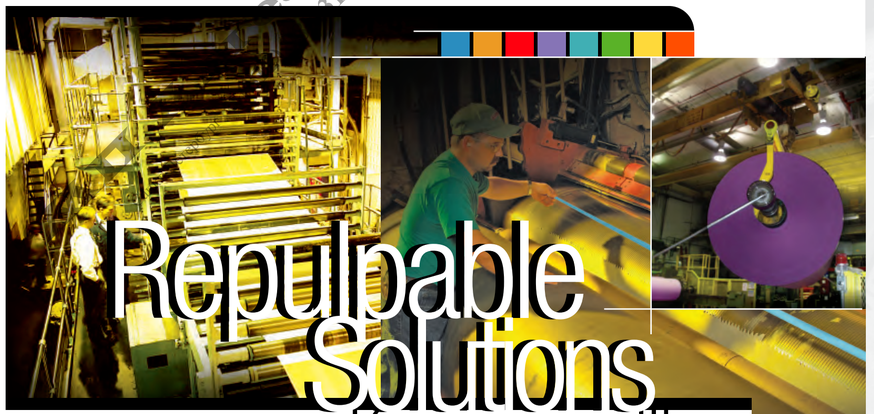

Repulpable Solutions

Keep you rolling

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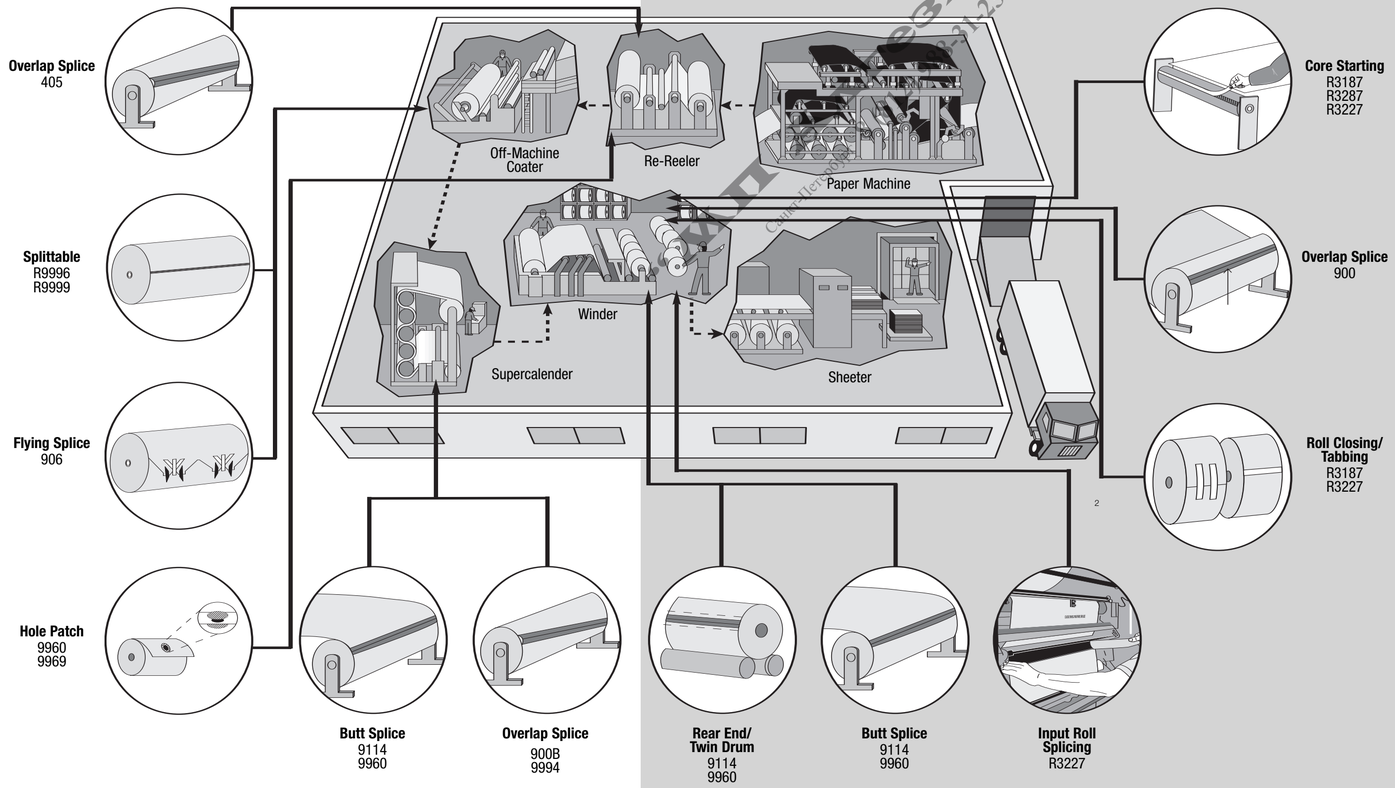
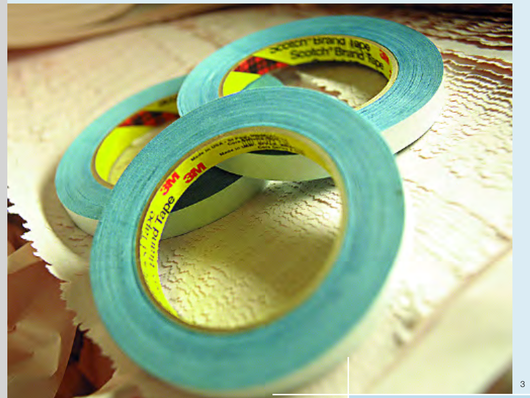
3M Tapes Fit Your Web Processing Applications



