



Scotchmate™ Reclosable Fasteners

SJ3571 and SJ3572 Family

Nylon Loop and Hook

with high performance acrylic adhesive

Product Information

March, 2008

Product Description

3M™ Scotchmate™ Reclosable Fasteners offer advanced closure alternatives to zippers, screws, snaps, hooks and more. They offer greater design flexibility, faster product assembly, smoother and cleaner exterior surfaces and improved product performance in many applications. Scotchmate reclosable fasteners consist of nylon fabric with hooks or loops. They engage to form a quick fastening attachment. Simply pull the strips apart by hand to disengage.

The woven nylon hook backing has flexible, self-supporting inverted J-hooks protruding up from the backing. There are approximately 300 hooks per square inch (46 hooks/square cm). The woven nylon loop backing has thousands of soft, pliable napped loops protruding above the backing, providing for thousands of openings and closings (cycles). The hook and loop are preshrunk to ensure maximum dimensional stability and flatness.

These hook and loop fasteners are coated on the backside with a high temperature acrylic pressure sensitive adhesive designed to function over a range of temperatures and humidity. This adhesive is especially suited for attachment to bare metals and a variety of high surface energy adherends. For attachment to powder coated paints or other low surface energy materials such as polyethylene or polypropylene, the use of adhesion promoters may be necessary or you can evaluate our line of Scotchmate fasteners with rubber based adhesives such as 3M™ Scotchmate™ Reclosable Fastener SJ3518FR or SJ3532N.

The loop is available with a fabricator splice. This consists of the adhesive side of the Scotchmate reclosable fastener and the liner being spliced. This provides product and liner continuity on the roll. This product is ordered as SJ3571FS. When it is desired to have marked the splices, the loop product can be ordered as SJ3571FSR.

Scotchmate reclosable fastener SJ3571 is also available with a brown 83 pound polykraft paper liner allowing easier die-cutting. The product number with the paper liner is SJ3571P.

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

Products		3M™ Scotchmate™ Reclosable Fastener	
		SJ3571 (Loop)	SJ3571P (Loop)
		SJ3572 (Hook)	
Material of Construction		Hook	nylon 6 hook, nylon 6,6 ground
	Loop		all nylon 6,6
	Adhesive		Acrylic
Standard Colors^(a)		Black, White, Beige	
Thickness^(b) max. unmated	Hook	3/32" (2.4 mm)	
	Loop	4/32" (3.2 mm)	
Selvedge Edge In. (mm) ± 1/32" (0.8 mm)		3/32" (2.4 mm)	
		4/32" (3.2 mm) for 4" wide	
Weight^(b) oz/in² (g/cm²)	Hook	0.013 oz/in ² (0.06 g/cm ²)	
	Loop	0.014 oz/in ² (0.06 g/cm ²)	
Liner		Clear polypropylene film with white embossed 3M logo (4.0 mil)	Brown 83 pound polykraft liner with a silicone release coating. No printing.

a) Other fastener colors are available as special orders. 3M recommends the user to evaluate a color sample to see if it meets their color requirements. See your 3M authorized distributor or 3M representative for color selection guide and minimum requirements.

b) Thickness was measured using a 1/2" diameter pressure foot supporting a 34 gram weight. Actual thickness depends upon the amount of compression load on the pieces. All thickness and weight values are with the liner removed.

Storage Store in original packaging between 60° to 80°F (16° to 27°C) and 40 to 60% relative humidity.

Shelf Life To obtain best performance, use this product within two years from date of manufacture.

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Typical Closure and System Performance Characteristics

Note: The following information is not product release requirements, nor product specifications. Rather this data represent typical performance using standard test methods. This is intended for use as a guide to assist in selection of 3M™ Scotchmate™ Reclosable Fasteners for further evaluation. Customer specifications should not be based solely on the data presented in this document.

Unless stated, typical system performance characteristics were measured under controlled laboratory conditions of 72°F (22°C) and 50% relative humidity. The user should evaluate products in the actual application to ensure suitable performance for the intended use.

