

3M™ Masking Tapes

Key Customer Markets:

- Auto Assembly
- Aerospace
- Truck and Bus
- Recreational Vehicles
- Marine
- Parts Manufacturers
- Printing Manufacturers
- Paper Manufacturers
- Electronics

3M offers a complete family of crepe masking tapes for the industrial and consumer markets. All of our crepe masking tapes are manufactured with the highest professional standards.

Key product features and benefits:

Instant Adhesion—Tapes sticks at a touch.

Holding Power—Tape sticks to the job when and where you want it to, even under stress.

Easy Tear—Tape tears easily from the roll without stretching or pulling.

Controlled Unwind—Tape comes off the roll in a controlled fashion...not too easy; not too hard.

Conformability—Tape easily makes sharp curves.

Thinness—Tape does not leave thick edge build-up.

Smoothness—Tape is smooth to a touch and does not irritate hands when you press it down.

Transfer Resistance—Tape can be removed without leaving adhesive.

Solvent Resistance—Tape backing resists solvent penetration.

Sliver Resistance—Tape does not come off in pieces.

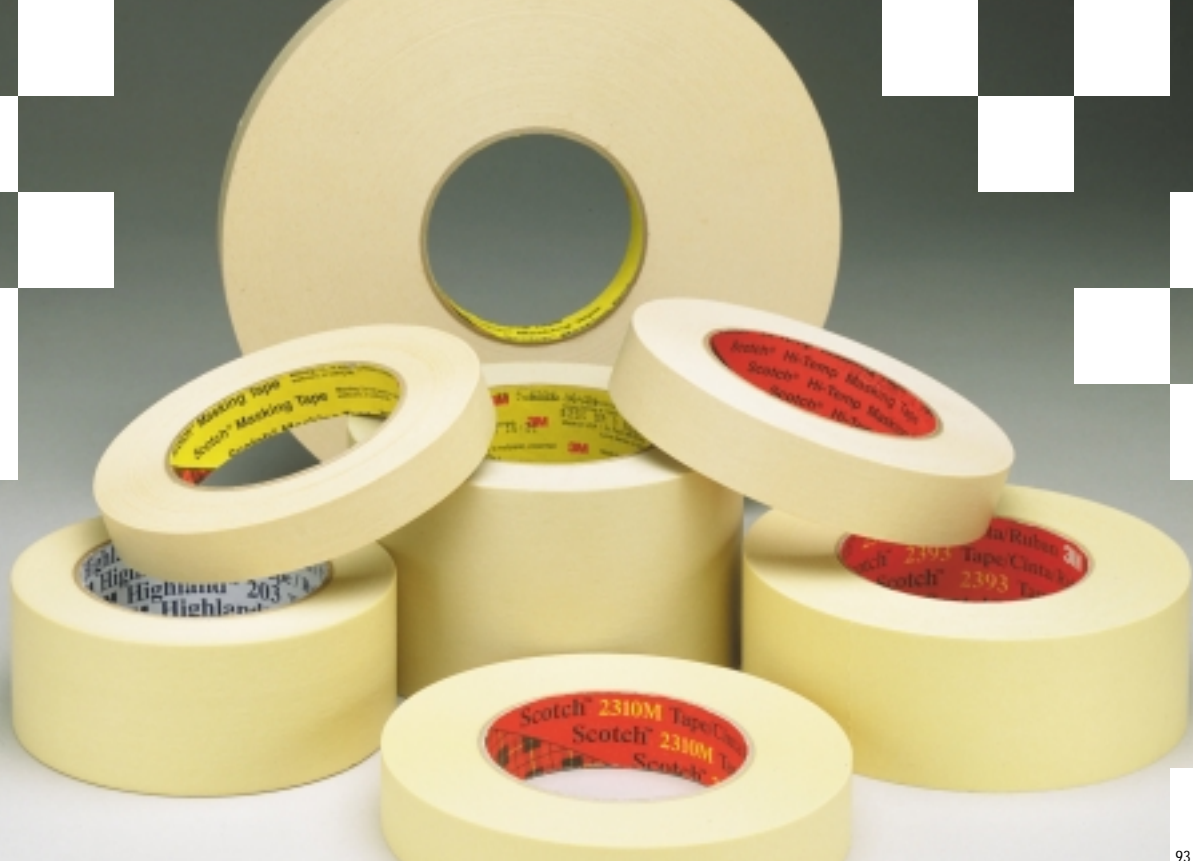
Dead Stretch—Tape can be stretched around a curved surface without pulling away.