3M™ Repulpable Tapes for the Pulp and Paper Industry

Your First Choice in 3M™ Repulpable Tapes

Application	Re-Reelers	Off-Machine Coaters	Calenders	Winders	Sheeters
Core Starting & Roll Closing	R3187	R3187	R3187	R3187, R3287	
Overlap Splicing	900		900B	900	R3227
Butt Splicing	9114, 9960		9114	9114, 9960	
Splittable Flying Splice		R9996, R9999	9994		
Flying Splice		906			R3227
Hole Patching	9969, 9960			9969, 9960	



pg.5

Core Starting and Rolling

R3187

3M™ Super Strength Repulpable Single Coated Tape

3M tape R3187 has excellent backing strength coupled with a high tack adhesive that will not slip or pop off in core starting, roll closing and butt splicing applications.

- Colors: Blue, White, Kraft, Black
- Tensile Strength: 34 lbs./in. (595N/100mm)
- Elongation at Break:
  Machine direction - 6.0% (min.)
  Cross direction - 3.0% (min.)
- Thickness: 7.5 mils (0.19mm)
- Heat Resistance: Excellent to 350˚F (180˚C) web temperature on most paper grades up to one minute
- Backing Strength: 70 lbs.
- Bonding Strength: Delaminates most papers

R3287

3M™ Heavy Duty Repulpable Double Coated Tape

3M tape R3287 has a high tack adhesive for adhering a very wide range of paper types and fluff pulp to all types of paper cores.

- Color: White
- Thickness: 5.5 mils (0.14mm) without liner
- Backing Strength: Stronger than most double coated repulpable tapes
- Bonding Strength: Excellent on a wide range of paper grades

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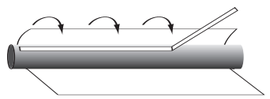
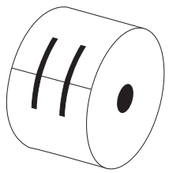
Single Coated Core Starting

