



# High Strength Double Coated Tapes

## 93010LE • 93015LE • 93020LE

Technical Data

October 2017

**Product Description** 3M™ Double Coated Tapes with 3M™ High Strength Acrylic Adhesive 300LSE provides a high bond strength to most surfaces, including many low surface energy plastics such as polypropylene and powder coated paints. The acrylic adhesive also provides excellent adhesion to surfaces contaminated with oil typically used with machine parts.

Construction Information	Product Number	Faceside <sup>1</sup> Adhesive Type Thickness	Carrier Type Thickness	Backside <sup>2</sup> Adhesive Type Thickness	Liner Color, Type, Caliper <sup>3</sup>	Total Thickness (w/o liner)
	3M™ Double Coated Tape 93010LE	300LSE	Clear Polyester 0.044 mm (1.7 mil)	0.012 mm (0.5 mil)	300LSE 0.044 mm (1.7 mil)	Tan, 58# Polycoated Kraft 0.10 mm (4.0 mil)
3M™ Double Coated Tape 93015LE	300LSE	Clear Polyester 0.069 mm (2.7 mil)	0.012 mm (0.5 mil)	300LSE 0.069 mm (2.7 mil)	Tan, 58# Polycoated Kraft 0.11 mm (4.2 mil)	0.15 mm (5.9 mil)
3M™ Double Coated Tape 93020LE	300LSE	Clear Polyester 0.095 mm (3.7 mil)	0.012 mm (0.5 mil)	300LSE 0.095 mm (3.7 mil)	Tan, 58# Polycoated Kraft 0.11 mm (4.2 mil)	0.20 mm (7.9 mil)

Note 1: Faceside (FS) adhesive is on the interior of the roll, exposed when unwound.

Note 2: Backside (BS) adhesive is on the exterior of the roll, exposed when liner is removed.

Note 3: The caliper listed is based on a calculation from manufacturing controlled adhesive coat weights using a density of 1.012 g/cc.

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Typical Physical  
Properties and  
Performance  
Characteristics

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

	3M™ Double Coated Tape											
Product Number	93010LE			93015LE			93020LE					
Adhesive	300LSE			300LSE			300LSE					
Tape Thickness	0.10 mm			0.15 mm			0.20 mm					
Breakdown Voltage	5600 volts			6900 volts			7500 volts					
Dielectric Strength	1400 volts/mil			1200 volts/mil			900 volts/mil					
Adhesion 15 min dwell @ RT Modified ASTM D-3330 180 degree peel 2 mil Al foil backing	oz/in	N/cm	kg/25.4mm	oz/in	N/cm	kg/25.4mm	oz/in	N/cm	kg/25.4mm			
	SS	85	9.3	2.4	SS	100	10.9	2.8	SS	155	17.0	4.4
	PC	110	12.3	3.1	PC	130	14.2	3.7	PC	165	18.1	4.7
	ABS	80	8.8	2.3	ABS	85	9.3	2.4	ABS	145	15.9	4.1
	PP	95	10.4	2.7	PP	105	11.5	3.0	PP	155	17.0	4.4
Adhesion 72 hr dwell @ RT Modified ASTM D-3330 180 degree peel 2 mil Al foil backing	oz/in	N/cm	kg/25.4mm	oz/in	N/cm	kg/25.4mm	oz/in	N/cm	kg/25.4mm			
	SS	110	12.0	3.1	SS	125	13.7	3.6	SS	170	18.6	4.8
	PC	140	15.3	4.0	PC	165	18.1	4.7	PC	180	19.7	5.1
	ABS	110	12.0	3.1	ABS	125	13.7	3.6	ABS	155	17.0	4.4
	PP	110	12.0	3.1	PP	135	14.8	3.9	PP	175	19.2	5.1
Shear Strength at RT Modified ASTM D-3654 1 inch <sup>2</sup> sample size 1000 grams	10,000 Minutes			10,000 Minutes			10,000 Minutes					
Shear Strength at 158°F (70°C) Modified ASTM D-3654 1 inch <sup>2</sup> sample size 500 grams	10,000 Minutes			10,000 Minutes			10,000 Minutes					

### Features

- This tape has a film carrier which can add dimensional stability to foams and other substrates and also makes it easier to handle the tape during slitting and die-cutting.
- The bond strength of 3M™ Acrylic Adhesive 300LSE increases as a function of time and temperature, and has very high initial adhesion.

### Available Sizes

Roll length, width, slitting tolerance, core size.

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Maximum Length in.:

1/2" to 63/64"	180 yds. (164 m)
1" to 3"	360 yds. (329 m)
3" to 48"	360 yds. (329 m)
48" to 54"	360 yds. (329 m)

Normal Slitting Tolerance: ± 1/32 in. (0.08 mm)

Core Size (ID): 3.0 in. (76.2 mm)

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Temperature Resistance	Long Term (days, weeks): 250°F (121°C) Short Term (minutes, hours): 300°F (149°C)
Humidity Resistance	No adverse effect on the bond after exposed to 100% relative humidity at 100°F (38°C).
U.V. Resistance	Adhesive is resistant to oxidation and ozone when exposed to air or ultraviolet light.
Application Techniques	<p>Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure helps develop better adhesive contact and improve bond strength. To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Some typical surface cleaning solvents are isopropyl alcohol or heptane.*</p> <p>*Note: Carefully read and follow the manufacturer’s precautions and directions for use when using solvents. Ideal tape application temperature range is 70°F to 100°F (21°C to 38°C). Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.</p>
Environmental Performance	<p>Humidity Resistance: High humidity has minimal effect on adhesive performance. No significant reduction in bond strength is observed after exposure for 7 days at 90°F (32°C) and 90% relative humidity.</p> <p>UV Resistance: When properly applied, nameplates and decorative trim parts are not adversely affected by exposure.</p> <p>Water Resistance: Immersion in water has no appreciable effect on the bond strength. After 100 hours at room temperature, the high bond strength is maintained.</p> <p>Temperature Cycling Resistance: High bond strength is maintained after cycling four times through:</p> <ul style="list-style-type: none"> <li>4 hours at 158°F (70°C)</li> <li>4 hours at -20°F (-29°C)</li> <li>4 hours at 73°F (22°C)</li> </ul> <p>Chemical Resistance: When properly applied, nameplate and decorative trim parts will hold securely after exposure to numerous chemicals including oil, mild acids, and alkalis.</p>
Application Ideas	<ul style="list-style-type: none"> <li>• Foam to powder coated painted surfaces.</li> <li>• Low surface energy plastic adhesion.</li> </ul>

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**Storage** Store in original cartons at 70°F (21°C) and 50% relative humidity.

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**Shelf Life** If stored under proper conditions, these products retain their performance and properties for two years from date of manufacture.

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ISO 9001

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.



Industrial Adhesives and Tapes  
Division Converter Markets  
3M Center, Building 225-3S-  
06 St. Paul, MN 55144-1000  
800-223-7427 • 651-778-4244 (fax)  
www.3M.com/converter

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Printed in U.S.A.  
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