Flake Resistance—Paint anchors to the tapes backing.

PRODUCT INFORMATION

| Product | Tape Structure (Backing/Adhesive) | Total Tape Thickness | Tensile Strength lbs./in. (N/100mm) | Adhesion oz./in. width (N/100mm) | % of Elongation at Break | Temperature Range (F/C) | Government Specification |
|---------------------------|------------------------------------|----------------------|-------------------------------------|----------------------------------|--------------------------|---|--|
| LOW TEMPERATURE | | | | | | | |
| 200 | Natural Colored Crepe Paper/Rubber | 4.5 mils 0.11mm | 20 lbs./in. width 350 N/100mm | 32 oz. in. width 35 N/100mm | 8% | Up to 200°F (93°C) | — |
| 2214 | Natural Colored Crepe Paper/Rubber | 5.3 mils 0.13mm | 20 lbs./in. width 350 N/100mm | 24 oz. in. width 26 N/100mm | 10% | Up to 150°F (66°C) | — |
| 2307 | Natural Colored Crepe Paper/Rubber | 5.6 mils 0.14mm | 20 lbs./in. width 350 N/100mm | 32 oz. in. width 34 N/100mm | 9% | Up to 200°F (93°C) | PPP-T-42C, Type I CID A-A883A, Type I |
| MEDIUM TEMPERATURE | | | | | | | |
| 202 | Natural Colored Crepe Paper/Rubber | 5.8 mils 0.15mm | 24 lbs./in. width 420 N/100mm | 38 oz. in. width 42 N/100mm | 8% | Up to 200°F (93°C) | PPP-T-42C, Type I |
| 231 | Natural Colored Crepe Paper/Rubber | 6.1 mils 0.15mm | 26 lbs./in. width 455 N/100mm | 36 oz. in. width 39 N/100mm | 10% | Up to 250°F (121°C) Up to 1 hour | MIL-T-21595D, Type I PPP-T-42C, Type I CID A-A883A, Type I |
| 232 | Natural Colored Crepe Paper/Rubber | 5.7 mils 0.14mm | 23 lbs./in. width 403 N/100mm | 36 oz. in. width 39 N/100mm | 8% | Up to 250°F (121°C) | PPP-T-42C, Type I CID A-A883A, Type I |
| 233+ | Green Colored Crepe Paper/Rubber | 6.7 mils 0.17mm | 25 lbs./in. width 403 N/100mm | 38 oz. in. width 37 N/100mm | 12% | Up to 250°F (121°C) Up to 30 minutes | — |
| 234 | Natural Colored Crepe Paper/Rubber | 5.4 mils 0.14mm | 25 lbs./in. width 438 N/100mm | 37 oz. in. width 41 N/100mm | 8% | Up to 250°F (121°C) Up to 1 hour | PPP-T-42C, Type I |
| 236 | Natural Colored Crepe Paper/Rubber | 6.5 mils 0.17mm | 26 lbs./in. width 455 N/100mm | 34 oz. in. width 37 N/100mm | 9% | Up to 250°F (121°C) Up to 1 hour | — |
| 2308 | Natural Colored Crepe Paper/Rubber | 5.6 mils 0.14mm | 22 lbs./in. width 367 N/100mm | 39 oz. in. width 43 N/100mm | 7% | Up to 250°F (121°C) Up to 30 minutes | — |
| 2311 | Natural Colored Crepe Paper/Rubber | 6.2 mils 0.15mm | 24 lbs./in. width 420 N/100mm | 34 oz. in. width 37 N/100mm | 8% | Up to 250°F (121°C) Up to 1 hour | — |
| 2317 | Natural Colored Crepe Paper/Rubber | 6.2 mils 0.16mm | 26 lbs./in. width 455 N/100mm | 34 oz. in. width 37 N/100mm | 11% | Up to 250°F (121°C) Up to 40 minutes | — |

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93



3M Fine Line Masking Tape 4737T is the most conformable fine line masking tape. 4737T Tape conforms to many irregular surfaces, resists lifting and stays in place throughout most paint masking processes. 4737T Tape can withstand 300° F bake cycles for up to 40 minutes.