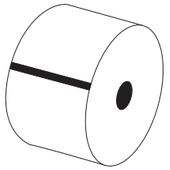
Double Coated Core Starting

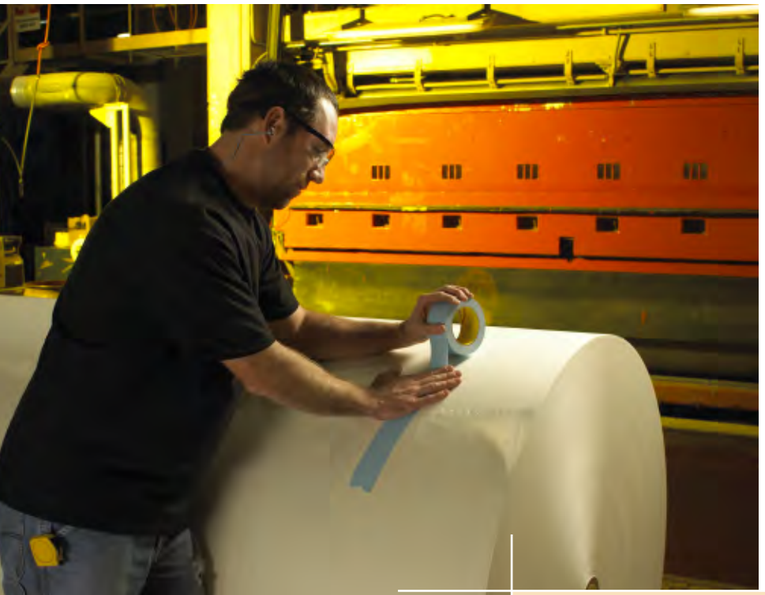


Single Coated Roll Closing



Double Coated Roll Closing





4

3M™ Repulpable Single Coated Tapes

Product	Comments	Color	FDA Status
R3187	Multiple applications, strong repulpable backing.	Blue, White, Kraft, Black	FDA Compliant

Alternative

R3127	Multiple applications, strong repulpable backing.	White, Kraft, Red	FDA Compliant

3M™ Repulpable Double Coated Tapes

Product	Comments	Color	FDA Status
R3287	Heavy tissue, very high tack, first choice for core starting (also for use in S-170/S-171).	White	FDA Compliant
R3227	Multiple applications, excellent all around performance (also for use in RTA-500).	Blue, White	FDA Compliant

5

Scotch® Set Change Dispensing System S-170/S-171

The system allows for double duty — removing tape liner while dispensing the necessary length of tape for simplified core set changes. Available in vertical or table top mounting options these systems will allow faster set changes, minimize tape waste, reduce operator risk, and improve winder productivity. Used exclusively with 3M tape R3287.

6

3M™ Auto Core Taper

The 3M™ Auto Core Taper leaves little to chance. This innovative unit automatically dispenses and firmly applies the required length of 3M repulpable tapes to paper cores. This state of the art equipment will improve winder efficiency, maximize core starting reliability and reduce potential for worker injury by keeping operators safely out of winding area.

7

3M™ Repulpable Tape Applicator RTA-500

This hand held dispenser allows for easy dispensing and liner removal of 3M™ Repulpable Double Coated Tapes for web operations such as core starting and roll closing. Dispense tape and dispose of liner with one pull of the trigger.

Overlap Splicing

900/900B

3M™ Repulpable Double Coated Splicing Tape for Coated Papers

3M tape 900/900B is ideal for permanent overlap splicing on coated and uncoated papers. It combines high initial adhesion with very good heat resistance. We suggest using the ultra-thin 3M™ Repulpable Single Coated Tape 9960 when taping down the leading or trailing end of paper on an overlap splice.

- Color: Blue
- Thickness: 2.5 mils (0.06mm) without liner
- Heat Resistance: 400˚F (204˚C)
- Bonding Strength: High ultimate adhesion that delaminates most papers, excellent for LWC formulations

405

3M™ Repulpable Double Coated Splicing Tape for Uncoated Papers

3M Repulpable tape 405 has a firm adhesive that is primarily utilized for overlap splicing of uncoated paper grades. The firm adhesive resists oozing and/or bleed through, yet offers high shear strength.

