

Scotch™ Brand No. 219 Fine Line Tape

February 1995

DESCRIPTION: A high temperature film backed tape with low profile and high adhesion to achieve excellent paint lines and for masking and holding applications.

CONSTRUCTION:

Backing:	A green colored matte finish film
Adhesive:	A rubber adhesive designed with properties suitable for high temperature masking
Standard Roll Length:	60 yards (55 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:	42 oz./in. width (46 N/100 mm)	D-3330
Tensile Strength:	12 lbs./in. width (209 N/100 mm)	D-3759
Elongation at Break:	440%	D-3759
Total Tape Thickness:	5.1 mils (.13 mm)	D-3652
Temperature Use Range:	Up to 300°F (149°C) Clean and easy removal	

GENERAL INFORMATION:

1. No. 219 is designed to be used where superior paint lines are required in high temperature bake cycles.
2. No. 219 may be used where exposure up to 300°F (149°C) for 40 minutes is needed.
3. The special processed film backing stretches easily for smooth curves yet can be easily torn by hand with a quick tearing action.
4. The special processed No. 219 film backing will allow taping over fresh paint jobs sooner with less chance of imprint damage.
5. No. 219 will give excellent color line separation due to its thinness.
6. No. 219 should not be subjected to outdoor exposure or prolonged periods of sunlight.

SHELF LIFE:

To obtain best performance, use this product within one year from date of manufacture and store under normal conditions of 70°F (21°C) and 50% R.H. in the original carton.

POSSIBLE USES:

No. 219 is specifically designed where high temperature 300°F (149°C) and Fine Line paint masking are needed.

<u>FEATURES</u>	<u>ADVANTAGES</u>	<u>BENEFITS</u>
Film backing	Conformability	Minimizes recovery and lift on curves/reduces rework
	Smoothness	Minimizes chance of imprint damage/fewer rejects
	Thinness	Minimum edge build-up/excellent paint job
	Solvent and moisture resistance	Resists bleed-through/reduces rework
	Easy hand tear	Easy to handle/labor savings
Matte finish backing	Good paint anchorage	Minimizes flaking and paint runs/reduces rework
Heat resistant rubber adhesive	Instant adhesion	Sticks easier/reduces labor involved
	Excellent holding power	Resists lifting or curling/reduces rework
	Excellent adhesive transfer resistance	Clean removal/reduces labor
Special backsize treatment	Controlled unwind	Easy to use/minimizes waste

Technical Data: All physical properties, statements, and recommendations are either based on tests we believe to be reliable or our experience, but they are not guaranteed. 3M recommends each user determine the suitability of the masking paper, film or tape for the intended use.

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