System Performance ^(a)		
	3M™ Scotchmate™ Reclosable Fastener SJ3571 Loop engaged to 3M™ Scotchmate™ Reclosable Fastener SJ3572 Hook	3M™ Scotchmate™ Reclosable Fastener SJ3571 Loop engaged to 3M™ Dual Lock™ Reclosable Fastener SJ3560 ^(b)
TENSILE (Rigid to Rigid Substrates)	lbs _F /sq inch (Newton/cm ²):	
Dynamic Tensile Engagement Strength	< 1.0 (0.69)	< 1.0 (0.69)
Dynamic Tensile Disengagement ^(c)	7.5 (5.2)	39.8 (27.4)
Static Tensile Holding Power	Holds 2.2#/in ² (155 grams/cm ²) for indicated time and temperature	
	100°F/100% RH	10,000 minutes
	200°F	10,000 minutes
	220°F	10,000 minutes
	250°F	1,300 minutes
SHEAR (Rigid to Rigid Substrates)	lbs _F /sq inch (Newton/cm ²):	
Dynamic Shear (1" x 1" overlap) ^(c)	23 (16)	46 (32)
Static Shear Holding Power	Holds 2.2#/in ² (155 grams/cm ²) for indicated time and temperature	
	100°F/100% RH	10,000 minutes
	158°F	10,000 minutes
	200°F	10,000 minutes
PEEL AND CLEAVAGE^(c)	Pounds/inch width (grams/cm width)	
Peel Strength ("T" Peel, Flexible to Flexible)	1.3 (223)	3.0 (528)
Peel Strength (90° Peel, Flexible to Rigid)	1.8 (313)	4.6 (821)
ENGAGED THICKNESS^(d)	Inches (mm)	
(Nominal without liner)	0.15 (3.8)	0.21 (5.2)
CLOSURE CYCLE LIFE^(e)	5,000	50

Note: Long Term Static Load: Conditions such as temperature variations, engagement area, closure pressure and vibrations or side to side movement after engagement or exposure to prolonged periods of moisture, ultraviolet or other environmental factors can affect the closure strength and long term static load performance. Fasteners may slip or creep in the direction of the static load forces when subjected to static loads at temperatures, times or weights greater than indicated. The user is responsible for designing the amount of fastening area based upon the specific conditions for the application. Four square inches of fastening area per pound of static load is suggested as a starting point for such evaluations.

- System performance tests are determined by measuring the performance of the entire mated reclosable fastener system consisting of two 1/8" thick non-anodized aluminum plates joined together with the indicated fasteners. The "T" peel test only measures the closure performance per ASTM D5170 and was not adhered to aluminum panels. The 90° peel has one of the mated fasteners attached to a 1/8" thick non-anodized aluminum plate while the mated fastener is not attached to an adherend and is disengaged at a 90° angle.
- The use of 3M™ Scotchmate™ Loop Reclosable Fasteners engaged to 3M™ Dual Lock™ Reclosable Fasteners provides increased strength over standard Scotchmate reclosable fasteners, with a limited number of reclosures compared with Scotchmate systems. Due to the very high strength of Scotchmate reclosable fasteners mated to Dual Lock reclosable fasteners, extra care should be given to ensure the maximum bond strength is obtained to the adherends being joined. Failure to obtain bond strengths sufficiently high to the adherend may cause the fastener's adhesive to release from the adherend.
- 3M™ Scotchmate™ Reclosable Fasteners SJ3571 and SJ3572 and 3M™ Dual Lock Reclosable Fastener SJ3560 are engaged with firm pressure and disengaged, peeled or cleaved at the rate of 12 inches (305 mm) per minute.
- The engaged thickness was measured using a 0.5" diameter pressure foot supporting a 34 gram weight. Engaged thickness per given fastener area will decrease when compressed or increase with no load or when the engaged fasteners are separated under a tensile load.
- Cycle Life is the number of cycles (openings and closings) that the fastener is subjected to while maintaining 50% or greater of the initial peel value.