- Color: Light Green
- Thickness: 3.0 mils (0.75mm) without liner
- Heat Resistance: Up to 400˚F (204˚C) web temperature
- Bonding Strength: Excellent affinity to cellulose fibers and starch coatings

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3M™ Repulpable Double Coated Tapes

Product	Comments	Color	FDA Status
900	Suggested for coated and uncoated LWC papers.	Blue	FDA Compliant
900B	Suggested for coated and uncoated LWC supercalendared papers.	Blue	FDA Compliant
405	Excellent for raw and starch-treated papers.	Lt. Green	-

3M™ Repulpable Single Coated Tapes

Product	Comments	Color	FDA Status
9960	Ultra-thin and printable, excellent on most grades of coated and uncoated papers.	Blue	FDA Compliant
9969	Ultra-thin backing suggested for uncoated, newsprint and most coated papers.	White, Blue	FDA Compliant
9103	Printable, coatable backing.	Blue	FDA Compliant
901	Excellent for raw and starch-treated papers.	Lt. Green	-
910	Suggested for LWC papers, linerless and non-printable.	Blue	FDA Compliant

Simple
Overlap Splice

Leading Edge
Taped Down

Both Edges
Taped Down

Butt Splicing

9114

3M™ Repulpable Butt Splicing Tape

3M tape 9114 is an easy to apply, repositionable, single coated tape that provides a thin, strong bond.

- Color: Blue
- Thickness: 4.5 mils (0.11mm) without liner and removable tape strip
- Heat Resistance: Excellent to 400˚F (204˚C) web temperature
- Bonding Strength: Delaminates most papers

9969

3M™ Repulpable Single Coated Printable Splicing Tape

3M tape 9969 is an ultra-thin, printable, single coated repulpable splicing tape that can be used on a variety of lightweight coated and uncoated grades of paper.

- Color: Blue, White
- Thickness: 2.2 mils (0.06mm) without liner
- Heat Resistance: Excellent to 350˚F (180˚C) web temperature on most paper grades
- Bonding Strength: Delaminates most papers

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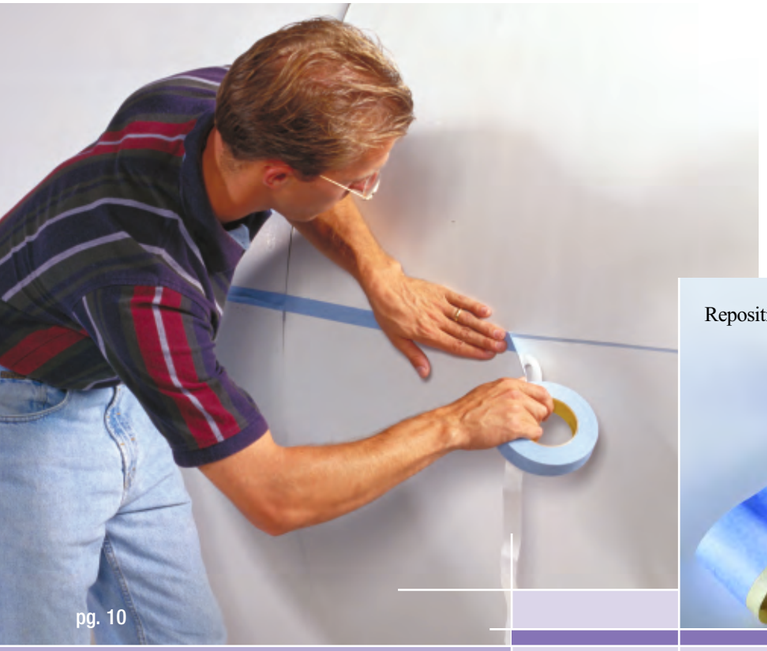

