

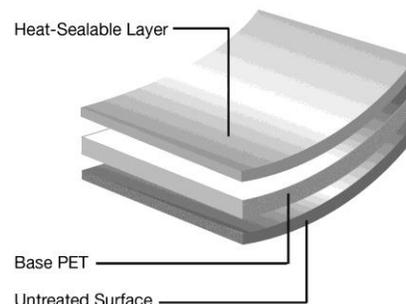
3M Scotchpak™ MA-250M

DESCRIPTION:

3M Scotchpak™ MA-250M is a heat sealable, adhesive-free, translucent polyester film that provides a strong heat seal to a variety of clean metal surfaces and metal vapor coatings.

APPLICATIONS:

- Collate nails, staples and other metal fasteners
- Strong thermal lamination bonds to metal foils and metal vapor coated surfaces



TECHNICAL DATA:

| PROPERTIES | UNIT OF MEASURE | TYPICAL VALUE | TEST METHOD |
|-----------------------|---------------------|---------------|----------------------------------|
| Thickness | Gauge | 250 | - |
| Yield | in ² /lb | 10,886 | - |
| Break Strength | Lb/in | 15 | ASTM D1992 |
| Heat Seal Temperature | °F | 300-400 | 0.2-2.0 secsx20-60 PSI |
| Heat Seal Strength | Lb/in | 14 | Face/facex355 °F x 1sec x 40PSI |
| Heat Seal to Steel | Lb/in | 12 | Film/steelix355°F x 1sec x 40PSI |

Proper Film Use: To achieve a good bond at reasonable application rates, it is necessary to heat the metal so that the film-to-metal interface temperature is maintained for a sufficient amount of time to effect a bond. In a typical application, the metal surface is heated to a range of 300-400°F (149-204°C) via IR radiation (quartz lamps, resistance heaters, etc...), gas flame, induction or hot air methods. This is followed immediately by bonding of the Scotchpak™ film under a rubber covered pressure roller with nip pressure of 20-60 PSI. The roller should be constructed of a high temperature resistant rubber (e.g. silicone) with hardness of 40-60 durometer. The finished work should be cooled slowly to below 140°F (60°C) prior to handling to allow a good bond to develop.

All information, recommendations and suggestions contained herein, including, without limitations, stated values (collectively the "Information") shall be used only as a guide by Purchaser and not for specification or any other purpose. The Information does not constitute a warranty nor guaranty of any type whatsoever. Purchaser should independently determine the suitability of all material purchased and must confirm adaptability and other characteristics by conducting its own test. Transcendia shall have no liability as a result of any loss, expense, damage, cost or other injury which results from Purchaser's reliance on the Information.

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