Electroplating Tape
470

Technical Data

Product Description

A conformable and abrasion-resistant vinyl tape with excellent resistance to most chemicals used in typical electroplating processes. 470 tape can be qualified to meet specification HH-T-0025, Amendment 2.

Product Construction

Backing	Adhesive	Color	Standard Roll Length
Pigmented vinyl plastic	Rubber	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:	26 oz./in. width (28 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:	7.1 mils (0.18 mm)	D-3652
Temperature Use Range:	Up to 170°F (77°C)	

General Information

- Excellent resistance to most chemicals used in typical electroplating operations.
- Prolonged exposure to elevated temperatures (above 170°F/77°C) and hot caustics may cause weakening of the adhesive bond.
- Can be qualified to meet Federal Specification HH-T-0025 (GSA-FSS).
- While 470 tape 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.

Shelf Life

To obtain best performance, use this product within 18 months from date of manufacture and store under normal conditions of 60º to 80ºF (16º to 27ºC) and 40 to 60% R.H. in the original carton.

Application Ideas

- Masking during many electroplating operations, including both flat strip and overlapping masks.
- Wrapping, patching, coated racks and masking many irregular surfaces.

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Features

Features	Advantages	Benefits
• Resistant to most electroplating chemicals	• Less undercutting	• Helps save money because of fewer rejects
• Abrasion resistant	• Helps protect parts from processing scratches and grit blasting	• Helps save money by reducing rework
• Conformable backing	• Follows contours	• Helps save money by reducing rework

Technical Information and Data

The technical information and data, recommendations, and other statements provided in this brochure are based on tests or experience which 3M believes to be reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use

Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be used with the 3M product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

Limited Warranty and Limited Remedy

The 3M product will be free from defects in material and manufacture for a period of one (1) year from the date of manufacture. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. If the 3M product is defective within the warranty period stated above, YOUR EXCLUSIVE REMEDY AND 3M'S SOLE OBLIGATION SHALL BE, AT 3M'S OPTION, TO REPLACE OR REPAIR THE 3M PRODUCT OR REFUND THE PURCHASE PRICE OF THE 3M PRODUCT.

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ISO 9002

This Industrial Tape and Specialties Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

3M

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