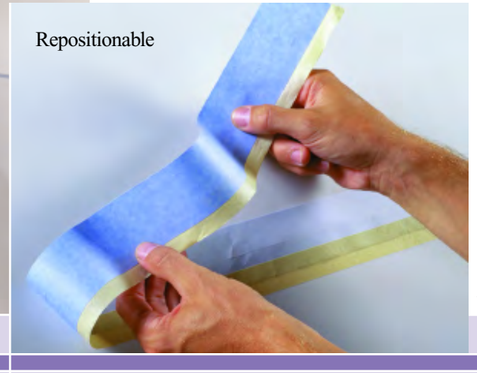

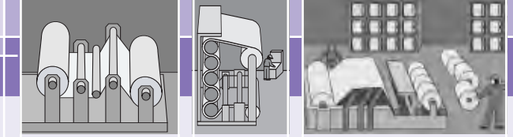

3M™ Repulpable Butt Splicing Tapes

Product	Comments	Color	FDA Status
9114	Thin, repositionable butt splicing system.	Blue	FDA Compliant

3M™ Repulpable Single Coated Tapes (Printable)

Product	Comments	Color	FDA Status
9969	Thin and printable, excellent for newsprint or directory stock.	White, Blue	FDA Compliant
9960	Ultra-thin and printable, excellent on most grades of coated and uncoated papers.	Blue	FDA Compliant
9103	Printable, coatable backing.	Blue	FDA Compliant

3M™ Repulpable Single Coated Tapes (Non-Printable)

Product	Comments	Color	FDA Status
910	Suggested for lightweight coated papers.	Blue	FDA Compliant
R3187	Bleached extensible kraft paper coated with a new technology high tack transparent repulpable adhesive.	Blue, White, Kraft, Black	FDA Compliant
R3127	Paper backing coated with a new technology high tack transparent repulpable adhesive.	White, Kraft, Red	FDA Compliant

One-Sided

Two-Sided
(Offset)

Two-Sided
(Different Widths)

Flying Splicing

R9996

3M™ Repulpable Flying Splice System

3M tape R9996 has a double coated, splittable tape construction designed for straight line flying splices, with a low release split paper liner for easy application.

- Color: Blue
- Thickness: 5.0 mils (0.11mm) without liner
- Temperature Use Range: Up to 400˚F (204˚C)
- Bond Strength: Excellent affinity to cellulose fibers

R9999

3M™ Repulpable Flying Splice System

3M tape R9999 has a double coated, splittable tape construction designed for straight line flying splices, with a low release split paper liner for easy application.

- Color: Blue
- Thickness: 6.5 mils (0.17mm) without liner
- Temperature Use Range: Up to 400˚F (200˚C)
- Bond Strength: Excellent affinity to cellulose fibers

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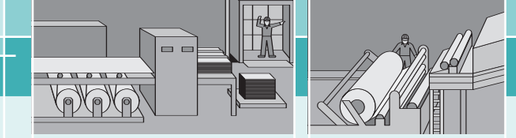


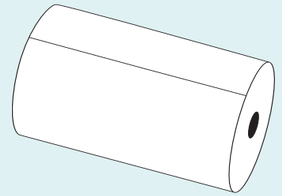
3M™ Repulpable Double Coated Tapes

Product	Comments	Color	FDA Status
R9996	Repulpable double coated tape laminate with a low release split liner.	Blue	-
R9999	Repulpable double coated tape laminate with a low release split liner.	Blue	-
906	Flying splice tape for Off-Machine Coaters.	Blue, White	FDA Compliant
9977	Reinforced tissue, strongest flying splice tape for heavy grades of paper and easy tear back.	Blue	-
905	Thinnest, reinforced adhesive transfer tape.	Clear	FDA Compliant

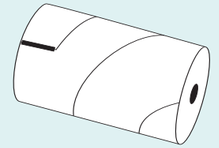
3M™ Repulpable Single Coated Tapes

Product	Comments	Color	FDA Status
R3187	Off-Machine Coater thread up (kite flying).	Blue, White	FDA Compliant

