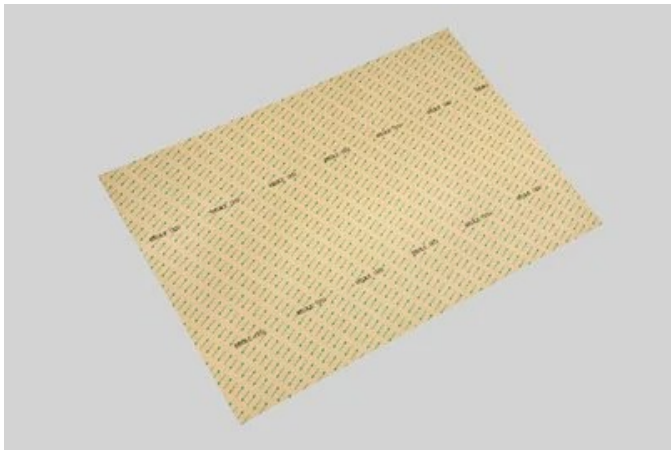




3M™ Adhesive Transfer Tape 8132LE

Last Revision Date: May, 2022

Product Description

Finite Element Analysis (FEA) data is available for this product at: [3m.com/FEA](https://www.3m.com/FEA)

3M™ Adhesive Transfer Tapes with 3M™ Low Surface Energy Acrylic Adhesive 300LSE provides high bond strength to most surfaces, including many low surface energy plastics such as polypropylene and powder coated paints. The acrylic adhesive also provides excellent adhesion to surfaces contaminated lightly with oil typically used with machine parts.

Product Features

- 3M™ Adhesive 300LSE is a hi-strength acrylic adhesive that provides a very high bond strength to most surfaces.
- Excellent bond to low surface energy plastics such as polypropylene and powder coatings.
- Excellent adhesion to lightly oiled surfaces typical of machine parts.
- Thickness range of 2.3 and 3.6 mils for use on smooth, or rough surfaces.
- Extremely smooth adhesive for excellent graphics appearance.
- Polycoated kraft liner for die-cutting end tabs and waste removed nameplates on a common carrier.
- 3M™ Adhesive Transfer Tape 8132LE is double lined for selective die-cutting.

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

Property	Values	Additional Information
Adhesive Type	3M High Strength Acrylic Adhesive 300LSE	
Liner	PCK PCK	
Primary Liner Type	83# Polycoated Kraft	View
Notes: Inner liner is primary (stays with die-cut part); Outer liner is secondary (removed first)		
Secondary Liner Type	58# Polycoated Kraft	View
Notes: Inner liner is primary (stays with die-cut part); Outer liner is secondary (removed first)		
Liner Thickness	0.102 mm	

Primary Liner Thickness	0.102 mm	
Secondary Liner Thickness	0.157 mm	
Total Tape Thickness	2.3 mil	View 
Test Method: ASTM D3652		
Total Tape Thickness	0.058 mm	View 
Test Method: ASTM D3652		
Liner Print	300LSE	
Liner Thickness	4 mil	
Primary Liner Thickness	4 mil	
Secondary Liner Thickness	6.2 mil	

Typical Performance Characteristics

Property	Values	Additional Information
90° Peel Adhesion	7.8 N/cm	View 
Test Method: ASTM D3330		
Dwell/Cure Time: 15.0		
Dwell Time Units: min		
Temp C: 23C		
Temp F: 72F		
Environmental Condition: 50%RH		
Substrate: Stainless Steel		
Backing: 2 mil Aluminum Foil		
90° Peel Adhesion	71 oz/in	View 
Test Method: ASTM D3330		
Dwell/Cure Time: 15.0		
Dwell Time Units: min		
Temp C: 23C		
Temp F: 72F		
Environmental Condition: 50%RH		
Substrate: Stainless Steel		
Backing: 2 mil Aluminum Foil		
Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion		

7.7 N/cm	View	^
Test Method: ASTM D3330 Dwell/Cure Time: 15.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: ABS Backing: 2 mil Aluminum Foil Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	70 oz/in	View ^
Test Method: ASTM D3330 Dwell/Cure Time: 15.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: ABS Backing: 2 mil Aluminum Foil Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	7.5 N/cm	View ^
Test Method: ASTM D3330 Dwell/Cure Time: 15.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Backing: 2 mil Aluminum Foil Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	69 oz/in	View ^
Test Method: ASTM D3330 Dwell/Cure Time: 15.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Backing: 2 mil Aluminum Foil Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	8.2 N/cm	View ^
Test Method: ASTM D3330 Backing: 2 mil Aluminum Foil Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	75 oz/in	View ^
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH		

Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	8.6 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: ABS Backing: 2 mil Aluminum Foil Notes: 12 in/min (300 mm/min)		

90° Peel Adhesion	79 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: ABS Backing: 2 mil Aluminum Foil Notes: 12 in/min (300 mm/min)		

90° Peel Adhesion	8.1 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Backing: 2 mil Aluminum Foil Notes: 12 in/min (300 mm/min)		

90° Peel Adhesion	74 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Backing: 2 mil Aluminum Foil Notes: 12 in/min (300 mm/min)		

Short Term Temperature Resistance	300 °F	

Short Term Temperature Resistance	149 °C	
-----------------------------------	--------	--

Long Term Temperature Resistance	93 °C	

alkalis.

