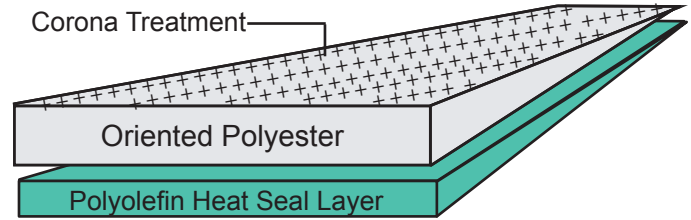


**Scotchpak™**  
Heat Sealable,  
Polyester Based Film



## Product Features

Scotchpak™ is a trademark of 3M

**DESCRIPTION:** Scotchpak™ heat sealable polyester films are adhesive-free, translucent films that provide strong heat seals to a variety of clean metal surfaces and metal vapor coatings.

### FEATURES:

- Translucent
- Controlled Caliper
- Matte Finish
- Adhesive-Free
- Strong Seal to Metal
- Printable

### APPLICATIONS:

- Collate Nails, Staples, and Other Metal Fasteners
- Strong Thermal Lamination Bonds to Metal Foils and Metal Vapor Coated Surfaces

Property	Value		Unit	Test Method
<b>Physical Properties</b>				
Thickness	250	450	gauge	
Product Code	MA 309	MA 233		
Yield	10,886	6,869	in <sup>2</sup> /lb	
Break Strength	15		lb/in	ASTM D 1992
<b>Thermal Properties</b>				
Heat Seal Temperature	300-400		°F	0.2-2.0 secs x 20-60 PSI
Heat Seal Strength	14	22	lb/in	face/face x 355 °F x 1 sec x 40 PSI
Heat Seal to Steel	12	15	lb/in	film/steel x 355 °F x 10 sec x 40 PSI

\* All values +/- 10%

**Proper Film Use:** To achieve a good bond at reasonable application rates, it is **necessary to heat the metal** so that the film-to-metal interface temperature is maintained for a sufficient amount of time to effect a bond. In a typical application, the metal surface is heated to a range of 300-400 °F (149-204°C) via IR radiation (quartz lamps, resistance heaters, etc...), gas flame, induction or hot air methods. This is followed immediately by bonding of the Scotchpak™ film under a rubber covered pressure roller with nip pressure of 20-60 PSI. The roller should be constructed of a high temperature resistant rubber (e.g. silicone) with hardness of 40-60 durometer. **The finished work should be cooled slowly to below 140°F (60°C) prior to handling to allow a good bond to develop.**

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