



Technical Data Sheet

Scotch® High Tack Light Duty Packaging Tape 640+

Product Description

Scotch® High Tack Light Duty Packaging Tape 640+ is a clear film tape specifically designed to provide a unique combination of high tack and excellent clean-release properties for garment taping. It also can be used for sealing, tabbing, splicing, and various inner-pack applications. This product has a conformable backing and a consistent pressure sensitive acrylic adhesive system.

Product Features

- Adheres instantly to a variety of surfaces
- Removes cleanly from synthetic and natural fiber garments treated with a variety of finishing and treatments. High clarity, non-staining or yellowing.
- Roll to roll consistency increases productivity for improved unit costs.

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		Clear
Adhesive Type		Pressure sensitive acrylic
Backing		Paklon™ UPVC
Backing Thickness	ASTM D3652	0.038 mm (1.5 mil)
Total Tape Thickness	ASTM D3652	0.058 mm (2.3 mil)

Typical Performance Characteristics

Attribute Name	Test Method	Temperature	Test Condition	Value
180° Peel Adhesion	ASTM D3330	22 °C (72 °F)		5.7 N/cm (50 oz/in) ¹
Elongation at Break	ASTM D3759			50 %
Tensile Strength	ASTM D3759		Machine Direction	56 N/cm (32 lb/in)

¹ 12 in/min (300 mm/min)

Handling/Application Information

Application Techniques

An extensive line of application equipment including hand held manual dispensers, semi-automatic and fully automatic equipment is available. Application of Scotch® High Tack Light Duty Packaging Tape 640+ is most easily accomplished at room temperature. At colder temperatures, approaching 32°F (0°C), the adhesive becomes more firm. Once applied, Scotch® High Tack Light Duty Packaging Tape 640+ performs well throughout the normal temperature ranges typically encountered by packaged products in shipping and storage requirements.

Storage and Shelf Life

Store under normal conditions of 4° to 27°C (40° to 80°F) and 40 to 50% 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
Core Size (ID)	76.2 mm (3 in)
Standard Roll Length	66 m (72 yd)
Standard Width	12.7, 19, 25.4, 50.8 mm (1/2, 3/4, 1, 2 in)

Information

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

Disclaimer: 3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and limitations, and the user must take any action required under any recall, field action or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, or death. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit www.3M.com.

ISO Statement

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

3M™ Industrial Specialties Division
3M Center, St. Paul, MN 55144-1000
www.3M.com

Scotch is a registered trademark of 3M.
Paklon is a trademark of 3M.
©3M 2024 (1/24)