Electroplating Tape
470 • 470L

Technical Data

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 lined version of 3M vinyl tape 470 that may be used for die-cutting or large area applications.

Product Construction

<table>
<thead>
<tr>
<th>Backing</th>
<th>Adhesive</th>
<th>Liner</th>
<th>Color</th>
<th>Standard Roll Length</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pigmented vinyl</td>
<td>Rubber</td>
<td>Tape 470 - none</td>
<td>Tan</td>
<td>36 yds. (33 m)</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Tape 470L - white paper</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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.

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

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.

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