Temperature Resistance: 3M™ Adhesive 300LSE is usable for short periods (minutes, hours) at temperatures up to 300°F (148°C) and for intermittent longer periods of time (days, weeks) up to 200°F (93°C).

Lower Service Temperature: -40°F (-40°C).

Processing

Slitting and die-cutting: This adhesive is very aggressive and may be difficult to convert depending on your application requirements. Chilling the adhesive between 35°F and 50°F will improve the processability. In addition, dies can be lubricated with evaporative stamping oil. You may also refer to our Technical Bulletin on 3M™ Adhesive 300LSE converting. (70-0707-6205-2)

Roll Laminating: A combination of metal and rubber rollers with moderate pressure is recommended. Note: Please refer to the Technical Bulletin on slitting. (70-0709-3905-6)

Storage and Shelf Life

Store at room temperature conditions of 70°F (21°C) and 50% relative humidity.

If stored properly, product retains its performance and properties for 24 months from date of manufacture.

Recognition/Certification

TSCA: These products are defined as articles under the Toxic Substances Control Act and therefore, are exempt from inventory listing requirements.

MSDS: These products are not subject to the MSDS requirements of the Occupational Safety and Health Administration’s Hazard Communication Standard, 29 C.F.R. 1910.1200(b)(6)(v). When used under reasonable conditions or in accordance with the 3M directions for use, the products should not present a health and safety hazard. However, use or processing of the products in a manner not in accordance with the directions for use may affect their performance and present potential health and safety hazards.

Note: One of 3M’s core values is to respect our social and physical environment. 3M is committed to comply with ever-changing, global, regulatory and consumer environmental, health, and safety (EHS) requirements. As a service to our customers, 3M is providing information on the regulatory status of many 3M products. Further regulation information including that for OSHA, USCPSI, FDA, California Proposition 65, READY and RoHS, can be found at 3M.com/regs.

Bottom Matter

3M
Industrial Adhesives and Tapes Division
Converter Markets
3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-223-7427 • 651-778-4244 (fax)
www.3M.com

Trademarks

3M is a trademark of 3M Company.

Automotive Disclaimer

Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, including, but not limited to, automotive electric powertrain battery or high voltage applications. This product does not fully adhere to typical automotive design or quality system requirements, such as IATF 16949 or VDA 6.3. This product may not be manufactured in an IATF certified facility and may not meet a Ppk of 1.33 for all properties. The product may not undergo an automotive production part approval process (PPAP). Customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer’s automotive application and for conducting incoming inspections before use of the product. Failure to do so may result in injury, death, and/or harm to property. No written or verbal statement, report, data or recommendation by 3M related to automotive use of the product shall have any force or effect unless in an agreement signed by the Technical Director of 3M’s Automotive Division. Customer assumes all responsibility and risk if customer chooses to use this product in an automotive electric powertrain battery or high voltage application, and 3M will not be liable for any loss or damage arising from or related to the 3M product or customer’s use of the product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity or recall costs), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability. In no event shall 3M be liable for any damages in excess of the purchase price paid for the product.

NOTWITHSTANDING ANY OTHER STATEMENT TO THE CONTRARY, 3M MAKES NO REPRESENTATIONS, WARRANTIES OR CONDITIONS WHATSOEVER, EXPRESS OR IMPLIED, REGARDING THE PRODUCT IF USED IN AN AUTOMOTIVE ELECTRIC POWERTRAIN BATTERY OR HIGH VOLTAGE APPLICATION, INCLUDING, BUT NOT LIMITED TO, ANY WARRANTY ON PERFORMANCE, LONGEVITY, SUITABILITY, COMPATIBILITY, OR INTEROPERABILITY, OR 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.

Handling/Application Information

Application Examples

9672LE	3M High Strength	83#	Polycoated Kraft	0.157 mm	0.132 mm	149 °C	200 °F	N/A	N/A	N/A	N/A	
	Acrylic Adhesive											
	300LSE											
9453LE	3M High Strength	58#	Polycoated Kraft	0.107 mm	0.091 mm	149 °C	200 °F	N/A	N/A	N/A	N/A	
	Acrylic Adhesive											
	300LSE											
8132LE	3M High Strength	PCK	0.102 mm	0.058 mm	149 °C	200 °F	0.157 mm	83#	58#	Polycoated Kraft	Polycoated Kraft	0.102 mm
	Acrylic Adhesive											
	300LSE											
9472LE	3M High Strength	58#	Polycoated Kraft	0.107 mm	0.132 mm	149 °C	200 °F	N/A	N/A	N/A	N/A	
	Acrylic Adhesive											
	300LSE											
8153LE	3M High Strength	PCK	0.107 mm	0.091 mm	149 °C	200 °F	0.157 mm	83#	58#	Polycoated Kraft	Polycoated Kraft	0.107 mm
	Acrylic Adhesive											
	300LSE											

ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

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.