resistance to help protect surfaces.
•The purple translucent backing allows for visual inspection without tape removal.
•Provides good initial tack and holding strength.
•Rubber adhesive specially formulated to resist the harshest of chemical bath chemistries and provide clean removal when finished.
•Non-silicone adhesive allows use on many parts where subsequent painting or bonding is necessary.
•Non-silicone liner allows for die-cuts.

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

Attribute Name	Test Method	Value
Color		Purple Printed
Adhesive Type		Rubber
Backing		Polyester
Backing Thickness	ASTM D3652	0.076 mm (3 mil)
Total Tape Thickness	ASTM D3652	0.099 mm (3.9 mil)
Liner		Polyester
Liner Thickness		0.051 mm (2 mil)

Typical Performance Characteristics

Attribute Name	Test Method	Temperature	Value
180° Peel Adhesion	ASTM D3330	23 °C (73 °F)	2.5 N/cm (23 oz/in) [1]
Elongation at Break	ASTM D3759		131 %
Tensile Strength	ASTM D3759		1234 N/100mm (70 lb/in)
Long Term Temperature Resistance			93 °C (200 °F) [2]

[1] 304 mm/min (12 in/min)

[2] Long Term (day, weeks)

Handling/Application Information

Application Examples

• Masking during anodization operations.

Application Techniques

Surface Preparation
•Clean surfaces prior to masking, such as alkaline clean and deoxidize.
•Improve masking success by chemfilm surface prior to masking.
Masking
•Optimal adhesion is obtained when both the tape and intended surface are within a temperature range of 60° to 80°F (16° to 27°C).
•To apply the tape, remove a portion of the liner from one end of the tape and firmly tack it down to the surface. Gently pull liner away from tape at an angle as it is being applied by hand.
•Once the tape has been applied, firmly apply pressure to improve bond strength to surface. Additional tools (wipers, rollers, etc.) may be needed to achieve proper bond.
•Squeegee out any air bubbles that may be trapped between the tape and the surface. Special attention to masking edges for better sealing from chemicals.
Removal Techniques
•Allow masking tape to dwell greater than four hours after part processing before removal.

Plotter Suggestions
•Plotter Test Plot: Imperative to test and verify that the blade cuts all the way through the tape
•Plotter Pressure: Validate pressures are set to cut through the tape (backing and adhesive) to the liner. Pressure settings may need to be increased depending on the thickness of the product and what material was run on the plotters previously.
•Blade Angle: 45 or 60 degree angle preferred
•Blade Adjustment: If the blade is too far into the housing it isn't exposing enough blade to cut through down to the liner. Adjust the blade to expose more in order to cut through the material.
•Fresh Blade: Blades need to be routinely changed in order to remain sharp to cut through the material correctly.
•Plotter Maintenance: Routine maintenance should be performed on plotters when inconsistent cuts are observed. (cutter protection strip, blade holder, etc)

Storage and Shelf Life

Store under normal conditions of 16° to 27°C (60° to 80°F) and 40 to 60% relative humidity in the original packaging, out of direct sunlight. For best performance, use this product within 12 months from date of manufacture.

Available Sizes

Attribute Name	Value
Standard Roll Length	65.8 m (72 yd)

Information

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ISO Statement

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