



High Performance Permanent Tackified Acrylic Adhesive P1480

Technical Data

May, 2006

Product Description 3M™ High Performance Permanent Tackified Acrylic Adhesive P1480 is formulated for acid resistance and adhesion to polyolefins, and this adhesive exhibits high initial tack, as well as, ultimate adhesion and is designed to meet the demanding requirements of most battery label specifications.

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.

Adhesion properties determined per TLMI Method using 1.0 mil polyester with 1.1 mils of adhesive on a stainless steel panel.

Peel Adhesion	5.0 lbs./in. (880 N/m)	TLMI Method, 180° Peel, 12"/min., 1" wide sample
Loop Tack	3.5 lbs./in. (616 N/m)	TLMI Method, 12"/min., 1" wide sample
Shear	1.0 hour	TLMI Method, 1.0 in. ² x 1000g
Application Temperature	40°F to 120°F (5°C to 49°C)	
Service Temperature*	-22°F to 221°F (-30°C to 105°C)	

*Actual service temperature is a function of the entire construction, including the facestock. Care should be taken to match facestock temperature limitations with the label application requirements.

Features

- High initial tack
- Good ultimate adhesion on a wide variety of surfaces
- Adhesive dry ingredients are listed by FDA as indirect food contact additives when used in food packaging with minimum opportunity for exposure. See 21 CFR 175.105.
- Meets CONEG requirements

Application Ideas

- Automotive battery
- Machinery
- Durable goods
- Ladders

Recommended Substrates

- Textured surfaces
- Polyolefins / low surface energy plastics
- Powder coated paints
- Wood
- Aluminum
- Fiberglass

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Die Cutting Rotary die cutting is recommended. Fanfolding of labels is not recommended. Small labels should be evaluated carefully. Winding tensions should be kept at a minimum to help prevent the adhesive from oozing.

Storage Conditions Store under normal conditions of 70°F (21°C) and 50% relative humidity. To minimize the effects of humidity on the products, package the die-cut and printed stock in polyethylene bags. Low density polyethylene (2-4 mils) can help prevent humidity penetration.

Shelf Life To obtain best performance, use this product within two years from the date of manufacture.

Product Use All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors 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.

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



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