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Additional Performance Characteristics

Note: The following information is not product release requirements, nor product specifications. Rather this data represent typical performance using standard test methods. This is intended for use as a guide to assist in selection of 3M™ Scotchmate™ Reclosable Fasteners for further evaluation. Customer specifications should not be based solely on the data presented in this document.

Solvent Resistance: The nylon components resist occasional attack by most common solvents and alkaline solutions. Acid solutions may cause deterioration of the fastener. The adhesive on 3M™ Scotchmate™ Reclosable Fasteners SJ3571 and SJ3572 is resistant to many common laboratory solvents and transportation fluids (gasoline, motor oil, etc.) when exposed for short time periods.

Plasticizer Resistance: The adhesive on Scotchmate reclosable fasteners SJ3571 and SJ3572 has good resistance to plasticizers found in many common flexible vinyls or other materials containing high levels of plasticizing materials. If greater plasticizer resistance is desired 3M™ Scotchmate™ Reclosable Fasteners SJ3522 or SJ3523 or many of our 3M™ Dual Lock™ Reclosable Fastener products can be evaluated.

Flammability Resistance: Scotchmate reclosable fasteners SJ3571 and SJ3572 meet the requirements of FMVSS-302 when attached to a thin metal panel. If you need 3M™ Scotchmate™ Reclosable Fasteners that meet other standard flammability tests (such as FAR 25.853, ASTM E-162, ASTM E-662 or BSS-7239), please refer to our publication *3M™ Scotchmate™ Reclosable Fasteners Flame Resistant Products Product Selection Guide (70-0707-3992-8)*.

Resistance to Environmental Exposure: Temperature down to -40°F (-40°C) increases the typical closure strengths. The adhesive on Scotchmate reclosable fasteners SJ3571 and SJ3572 has been formulated to withstand typical outdoor temperature, humidity and ultraviolet exposure conditions. Many of our Dual Lock reclosable fastener products also provide good to excellent performance in outdoor conditions.

Water (Humidity) Resistance: Closure strength of nylon hook and loop fasteners decreases after prolonged exposure to water due mainly to water absorption by the cut nylon ends for hook products. Closure strength is regained when dried. Improved water resistance of the closure can be obtained by using 3M™ Scotchmate™ Reclosable Fasteners polyester hook and loop SJ3576/SJ3577, SJ3586FR/SJ3587FR or our polyolefin based Dual Lock reclosable fasteners. Once bonded the adhesive has high resistance to moisture under typical use conditions.

Volatile Outgassing: Volatile outgassing, as per ASTM E595, is one important test in determining the suitability of materials for spacecraft. Scotchmate reclosable fastener SJ3571 and SJ3572 have not been tested for outgassing. Products tested at the Goddard Space Flight Center can be found at the following web site: <http://outgassing.nasa.gov/>

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**Additional
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Characteristics**
(continued)

Sterilization/Autoclaving: 3M™ Scotchmate™ Reclosable Fasteners SJ3571 and SJ3572 have not been tested for appearance or performance after gas or steam sterilization, or autoclaving.

Washing and Dry Cleaning: Washing or dry cleaning of these products is not recommended due to the potential for adhesive softening, that could transfer adhesive residues to other materials, or reduce long term performance.

Fungus Resistance:

Mil standard 810F, Method 508.5: Three samples from one lot of Scotchmate reclosable fasteners SJ3571 and SJ3572 were exposed to five fungal organisms (*Aspergillus versicolor* – ATCC 11730, *A. flavus* – ATCC 9643, *A. niger* – ATCC 9642, *Penicillium funiculosum* – ATCC 11797, and *Chaetomium globosum* – ATCC 6205) and gave an average fungal growth rating after 44 days of 2.3 for Scotchmate reclosable fastener SJ3571 and 1.7 for Scotchmate reclosable fastener SJ3572.

