



# High Temperature Nylon Tape

## 855

Technical Data

March, 2016

**Product Description** 3M™ High Temperature Nylon Tape 855 is a strong nylon backing and a high temperature rubber adhesive. Used in many composite bagging operations or assist in removing flashing after composite bonding, where the use of a non-silicone tape is preferred.

Product Construction	Backing	Adhesive	Color	Standard Roll Length
	Nylon	Rubber	Cream	72 yds. (65.8 m)

**Typical Physical Properties** Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

		ASTM Test Method
Adhesion to Steel:	46 oz./in. width (50 N/100 mm)	D-3330
Tensile Strength at Break:	35 lbs./in. width (605 N/100 mm)	D-3759
Elongation at Break:	640%	D-3759
Backing Thickness:	2.1 mils (0.052 mm)	D-3652
Total Thickness:	3.6 mils (0.091 mm)	D-3652
Temperature Use Range:	60 - 400°F (140 - 204°C) withstands autoclave cycles up to 400°F (204°C)	

### 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.
- Non-silicone adhesive allows use on many parts where subsequent painting or bonding is necessary. Removes cleanly after short bake cycles at 400°F (204°C).
- High temperature – clean removal after exposure to 350°F (177°C) for several hours. In shorter cycles, the tape can be expected to provide satisfactory performance in 400°F (204°C) bake cycles.
- Nylon backing for toughness, high elongation, quick removal, and ease of application.

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<b>Application Ideas</b>	<ul style="list-style-type: none"><li>• Designed to provide clean removal during masking operations in applications involving high temperature and pressure.</li><li>• Advanced composite and metal bond masking as non-silicone adhesive allows use on many parts where subsequent painting or bonding is necessary and removes cleanly after 400°F (204°C) autoclave exposure.</li></ul>
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<b>Storage</b>	Store under normal conditions of 60° to 80°F (16° to 27°C) and 40 to 60% relative humidity in the original packaging material.
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<b>Shelf Life</b>	To obtain best performance, use this product within 18 months from date of manufacture.
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<b>Technical Information</b>	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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