Scotch® Fine Line Tape 218 is an excellent low temperature masking tape for two-color separation lines in fiberglass boat manufacturing. Boat manufacturers need tapes with excellent quick stick to waxed molds, sharp paint lines and color separations plus conformability to curved surfaces, and solvent holdout and resistance to adhesive transfer.

3M Specialty Tapes are designed to accomplish the most demanding industrial applications. 226 Black polyethylene outdoor masking tape is used to hold polyethylene film to the underbelly of this airplane during a highly caustic paint stripping process. The tape must hold for several weeks, withstand UV exposure, overcome high pressure washing and remove without leaving adhesive. 226 Tape is more than up to this challenge and is considered a standard in the aircraft paint refurbishing industry.

PRODUCT INFORMATION

| Product | Tape Structure (Backing/Adhesive) | Total Tape Thickness (mils (mm)) | Tensile Strength lbs./in. width (N/100mm) | Adhesion oz./in. width (N/100mm) | % of Elongation at Break | Temperature Range (°F/°C) | Government Specification |
|---------|-----------------------------------|----------------------------------|---|----------------------------------|--------------------------|---------------------------|--------------------------|
|---------|-----------------------------------|----------------------------------|---|----------------------------------|--------------------------|---------------------------|--------------------------|

FLATBACK TAPES

| | | | | | | | |
|------------------------|-------------------------|---------------------|------------------------------------|----------------------------------|----|---|--------------------|
| 250 | Flat Stock Paper/Rubber | 5.9 mils 0.15mm | 62 lbs./in. width 1086 N/100mm | 65 oz./in. width 71 N/100mm | 3% | Up to 250°F (121°C) Up to 30 minutes | PPP-T-42C, Type II |
| 254 | Flat Stock Paper/Rubber | 5.7 mils 0.14mm | 62 lbs./in. width 1085 N/100mm | 62 oz./in. width 68 N/100mm | 4% | Up to 200°F (93°C) Up to 30 minutes | — |
| 256/ White, Red, Green | Flat Stock Paper/Rubber | 6.7 mils 0.17mm | 25 lbs./in. width 438 N/100mm | 30 oz./in. width 33 N/100mm | 5% | Up to 200°F (93°C) Up to 1 hour | — |
| 267/Red, White | Flat Stock Paper/Rubber | 5.8 mils 0.15mm | 25 lbs./in. width 438 N/100mm | 30 oz./in. width 33 N/100mm | 5% | Up to 200°F (93°C) Up to 1 hour | — |
| 280 | Flat Stock Paper/Rubber | 8.3 mils 0.21mm | 84 lbs./in. width 1470 N/100mm | 75 oz./in. width 82 N/100mm | 4% | Up to 250°F (121°C) Up to 30 minutes | — |
| 300 | Flat Stock Paper/Rubber | 13.3 mils 0.34mm | 125 lbs./in. width 2188 N/100mm | 141 oz./in. width 154 N/100mm | 5% | Up to 250°F (121°C) Up to 1 hour | — |
| 2516 | Kraft Paper/Rubber | 7.0 mils 0.18mm | 43 lbs./in. width 753 N/100mm | 74 oz./in. width 80 N/100mm | 6% | Up to 150°F (65°C) Up to 30 minutes | — |

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For additional product information call toll free **1-800-362-3550**

3M™ Masking Tapes (Continued)

