# **3M**

# PTFE Skived Film Tape

5480 • 5481

Technical Data				June, 2009
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Product Description	3M <sup>™</sup> PTFE Skived Film Tape 5480 and 5481 has a film backing with a silicone adhesive.			
<b>Product Construction</b>	Backing	Adhesive	Color	Standard Roll Lengtl
	Skived PTFE (polytetrafluoroethylene)	Silicone	Gray	36 yds. (32.9 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			
	3M tape 5480		<b>&gt;</b>	
	Adhesion to Steel:	20 oz./in. width (22 N/100 mm)		
	- 1 / / / / / / / / / / / / / / / / / /	27 lbs./in. width (473 N/100 mm)		D-3330
	Tensile Strength:	27 lbs./in. widt	th (473 N/100 mm)	D-3330 D-3759
	Elongation at Break:	140%	,	
.XX	Elongation at Break: Backing Thickness:	140% 2.0 mils (0.05	mm)	D-3759
	Elongation at Break: Backing Thickness: Total Tape Thickness:	140% 2.0 mils (0.05 3.7 mils (0.09	mm) mm)	D-3759 D-3759
	Elongation at Break: Backing Thickness:	140% 2.0 mils (0.05 3.7 mils (0.09	mm)	D-3759 D-3759 D-3652
	Elongation at Break: Backing Thickness: Total Tape Thickness:	140% 2.0 mils (0.05 3.7 mils (0.09	mm) mm)	D-3759 D-3759 D-3652
	Elongation at Break: Backing Thickness: Total Tape Thickness: Temperature Use Range:	140% 2.0 mils (0.05 3.7 mils (0.09 -65° to 400°F	mm) mm)	D-3759 D-3759 D-3652
	Elongation at Break: Backing Thickness: Total Tape Thickness: Temperature Use Range: 3M tape 5481	140% 2.0 mils (0.05 3.7 mils (0.09 -65° to 400°F 32 oz./in. widt	mm) mm) (-54° to 204°C)	D-3759 D-3759 D-3652 D-3652
	Elongation at Break: Backing Thickness: Total Tape Thickness: Temperature Use Range:  3M tape 5481 Adhesion to Steel:	140% 2.0 mils (0.05 3.7 mils (0.09 -65° to 400°F 32 oz./in. widt	mm) mm) (-54° to 204°C) h (35 N/100 mm)	D-3759 D-3759 D-3652 D-3652
	Elongation at Break: Backing Thickness: Total Tape Thickness: Temperature Use Range:  3M tape 5481 Adhesion to Steel: Tensile Strength:	140% 2.0 mils (0.05 3.7 mils (0.09 -65° to 400°F 32 oz./in. widt 49 lbs./in. widt	mm) mm) (-54° to 204°C) h (35 N/100 mm) th (858 N/100 mm)	D-3759 D-3759 D-3652 D-3652 D-3330 D-3759
	Elongation at Break: Backing Thickness: Total Tape Thickness: Temperature Use Range:  3M tape 5481 Adhesion to Steel: Tensile Strength: Elongation at Break:	140% 2.0 mils (0.05 3.7 mils (0.09 -65° to 400°F 32 oz./in. widt 49 lbs./in. widt 335%	mm) mm) (-54° to 204°C)  h (35 N/100 mm) th (858 N/100 mm)	D-3759 D-3759 D-3652 D-3652 D-3330 D-3759 D-3759

### **Features**

- Skived film tapes demonstrate good conformability when wrapping rollers.
- Provides excellent chemical resistance except to organic solvents. **Note:** The silicone adhesive will be attacked by commercial organic solvents and so are not recommended for applications requiring organic resistance.
- To help prevent wrinkling or bubbling of the backing on PTFE film tapes when they are subjected to temperatures above 250°F (121°C), pre-heat the surface to at least 150°F (66°C) (preferred 180°F, 82°C) to obtain best results.

**CAUTION:** When PTFE film tape is exposed to temperatures above 400°F (204°C), small quantities of hazardous vapors may be released. INHALATION OF THESE VAPORS MAY BE HARMFUL OR MAY CAUSE RESPIRATORY TRACT IRRITATION. Do not heat or expose PTFE film tape to temperatures above 400°F (204°C).

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## **Application Ideas**

- Wrapping rubber laminating rollers on hot polyethylene extruders to create a release surface to help minimize clean-up.
- Easy-release surface provided by wrapping rollers, plates, belts, etc. where build-up of sticky materials and inks can occur.
- Chemical resistant surface for sealing and masking.

### **Storage**

Store under normal conditions of  $60^{\circ}$  to  $80^{\circ}$ F ( $16^{\circ}$  to  $27^{\circ}$ 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.

#### **Product Use**

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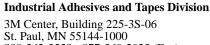
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ISO 9001:2000

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