



Technical Data Sheet

3M™ High Temperature Nylon Tape 855



[Product Details](#)



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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) ¹ |
| Elongation at Break | ASTM D3759 | | 460 % |
| Tensile Strength | ASTM D3759 | | 56 N/cm (512 oz/in) |

¹ 12 in/min (300 mm/min)

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

¹ 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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