ASTM G21-96 “Fungal Challenge Test”: Three samples from one lot of Scotchmate reclosable fasteners SJ3571 and SJ3572 were exposed to five fungal organisms (*Aspergillus niger* – ATCC 9642, *Penicillium funiculosum* – ATCC 11797, *Chaetomium globosum* – ATCC 6205, *Trichoderma virens* ATCC 9645 and *Auerobasidium pullulans* ATCC 15233). Scotchmate reclosable fastener SJ3571 had an average fungal growth after 7, 14, 21 and 28 days of 2.0, 2.7, 2.7 and 2.7 respectively, whereas Scotchmate reclosable fastener SJ3572 gave an average rating of 2.0, 2.3, 2.3 and 2.3 for the same time periods.

Static Discharge: Scotchmate reclosable fasteners SJ3571 and SJ3572 have not been tested for static charge released during liner removal, closure opening nor adhesive removal from adherends after attachment of the fastener. If your application requires use of these fasteners in areas where static discharge is of a concern, the fasteners should be tested under expected use conditions.

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3M™ Scotchmate™ Reclosable Fasteners^{(a),(b)}
Product Number and Roll Lengths – Yards (Meters)

			SJ3571			SJ3572				SJ3571P	SJ3571FSR	SJ3571FS
Standard Sizes Available ^(c)			(Loop)			(Hook)				(Loop)	(Loop)	(Loop)
Widths in. ± 1/16" (mm) ± 1.6	Selvage ^(d)	Extended Liner ^(d)	25 (22.8)	50 (45.7)	100 (91.4)	25 (22.8)	30 (27.4)	50 (45.7)	100 (91.4)	50 (45.7)	100 (91.4)	50 (45.7)
1/2" (12.7 mm)	One Edge	One Edge		BK W B				BK W B				
5/8" (15.9 mm)	One Edge	One Edge		BK W				BK W B				
3/4" (19 mm)	One Edge	One Edge		BK W B				BK W B				
1" (25.4 mm)	One Edge	One Edge	BK	BK W B	BK, W B	BK		BK W B	BK W B		BK	BK
1-1/2" (38.1 mm)	Two Edges	Two Edges		BK, W			BK	BK W				
2" (50.8 mm)	Two Edges	Two Edges		BK W B		BK W B		BK W B	BK W B	W		
3" (76.2 mm)	One Edge	One Edge		BK				BK				
4" (101.6)	Two Edges	Two Edges		BK W				BK W				

Fabricated Forms^(e)

See Below for Standard Pieces

Cut Pieces

- a) 3M™ Scotchmate™ Reclosable Fasteners SJ3571P is the same as Scotchmate reclosable fasteners SJ3571, but with a paper instead of film liner. Scotchmate reclosable fastener SJ3571FSR is SJ3571 with a marked product splice making splice identification easier. Scotchmate reclosable fastener SJ3571FS is identical to SJ3571 except the splice is not marked.
- b) Standard colors are white (W), black (BK) and beige (B). Other colors are available as special orders. 3M recommends the user to evaluate a color sample to determine if it meets their color requirements. See your local 3M authorized distributor or 3M representative for a color selection guide, minimum order quantities and lead times.
- c) 3M™ Scotchmate™ Reclosable Fasteners listed above come standard on a 3" inside diameter fiber core in widths up to 4". The diameter of the side shield is 17.5 inches (44.5 cm) and the width of the roll with the side shield is the product width plus 1/4". Contact your authorized 3M distributor or 3M representative for details on supplying widths, colors or special sizes not listed above.
- d) Other configurations may be possible as a special order, or via a 3M authorized converter.
- e) 3M™ Reclosable Fasteners can be fabricated in many custom shapes and sizes to fit your product design and manufacturing process. One standard shape and size is listed below. For others not listed please contact your local 3M authorized converter or 3M representative for additional options, configurations and ordering information.