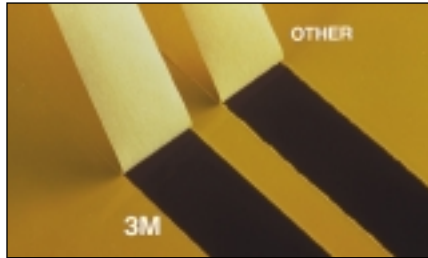
PRODUCT INFORMATION

| Product | Tape Structure (Backing/Adhesive) | Total Tape Thickness | Tensile Strength lbs./in. width (N/100mm) | Adhesion oz./in. width (N/100mm) | % of Elongation at Break | Temperature Range | Comments |
|--------------------------------|--|----------------------|---|----------------------------------|--------------------------|---|--------------------|
| HIGH TEMPERATURE | | | | | | | |
| 213 | Crepe Paper/Rubber | 6.1 mils 0.15mm | 25 lbs./in. width 438 N/100mm | 36 oz./in. width 39 N/100mm | 9% | Up to 350°F (177°C) Up to 1 hour | High Temperature |
| 214 | Crepe Paper/Rubber | 6.7 mils 0.17mm | 24 lbs./in. width 420 N/100mm | 27 oz./in. width 29 N/100mm | 10% | Up to 350°F (177°C) Up to 1 hour | High Temperature |
| 2309M | Crepe Paper/Rubber | 6.2 mils 0.16mm | 31 lbs./in. width 542 N/100mm | 37 oz./in. width 41 N/100mm | 10% | Up to 325°F (163°C) Up to 1 hour | High Temperature |
| 2310M | Crepe Paper/Rubber | 7.5 mils 0.19mm | 27 lbs./in. width 472 N/100mm | 36 oz./in. width 40 N/100mm | 10% | Up to 325°F (163°C) Up to 1 hour | High Temperature |
| 2364 | Crepe Paper/Natural Synthetic/Rubber Blend | 6.5 mils 0.16mm | 30 lbs./in. width 525 N/100mm | 36 oz./in. width 39 N/100mm | 10% | Up to 300°F (148°C) For 30 minutes | High Temperature |
| 2380 | Crepe Paper/Natural Synthetic/Rubber Blend | 7.5 mils 0.19mm | 27 lbs./in. width 472 N/100mm | 40 oz./in. width 43 N/100mm | 10% | Up to 325°F (163°C) For 30 minutes | High Temperature |
| 2393 | Mini-Crepe Paper/Rubber | 7.6 mils 0.19mm | 28 lbs./in. width 490 N/100mm | 30 oz./in. width 32 N/100mm | 11% | Up to 325°F (163°C) Up to 30 minutes | High Temperature |
| 2394 | Mini-Crepe Paper/Rubber | 7.6 mils 0.19mm | 29 lbs./in. width 508 N/100mm | 35 oz./in. width 38 N/100mm | 11% | Up to 325°F (163°C) Up to 30 minutes | High Temperature |
| 2396 | Mini-Crepe Paper/Rubber | 7.6 mils 0.19mm | 28 lbs./in. width 493 N/100mm | 41 oz./in. width 45 N/100mm | 10% | Up to 325°F (163°C) Up to 1 hour | High Temperature |
| 2693 | Mini-Crepe Paper/Rubber | 8.5 mils 0.21mm | 26 lbs./in. width 455 N/100mm | 46 oz./in. width 50 N/100mm | 10% | Up to 325°F (163°C) Up to 30 minutes | High Temperature |
| FINE LINE MASKING TAPES | | | | | | | |
| 215 | Blue, Plastic Film/Rubber | 4.7 mils 0.12mm | 10 lbs./in. width 175 N/100mm | 48 oz./in. width 53 N/100mm | 460% | Up to 250°F (121°C) Up to 40 minutes | Medium Temperature |