Splittable



Spiral



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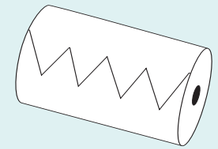
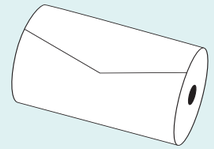


Shallow “V”



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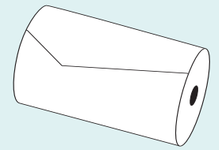

Pulp and Paper Permanent Tape Selection Guide

PRODUCT FEATURES				APPLICATION IDEAS				PAPER TYPES					
Product Number	Color	Liner	Tape Thickness mils (mm)	Overlap Splice	Butt Splice	Flying Splice	Other	Coated	Uncoated	Super Calendered	Newsprint	Kraft	Towel and Tissue
3M™ Repulpable Double Coated Tapes													
405	Lt. Green	UPVC	3.0 (0.08)	x					x	x	x		x
900	Blue	Paper	2.5 (0.06)	x				x	x		x	x	x
900B	Blue	Paper	2.5 (0.06)	x				x	x	x	x	x	x
3M™ Repulpable Single Coated Tapes													
901	Lt. Green	UPVC	4.0 (0.10)	Tape Down	x	Paster Tab	Printable Lap Tape		x	x	x		
9103	Blue	Paper	4.5 (0.11)	Tape Down	x		Printable Lap Tape	x	x	x		x	x
9114	Blue	Paper	4.5 (0.11)		x		Blue Butt Splicing	x	x	x		x	x
9960	Blue	Paper	2.2 (0.06)	Tape Down	x	Paster Tab	Thin Lap Butt Splicing	x	x	x	x	x	x
910	Blue	None	4.0 (0.10)	Tape Down	x			x	x	x	x	x	x
9969	White & Blue	Paper	2.2 (0.06)	Tape Down	x	Paster Tab	Thin Lap Butt Splicing	x	x		x	x	x

Note: User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application.

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Pulp and Paper Temporary Tape Selection Guide

PRODUCT FEATURES				APPLICATION IDEAS				PAPER TYPES				
Product Number	Color	Liner	Tape Thickness mils (mm)	Overlap Splice	Butt Splice	Flying Splice	Other	Coated	Uncoated	Newsprint	Kraft	Towel and Tissue
3M™ Repulpable Double Coated Tapes												
905	Clear	Paper	2.0 (0.05)			x	Core Starting, Roll Closure	x			x	x
906	Blue & White	Paper	3.0 (0.06)			x	Flying Splice	x	x	x		
R3287	White	Paper	5.5 (0.14)				Core Starting, Roll Closure	x	x	x	x	x Core Starting
9069	Blue	Paper	3.0 (0.08)			x	Cold Temp. Flying Splice		x	x		
R3227	Blue & White	Paper	3.0 (0.75)	x			Core Starting, Roll Closure	x	x	x	x	x Core Starting
9977	Blue	Paper	4.0 (0.10)			x	Heavy Duty Hemp	x	x		x	
R9996	Blue	Paper	5.0 (0.11)			x	Spittable Flying Splice		x			
R9999	Blue	Paper	6.5 (0.17)			x	Spittable Flying Splice		x			
3M™ Repulpable Single Coated Tapes												
902	White Green	None	3.9 (0.09)		x		Core Starting, Roll Closure	x	x	x	x	x
R3187	Blue, White, Kraft & Black	None	7.5 (0.19)		x		Core Starting, Roll Closure	x	x	x	x	x
R3127	White, Kraft & Red	None	4.5 (0.11)		x		Core Starting, Roll Closure	x	x	x	x	x

Note: User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application.

Print Splicing

R9993

3M™ Repulpable Flying Splice System for Print

3M tape R9993 has a double coated, splittable tape construction designed for straight line flying splices, with a low release split paper liner for easy application.

