

3M Medical Materials & Technologies

Frequently Asked Questions & Converting Tips for:

3M™ Medical #4075 Extended Wear Transfer Adhesive

Effective: March 2019

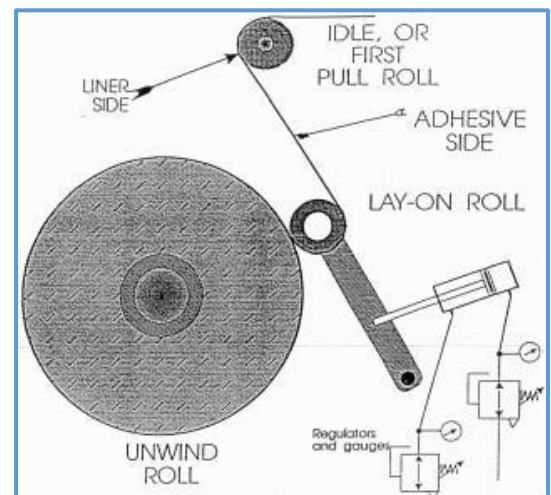
Supersedes all previous versions

Appearance and Converting Suggestions:

#4075 is a thick, relatively soft tackified acrylic adhesive provided on a thin, clear polyester liner with differential silicone release chemistry on both sides. There is a slight yellowish color to most acrylic-based adhesives especially those that are tackified. This is normal and only evident when multiple layers are visible – such as the rolls of #4075.

The soft, thick adhesive tends to dry more slowly in the ovens during production. This results in a somewhat more “mottled” or uneven upper or face side surface when it is wound/unwound. The mottling – often referred to as “fish eyes”, “orange peel”, “laking”, or other similar terms – is cosmetic and does not affect the adhesion properties or performance of the transfer adhesive based on testing done by 3M Medical Materials & technologies during our commercialization. Taking care during any lamination steps in converting by keeping the adhesive surface from contacting the lamination substrate except at the point of necessary contact under the nip roll will help prevent air pockets becoming trapped between layers.

A differential release liner is typically used for double-coated & transfer adhesives. This type of release liner design helps ensure that when the product is unwound, the adhesive stays with one side of the release liner [the side with slightly tighter or higher release values] to reduce chances of “liner confusion”. This problem occurs when adhesive switches back & forth during the breakaway from the release surfaces intermittently making unwinding and laminating to other materials more difficult. To help encourage correct unwind, especially at start-up, a small diameter “breaker bar” or “lay-on” roller can be used to ensure that the angle of unwind is as close as possible to back on itself as possible. If using a secondary liner, try cutting parts with the original film liner on top of the stack for best results.



Storage:

Store in the original packaging in areas where the temperature & humidity levels are controlled. Keeping the rolls in the packaging also prevents any possible damage from strong lighting – indoor or outdoor – which may affect the color and other properties over time. This is a soft, thick adhesive coating and long-term storage at higher temperatures [$>120\text{degF}/50\text{degC}$] may result in adhesive flow to the edges which could cause problems with unwinding and possibly a loss of overall adhesive thickness and make the coating uneven across the web. Colder storage shouldn't be a problem if the rolls are allowed to return to standard room temperatures and remain protected in the original packaging to help reduce condensation.

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Medical Materials & Technologies

3M Center, Building 275-5W-05
St. Paul, MN 55144-1000 USA

Phone 1-800-228-3957
Web 3M.com/MedTech

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