



Water-Soluble Wave Solder Tape

5414

Technical Data

Product Description Tape 5414 has a poly-vinyl alcohol backing which is water soluble and a synthetic water soluble adhesive to mask gold fingers on printed circuit boards during wave soldering.

Product Construction	Backing	Adhesive	Liner	Color	Standard roll Length
	PVA film	Water soluble synthetic	Kraft paper	Hazy, transparent	36 yds (33m)

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:	4 oz./in. width (4.4 N/100mm)	D-3330
Tensile Strength at Break:	6 lbs./in. width (105.1 N/100mm)	D-3759
Elongation at Break:	334%	D-3759
Total Tape Thickness:	2.1 mils (.053mm)	D-3652

Shelf Life To obtain best performance, use this product within 12 months from date of manufacture and store under normal conditions of 60° to 80°F (15° to 21°C) and 40 to 50% R.H. in the original carton.

Features	Features	Advantages	Benefits
	Water soluble	No manual removal required Low static removal	Helps save labor costs
		No adhesive residue after removal	Helps save labor costs/no cleaning
	Low static upon liner release	Low static when taping board	
	Moisture barrier packaging plus desiccant	Humidity extremes do not affect tape properties	Consistent product performance
	Easy application	Easy manual and machine (S-45) application	Helps save labor costs

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Technical Information and Data

The technical information and data, recommendations, and other statements provided in this document 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

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

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