Product Number	Fabricated Pieces
SJ3572	1-7/8" black hook circle, 1000 per roll.

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Attachment Techniques

The following information is intended to assist the designer considering the use of adhesively coated 3M™ Scotchmate™ Reclosable Fasteners. System product performance depends upon a number of factors, including the fastener (material, adhesive and area), application method, adherend surface characteristics (material, texture and cleanliness), environmental conditions (moisture, ultraviolet and temperature exposure) plus the time it is expected to support a given load. Because many of these factors are uniquely within the user's knowledge and control, it is required that the user evaluate 3M products to determine whether they are fit for a particular purpose and suitable for the user's adherends, method of application and desired end use.

Design Considerations: As a general rule, four square inches of fastener adhesive area per pound (57.3 square centimeters per kilogram) of static load to be supported is suggested as a starting point for evaluation. More or less area may be needed depending on specific conditions or end use applications.

Rounding the corners, slightly recessing the product into the adherend or providing raised edges around the reclosable fastener can reduce the possibility of edge lifting and improve the overall appearance of the fastener on the finished product. Mechanically securing the corners of the fastener with rivets, staples, screws, etc. may also reduce the possibility of edge lifting, but may reduce the closure performance.

The two most common techniques for attaching these 3M™ Scotchmate™ Reclosable Fasteners to various surfaces are summarized below.

1) Pressure Sensitive Adhesive attachment: The use of pressure sensitive adhesives eliminates or reduces the need for sewing, solvent activation, dielectric or ultrasonic bonding or bulk adhesive bonding. This can result in simplicity, improved safety and lower installation costs. Pressure sensitive adhesive products can be applied manually or automatically using a variety of equipment choices. Contact your 3M sales representative to discuss automated equipment options.

Adherend Surface Preparation: Highly textured adherend surfaces may reduce the ultimate adhesion levels and care should be given to minimize the surface texture or roughness. Adhesive backed Scotchmate reclosable fasteners should be applied to surfaces that are clean, dry and free of oil, grease, dust, mold release agents or surface contaminants that could reduce the adhesion. It is recommended to remove any surface contaminants that may reduce adhesion by using a method suited for the type and quantity of surface contaminants present.

Note: It is important for the customer to follow all manufacturer's precautions and directions for use as well as any specific government regulations or customer and supplier requirements for the method(s) used to remove any contamination on the surface of the adherend or preparing the surface for attaching the fastener(s).

In exceptional cases, especially when removing silicone mold release agents or on rough, porous surfaces, it may be necessary to lightly abrade the surface, use an adhesion promoter, or surface sealer to optimize the adhesive bond to the adherend. The selection of abrasion, priming or sealing methods will depend upon the adherends and the environmental conditions the product will be exposed to during use.

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Attachment Techniques (continued)

Attachment Procedure: To obtain an optimum bond to any surface, both the fasteners and the target surfaces should have equilibrated for a minimum of 1 hour at temperatures between 68°F (20°C) to 100°F (38°C) before application. The liner protecting the adhesive is removed and preferably without touching the adhesive, the fastener is applied to the adherend to obtain initial contact between the adhesive and adherend. Exposure of the adhesive to ambient conditions without the protective liner, before applying to the surface, should be minimized as initial adhesive tack may decrease. Flexible adherends should be lying on a hard, flat surface so as to permit uniform adhesive contact with the surface. Use of a rubber hand roller, press platen or similar device is recommended to ensure full adhesive contact with the adherend surface. Approximately 4.5 pounds of force per square inch, (310 grams per square centimeter) is recommended to increase adhesive contact, improving bond strength. For all adhesive applications, it is important to ensure that the edges are rolled down to reduce the chance of edge lifting.