- Color: Blue
- Thickness: 5.0 mils (0.11mm) without liner
- Heat Resistance: Up to 400˚F (204˚C)
- Bonding Strength: Delaminates most papers

913

3M™ Repulpable Double Coated Flying Paster Tape for Print

3M tape 913 has been an industry standard for flying splices by providing high initial wet grab and excellent shear strength.

- Color: Blue
- Thickness: 3.0 mils (0.75mm) without liner
- Heat Resistance: Up to 400˚F (204˚C)
- Bonding Strength: Provides high adhesion, even on treated papers, and delaminates most papers

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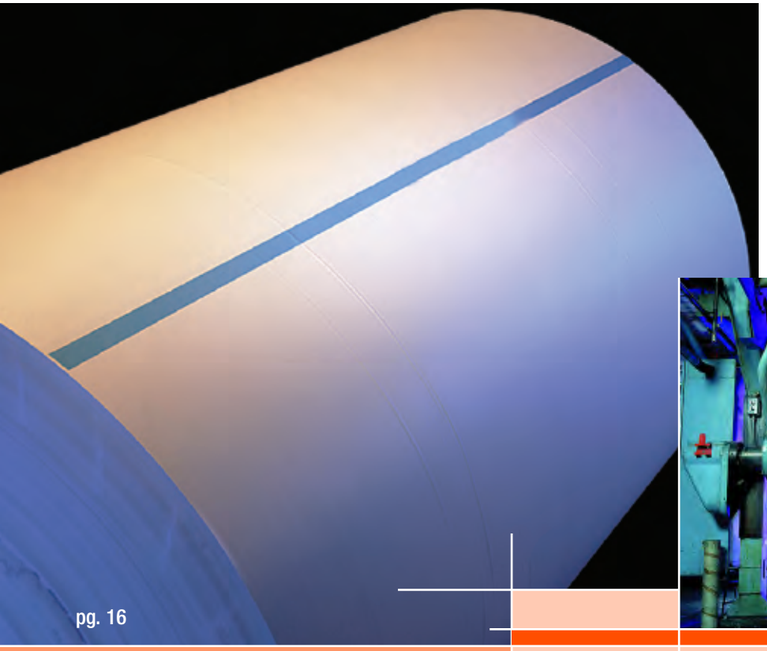

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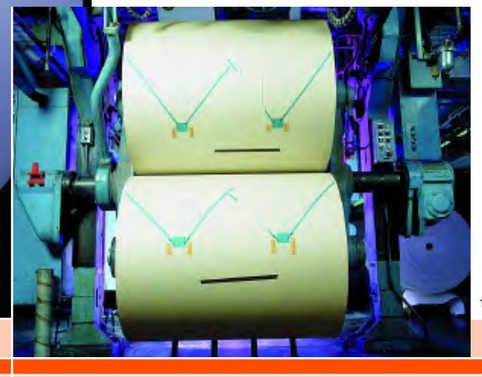

14

3M™ Repulpable Print Splicing Tapes

Product	Comments	Color
R9993	Repulpable double coated tape laminate with easy release split liner.	Blue/Clear
R9990	Double coated tape laminate with a low release split liner and metalized layer for auto sensing and splice detection applications.	Blue/Silver
913	Light-weight tissue coated on both sides with a blue repulpable adhesive for quick grab to newsprint. Furnished on a repulpable easy release paper liner.	Blue
9030	Light-weight tissue coated on both sides with a blue repulpable adhesive for quick grab to newsprint. Furnished on a repulpable easy release paper liner.	Blue
9069	Light-weight tissue coated on both sides with blue repulpable adhesive for quick grab on most grades of paper on a repulpable easy release paper liner.	Blue
9038	Light-weight tissue coated on both sides with a high tack, high shear strength, repulpable adhesive furnished on a repulpable easy release paper liner.	Blue, White
9977	High-stength tissue coated on both sides with a blue, high tack, high shear strength, repulpable adhesive furnished on a repulpable easy release liner.	Blue