



# Adhesive Transfer Tape

## 9447

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### Technical Data

March, 2009

#### Description

3M™ Adhesive Transfer Tape 9447 is specifically designed for use with 3M™ Label Component Systems for protected graphics printing of polyester films. Also can be used in constructing custom tamper-indicating labels.

#### Product Construction

<b>Adhesive:</b>	1.0 mil (25 microns) #320 "Hi-Tenacity" Acrylic
<b>Liner:</b>	3.2 mil (80 microns) 55# Densified Kraft

#### Features

- 3M™ Adhesive 320 is used for general purpose applications and offers excellent flagging resistance and adhesion to a variety of substrates.
- The liner provides an ideal surface for rotary die-cutting.
- Adhesive has a temperature range of -40°F (-40°C) to 150°F (65°C) for days or weeks and to 250°F (121°C) for minutes or hours.

#### Applications

- Used to make tamper-indicating labels with Label Component System films and solutions. These labels may be used as seals for over-the-counter drugs, banking envelopes, non-transferable automobile inspection labels and a variety of other applications.
- A component in the construction of labels with protected, or sub-surface printed graphics, used in harsh environments such as automotive under hood or outdoor environments.

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## 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 D-3330 (modified)  
(90 degree peel, 12"/min. 305 mm/min.)  
2 mil polyester to stainless steel:

	20 Minute Dwell Oz./In.
	28

2 mil polyester to various surfaces:

	72 Hour Dwell at Room Temp. Oz./In.
Stainless Steel (Metal)	34
Polycarbonate (High Surface Energy Plastics)	35
Polypropylene (Low Surface Energy Plastics)	9

## Environmental Performance

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

The properties defined are based on the attachment of impervious faceplate materials (such as polyester) to an aluminum test surface. Values are listed in ounces per inch based on a 90 degree peel at 12 inches/minute (305 mm/min.).

Unleaded Gas at 1 Hr. (Room Temp.)	20
MEK at 1 Hr. Room Temp.	24
Freon TF at 1 Hr. Room Temp.	28
Weak Acid (pH 4) at 4 Hrs. Room Temp.	30
Weak Base (pH 10) at 4 Hrs. Room Temp.	25
Oil (10W30) at 72 Hrs. 120°F (49°C)	37
Water at 100 Hrs. Room Temp.	36
7 Days at 90°F (32°C) and 90% Relative Humidity	56
Temperature Cycling: 4 Hrs. at 158°F (70°C) 4 Hrs. at -20°F (-29°C) 16 Hrs. at Room Temp. Repeat three times	40

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<b>Processing</b>	For processing instructions, refer to the "Label Component System Process Guide."
<b>Storage</b>	Store at room temperature conditions of 72°F (22°C) and 50% relative humidity.
<b>Shelf Life</b>	Product retains its performance and properties for two years from date of manufacture.
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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.

## 3M

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