Dwell Time before Handling or Applying a Load: Parts with properly chosen and applied pressure sensitive adhesive reclosable fasteners can be handled immediately. As the adhesive further wets-out the adherend surface, adhesive bond strength increases after application with time, pressure and/or temperature. Once attached to the adherend, a 1-hour minimum dwell time is recommended before applying a load or disengaging mated Scotchmate reclosable fastener pieces. This dwell time is important for achieving a firm adhesive bond before applying a load or using. The adhesive on 3M™ Scotchmate™ Reclosable Fasteners SJ3571 and SJ3572 family of products achieves approximately 50% of the ultimate bond strength within 60 minutes, 90% after 1 day and the ultimate bond strength of properly applied fasteners is obtained within 72 hours at 72°F (22°C) and 50% relative humidity. Primers or adhesion promoters may reduce the time required to achieve the ultimate bond strength.

2) Mechanical Attachment: Mechanical attachment of Scotchmate reclosable fasteners SJ3571 and SJ3572 family of products may also be secured using staples, screws, rivets and similar methods for difficult to adhere to surfaces such as textured plastics and wood. This may reduce the possibility of edge lifting. The head of the mechanical fastener should be flat and large enough to resist pull through when the fastener is disengaged. The head of the fastener should also be recessed as much as possible below the surface of the hook or loop to prevent interference with (dis)engagement properties.

The use of resin coated chisel divergent staples appear to provide excellent attachment to thick sections of soft and hardwood surfaces.

Application Ideas

Scotchmate reclosable fasteners SJ3571 and SJ3572 family of products can provide a firm adhesive bond to a wide variety of surfaces, including, but not limited to those listed below. Because product performance will depend on actual conditions within any specific application, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular material purpose and suitable for the user's method of application.

Plastics

Glass	Sealed Wood	Acrylic	ABS
CARC Paint	Bare and painted Metal	Polycarbonate	Polystyrene
			Rigid Vinyl

Scotchmate reclosable fasteners SJ3571 and SJ3572 family of products are not recommended for attaching to low surface energy materials without proper surface modification.

Scotchmate reclosable fasteners SJ3571 and SJ3572 family of products has shown to be useful for:

Anti-scratch surface	Attaching accessories and equipment
Medical Braces	Vibration and sound dampening control
Attaching Exhibit and Display Graphics	

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Certification/ Recognition

MSDS: 3M has not prepared a MSDS for these products which 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, these 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.

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

Mil Spec. MIL-F-21840: 3M™ Scotchmate™ Reclosable Fastener SJ3572 meets the physical requirements of Mil spec. MIL-F-21840, Type II, Class 1. 3M™ Scotchmate™ Reclosable Fastener SJ3571 meets the physical requirements of MIL-F-21840, Class 1. MIL-F-21840, Type II, Class 5 requirements are met by engaging Scotchmate reclosable fastener SJ3571, or any of our nylon Scotchmate loop products, to any polyester Scotchmate hook product such as SJ3476, SJ3486FR, SJ3576 or SJ3586FR.

GM 2743M Type II: Scotchmate reclosable fasteners SJ3571 and SJ3572 meet the requirements of GM 2743 Type II.

GM 3618M Scotchmate reclosable fasteners SJ3571 and SJ3572 meet the requirements of GM 3618.

FMVSS-302: Scotchmate reclosable fasteners SJ3571 and SJ3572 pass FMVSS-302 when tested attached to a thin metal panel.

Product Use

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

Warranty and Limited Remedy

Unless stated otherwise in 3M's product literature, packaging inserts or product packaging for individual products, 3M warrants that each 3M product meets the applicable specifications at the time 3M ships the product. Individual products may have additional or different warranties as stated on product literature, package inserts or product packages. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If the 3M product is defective within the warranty period, your exclusive remedy and 3M's and seller's sole obligation will be, at 3M's option, to replace the product or refund the purchase price.

Limitation of Liability

Except where prohibited by law, 3M and seller will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

ISO 9001:2000 - ISO/TS 16949:2002

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 and ISO/TS 16949:2002 standards.



Industrial Adhesives and Tapes Division

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