| 218 | Green Matte Finish/Polypropylene Film/Rubber | 4.8 mils 0.12mm | 13 lbs./in. width 228 N/100mm | 39 oz./in. width 43 N/100mm | 490% | Up to 250°F (121°C) Up to 30 minutes | Medium Temperature |
| 222 | White Polyester Film/Acrylic | 2.4 mils 0.06mm | 26 lbs./in. width 455 N/100mm | 24 oz./in. width 26 N/100mm | 127% | Up to 325°F (163°C) Up to 1 hour | High Temperature |
| 4735 | Orange Vinyl Film/Rubber | 5.5 mils 0.14mm | 15 lbs./in. width 260 N/100mm | 15 oz./in. width 16 N/100mm | 130% | Up to 300°F (149°C) Up to 30 minutes | High Temperature |
| 4737S | Opaque Blue Vinyl Film/Rubber | 5.1 mils 0.13mm | 14 lbs./in. width 245 N/100mm | 14 oz./in. width 15 N/100mm | 150% | Up to 325°F (163°C) Up to 1 hour | High Temperature |
| 4737T | Translucent Blue Vinyl Film/Rubber | 5.1 mils 0.13mm | 17 lbs./in. width 297 N/100mm | 14 oz./in. width 15 N/100mm | 150% | Up to 325°F (163°C) Up to 1 hour | High Temperature |
| SPECIALTY MASKING TAPES | | | | | | | |
| 217 | Black Crepe Paper/Rubber | 5.7 mils 0.14mm | 26 lbs./in. width 455 N/100mm | 41 oz./in. width 45 N/100mm | 10% | Up to 200°F (93°C) Up to 1 hour | Indoor |
| 225 | Crepe Paper/Rubber | 6.7 mils 0.17mm | 28 lbs./in. width 490 N/100mm | 45 oz./in. width 49 N/100mm | 9% | Up to 200°F (93°C) Up to 1 hour | Outdoor |
| 226 | Polyethylene Saturated Crepe Paper/Rubber | 10 mils 0.25mm | 30 lbs./in. width 526 N/100mm | 40 oz./in. width 43 N/100mm | 8% | Up to 250°F (121°C) Up to 30 minutes | Outdoor |
| 249 | Tan Colored Crepe Paper/Silicone | 6.6 mils 0.17mm | 20 lbs./in. width 350 N/100mm | 33 oz./in. width 36 N/100mm | 11% | Up to 250°F (121°C) | Indoor |
| 2060 | Crepe Paper/Rubber | 6.0 mils 0.15mm | 24 lbs./in. width 420 N/100mm | 34 oz./in. width 37 N/100mm | 8% | Up to 200°F (93°C) Up to 1 hour | Indoor |
| 2070 | Flatback Paper/Low Tack Adhesive | 4.0 mils 0.10mm | 28 lbs./in. width 490 N/100mm | 4 oz./in. width 4 N/100mm | 2.5% | — | Indoor |
| 2090 | Blue Crepe Paper/Synthetic Adhesive | 5.0 mils 0.13mm | 24 lbs./in. width 420 N/100mm | 20 oz./in. width 21 N/100mm | 6% | Up to 200°F (93°C) Up to 30 minutes | Outdoor |
| 2497S | Polyester Rubber/Resin | 3.0 mils 0.08mm | 50 lbs./in. width 875 N/100mm | 18 oz./in. width 19 N/100mm | 93% | Up to 350°F (177°C) Up to 30 minutes | Indoor |
| 2510 | Black Paper/Rubber | 5.3 mils 0.14mm | 25 lb./in. width 437 N/100mm | 46 oz./in. width 50 N/100mm | 6% | Up to 150°F (65°C) Up to 1 hour | Indoor |

