

# Technical data sheet



Product: 855

Manufacturer: 3M DEUTSCHLAND GMBH

Product group: KLEBEBAND

Article group: EINSEITIG

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## 3M™ HIGH TEMPERATURE NYLON TAPE 855

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## Technical Data Sheet

### 3M™ High Temperature Nylon Tape 855



[Product Details](#)



[Regulatory Info/SDS](#)

#### **Product Description**

3M™ High Temperature Nylon Tape 855 is a strong nylon backings and a high temperature rubber adhesive. Used to hold down materials during composite or metal bonding bagging operations or assist in removing flashing after composite bonding, where the use of a non-silicone tape is preferred.

#### **Product Features**

- High temperature performance is achieved without the use of silicone adhesive which eliminates silicone residue which often interferes with cleaning operations and anchorage of certain adhesives and paints.
- High temperature - clean removal to a variety of surfaces after exposure to 350°F (177°C) for several hours. In shorter cycles, the tape can be expected to provide satisfactory performance up to 400°F (204°C) bake cycles.
- Nylon backing for toughness, high elongation, quick removal, and ease of application.

#### **Technical Information Note**

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

#### **Typical Physical Properties**

Attribute Name	Test Method	Value
Color		Cream
Adhesive Type		Rubber
Backing		Nylon
Backing Thickness	ASTM D3652	0.051 mm (2 mil)
Total Tape Thickness	ASTM D3652	0.091 mm (3.6 mil)

#### **Typical Performance Characteristics**

Attribute Name	Test Method	Temperature	Value
180° Peel Adhesion	ASTM D3330	22 °C (72 °F)	6.1 N/cm (57 oz/in) <sup>1</sup>
Elongation at Break	ASTM D3759		460 %
Tensile Strength	ASTM D3759		56 N/cm (32 lb/in)

<sup>1</sup> 12 in/min (300 mm/min)

Attribute Name	Value
Long Term Temperature Resistance	204 °C (400 °F) <sup>1</sup>
Minimum Long Term Temperature Resistance	16 °C (60 °F) <sup>1</sup>
Temperature Use Range note	Withstands autoclave cycles up to 350°F (177°C)

<sup>1</sup> Long Term (day, weeks)

## **Handling/Application Information**

### **Application Examples**

- Holding down composite or metal bonding materials during autoclave processes.
- Used to remove flash after composite or metal bonding operations.
- Advanced composite and metal bond masking as non-silicone adhesive allows use on many parts and tooling equipment where subsequent painting or bonding operations will take place.
- High temperature paint masking up to 400°F (204°C) for short term bake cycles.

### **Storage and Shelf Life**

Store under normal conditions of 16° to 27°C (60° to 80°F) and 40 to 60% relative humidity in the original packaging, out of direct sunlight. For best performance, use this product within 18 months from date of manufacture.

### **Available Sizes**

Attribute Name	Value
Standard Roll Length	65.8 m (72 yd)

### **Information**

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### **ISO Statement**

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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