



X-Series Double Coated Paper Tapes

XR8115 • XR8123

Technical Data

February, 2013

X-Series Description

3M™ X-Series Industrial Attachment Tapes offer a variety of performance characteristics and product constructions to support demanding application requirements. This product line provides a range of adhesive transfer and double-coated tapes designed for attachment of paper, corrugated, films, foils, fabric, plastics and metal. Double Coated (DC) tapes provide a backing for improved handling. Adhesive Transfer Tapes (ATT) provide the thinnest bond lines. The 3M™ X-Series Tape System is manufactured in the United States by 3M.

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The X-Series Tape System offers four performance categories enabling quick identification and selection of the appropriate product for the intended application.

- XP - High Performance Acrylic – superior holding power over a range of temperatures.
- XT - High Tack Acrylic Adhesive – excellent initial adhesion for hard-to-stick surfaces.
- XG - General Purpose Acrylic – a clean acrylic adhesive for paper bonding and sensitive applications.
- XR - Rubber Adhesive – good initial grab and clean removal on many surfaces.**

Construction

Products	X-Series Double Coated Paper Tapes	
	XR8115	XR8123
Adhesive Type:	Natural Rubber	
Adhesive Carrier:	Treated Paper	
Release Liner:	White Densified Kraft Liner with Red Print	
Approximate Thickness:		
Release Liner:	0.003 inches (0.08 mm)	
Tape Only:	0.006 inches (0.15 mm)	0.009 inches (0.23 mm)
Tape Color:	Cream Color	

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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.

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	Faceside ⁽¹⁾	Backside ⁽²⁾	Faceside ⁽¹⁾	Backside ⁽²⁾
Adhesion to Stainless Steel: 180 Degree Peel (ASTM Test Method – 2-mil Al)	68 oz/in (74 N/100mm)	64 oz/in (70 N/100mm)	74 oz/in (81 N/100mm)	92 oz/in (101 N/100mm)
Relative High Temperature Operating Ranges:				
Long Term (days / weeks)	120°F (49°C)			
Short Term (minutes / hours)	150°F (66°C)			
Relative Solvent Resistance:	Low			
U.V. Resistance:	Medium			
Shelf Life of Tape in Roll Form:	12 Months from date of manufacture when stored in original cartons at 70°F and 50% relative humidity.			

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

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

Available Sizes - Minimum Order Quantity Requirements

Please contact your 3M Customer Service Representative for available sizes and minimum order quantity requirements.

Features and Benefits

- Excellent quick stick adhesion.
- Bonds to many foils, papers and plastics.
- Excellent for temporary holding of parts during machining processes.
- Paper carrier adds dimensional stability for handling and removal.

Application Techniques

- 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.*

***Note:** Be sure to follow solvent 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 satisfactory.

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Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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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

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40% pre-consumer
10% post-consumer

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