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Sharp Paint Edge: Some masking tapes can leave a ragged, poorly developed paint edge that usually requires rework. 3M masking tapes features a thin, smooth backing that results in a sharp paint line.



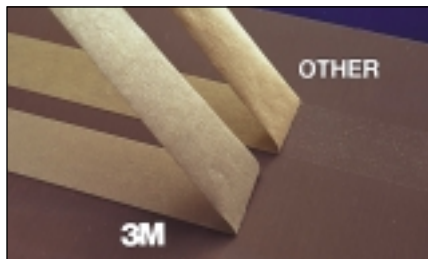
99

Slivering: With 3M masking tapes, removal is less work because the tape doesn't come off the work surface or the roll in strips or pieces.



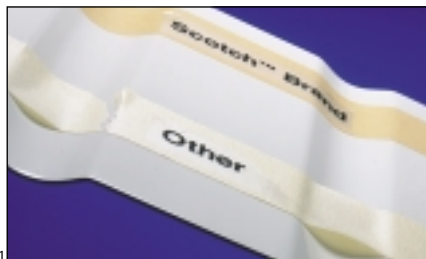
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Conformability: Balanced construction also means 3M masking tapes conform to compound surfaces and around curves without tearing the backing.



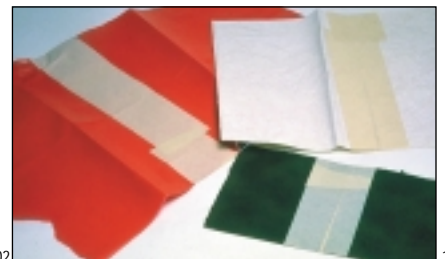
101

Transfer Resistance: Adhesive transfer can cause problems when removing the tape after painting, contributing to lost production time. The balanced construction of 3M masking tapes promotes easy, one-piece removal with excellent adhesive transfer resistance.



102

Dead Stretch: Compound surfaces such as contour or feature lines and curves are easily masked without recovery or lifting of the tape.



103

3M Flatback Tapes are excellent splicing mediums for most web handling applications. The 3M flatback family of tapes offer high machine direction tensile and easy cross tear. 3M flatback tapes come in a variety of thicknesses and adhesion levels for almost any splicing challenge.

PRODUCT INFORMATION

| Product/Color | Paper/Film Structure | Basis Weight | Total Thickness | Machine Direction Tensile Strength (lbs./in. width N/100mm) | Cross Direction Tensile Strength (lbs./in. width N/100mm) | % of Elongation at Break | Temperature Range F/°C |
|---------------------------------|----------------------|------------------------|-----------------|---|---|--------------------------|------------------------|
| LARGE AREA MASKING PAPER | | | | | | | |
| RED | | | | | | | |
| 6708 | 6711 | Treated Paper | 27.5 lbs. | 2.1 mils | 19 lbs./in. width | 23 lbs./in. width | — |
| 6710 | 6713 | | | 0.053mm | 333 N/100mm | 402 N/180mm | |
| WHITE | | | | | | | |
| 6537 | 6539 | Treated Paper | 24 lbs. | 2.2 mils | 18 lbs./in. width | 20 lbs./in. width | — |
| 6538 | 6540 | | | 0.056mm | 315 N/100mm | 315 N/100mm | |
| GRAY | | | | | | | |
| 6503 | 6518 | Steel Gray | 30 lbs. | 2.6 mils | 27 lbs./in. width | 28 lbs./in. width | 400°F (204°C) |
| 6506 | 6524 | Colored Paper | | | | | |
| 6509 | 6530 | | | | | | |
| 6512 | 6536 | | | | | | |
| 6515 | | | | | | | |
| GOLD | | | | | | | |
| 6706 | 6729 | Specially Coated Paper | 27 lbs. | 2.0 mils | 17 lbs./in. width | 22 lbs./in. width | — |
| 6712 | 6732 | | | 0.05mm | 298 N/100mm | 385 N/100mm | |
| 6715 | 6736 | | | | | | |
| 6718 | 6738 | | | | | | |
| 6726 | | | | | | | |
| | | | | | | | |
| BOLD BRICK | | | | | | | |
| 6603 | 6615 | Treated Paper | 31 lbs. | 2.7 mils | 24 lbs./in. width | 29 lbs./in. width | — |
| 6606 | 6618 | | | 0.068mm | 420 N/100mm | 507 N/100mm | |
| 6609 | 6624 | | | | | | |
| 6612 | 6636 | | | | | | |
| | | | | | | | |

| Product/Color | Paper/Film Structure | Gauge | Emboss Gauge | Machine Direction Tensile Strength (lbs./in. width N/100mm) | Cross Direction Tensile Strength (lbs./in. width N/100mm) | % of Elongation at Break | Temperature Range F/°C |
|----------------------------------|-----------------------------|----------------------|---------------------|---|---|--------------------------|--|
| LARGE AREA MASKING FILM | | | | | | | |
| 6700 Paint Repair Bags | Low Density Polyethylene | 1.0 mils 0.025 mm | — | 3.0 lbs./in. width 52 N/100mm | 3.0 lbs./in. width 52 N/100mm | 400% | Up to 210°F (100°C) |
| 6703 | Aluminum Metalized | 0.5 mils | — | 15.3 lbs./in. width | 12 lbs./in. width | — | Up to 340°F (170°C) Rejects over 70% of heat load for 1 hour. |
| 6704 | Polyester Film | 0.01 mm | | 268 N/100mm | 210 N/100mm | | |
| 6727 | High Density Polyethylene | 0.45 mils 0.011mm | 0.45 mils 0.01mm | 3.5 lbs./in. width 61 N/100mm | 2.0 lbs./in. width 35 N/100mm | 300% | Up to 225°F (107°C) |
| 6728 | High Density Polyethylene | 0.45 mils 0.011mm | — | 3.5 lbs./in. width 61 N/100mm | 2.0 lbs./in. width 35 N/100mm | 300% | Up to 225°F (107°C) |
| 6730 Paint Repair Bags | High Density Polyethylene | 0.7 mils 0.018 mm | — | 6.2 lbs./in. width 108 N/100 mm | 4.3 lbs./in. width 75 N/100mm | 400% | Up to 225°F (107°C) |
| 6739 | High Density Polyethylene | 0.43 mls 0.011 | — | 3.2 lbs./in. width 56 N/100mm | 1.5 lbs./in. width 26 N/100mm | 250% | Up to 225°F (107°C) |
| 6740 | High Density Polyethylene | 0.43 mls 0.011 | — | 3.2 lbs./in. width 56 N/100mm | 1.5 lbs./in. width 26 N/100mm | 250% | Up to 225°F (107°C) |
| 7000/Tan | Textured Polypropylene | 2.7 mils 0.07mm | 4.2 mils 0.11mm | 11 lbs./in. width 190 N/100mm | 10.0 lbs./in. width 175 N/100mm | 600% | Up to 310°F (155°C) |
| 7160 Paint Repair Bags | Soft Polypropylene | 1.6 mils 0.040 | — | 6 lbs./in. width 100N/100mm | 4.0 lbs./in. width 70 N/100mm | 600% | Up to 315°F (157°C) |
| 7300 Film | Textured Soft Polypropylene | 2.0 mils 0.05mm | 2.9 mils 0.07mm | 8.8 lbs./in. width 154 N/100mm | 4.7 lbs./in. width 82 N/100mm | 600% | Up to 310°F (155°C) |
| 7300 Paint Repair Bags | Soft Polypropylene | 1.8 mils 0.045mm | 2.0 mils 0.05mm | 6 lbs./in. width 100 N/100mm | 4 lbs./in. width 70 N/100mm | 600% | Up to 310°F (155°C) |
| MF-6 MF-9 MF-12 | White Polyethylene Film | 0.4 mils 0.10mm | — | 4.8 lbs./in. width 84 N/100mm | 2.0 lbs./in. width 35 N/100mm | — | Up to 200°F (93°C) for 1 hour |
| MF-24 MF-48 MF-72 MF-99 | High Density Polyethylene | | | | | | |

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Dispensers for Large Area Masking



104

Tray Masker 06783
Dispenses one apron of any length up to 36 in. wide. Can be wall mounted.*



105

Slimline Apron Taper 06864
Dispenses three widths of masking paper up to 18 in. wide. Side hooks hold different tape widths for special needs.



106

Utility Masker 06810
Portable Utility masker dispenses single aprons up to 12 in. wide for fast, easy masking.



107

Tray Masker 06784, 18 in.
Dispenses one apron of any length up to 18 in. wide. Can be wall mounted.*



108

Multi Mobile Masker 06869
Designed to cut masking time. Two to three roll capacity when used with Conversion Kit, Part No. 6782.*



109

Handy Masker 06814
Step-stool top combined with a smooth operating masker for high, hard-to-reach areas. Dispenses 3 in., 6 in., or 12 in. wide paper



110

Cart Masker 06781
Dispenses one apron of any length up to 18 in. wide on each of two levels.*



111

Apron Taper 06865
Dispenses single aprons up to 18 in. wide or any combination of two paper or film widths up to 18 in. wide with Conversion Kit, Part No. 6782.* Film Cutter Blade, Part No. 6785



112

Apron Taper 06866
Dispenses single aprons up to 36 in. wide or any combination of widths up to 36 in. wide when used with Conversion Kit, Part No. 6782.* Film Cutter Blade Attachment, Part No. 6786.



113

Mobile Frame 06871
Designed to have the Scotch™ Apron Taper, Part No. 6866, added to the top, this frame is for those wishing to build a mobile 36 in. dispenser. Pre-assembled except for insertion of two bolts to make frame operative.

* Apron Taper Conversion Kit 6782: converts maskers to handle one extra roll of masking paper.