

3M™ Masking, Packaging,  
Surface Protection,  
and Specialty Products



Design  
& Production  
Guide for  
Application Success

2

3



Masking, protecting, enhancing,  
shielding, splicing, cushioning,  
case sealing



# 3M™ Masking Tapes – Crepe

## Holding power, line sharpness, and removal the way you want

In this simplified line, you will find a range of such characteristics as adhesive holding power, line sharpness, and clean removal to meet different application requirements for virtually every industrial and consumer application. 3M products also feature...

- Instant adhesion at a touch
- Easy tear without stretching or pulling
- Controlled unwind...not too easy or too hard
- Conformability to stretch and adhere around curves



For best-in-class holding power for critical lines and clean removal, 3M™ Masking Tape 231 offers an optimum combination of characteristics for highly valued products or processes.



A quick easy wrap of 3M™ Masking Tape bundles plastic or metal pipes and other items. Select from wide range of temperature resistance to meet storage or transport conditions.



For attaching production records during assembly, warranty cards, or other temporary communications, 3M™ Masking Tapes 203, 2307, 200, and 2214 are cost-effective options.



For composite masking, 3M fine line (see page 8) overtapes 3M crepe masking tape for gelcoat color separation.

## Streamlined selection

In the guide below you will quickly find solutions for most industrial applications. If not, many other 3M masking tapes are available for more specialized requirements (see the following pages).

### Five questions to make 3M™ Masking Tape selection as easy as I, II, III

1. What is your application?
2. To what temperature will the tape be exposed during use?
3. Do you need maximum holding power during use?
4. Do you need maximum paint edge sharpness when the tape is removed?
5. Do you want to remove the tape without slivering and adhesive residue?



Increasing Holding Power, Line Sharpness, and Clean Removal

Tapes with best-in-class holding power for critical paint lines and clean removal on high valued products or processes.

Product number	Temperature Resistance
2693	up to 325°F (163°C)
231	up to 300°F (149°C)
232	up to 250°F (121°C)

Tapes with reliable masking and clean removal on surfaces for functional coatings or paints; splicing; heavy duty maintenance.

Product number	Temperature Resistance
2380	up to 325°F (163°C)
2364	up to 300°F (149°C)
234	up to 250°F (121°C)

Tapes with clean removal for light duty bundling, attaching, and labeling.

Product number	Temperature Resistance
2307	up to 200°F (93°C)
200	up to 200°F (93°C)
2214	up to 150°F (66°C)

**Increasing Temperature Performance\***

\*30-min. bake

## Product Information:

Product	Tape Structure (Backing/Adhesive)	Color	Total Thickness mils (mm)	Adhesion oz./in. (N/100 mm)	Tensile Strength lbs./in. width (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)	Comments
<b>Low Temperature (Holding, Bundling and Sealing)</b>								
200	Crepe Paper/Rubber	Tan	4.4 (0.11)	25 (27)	19 (333)	8	Up to 200°F (93°C)*	Good instant adhesion.
203 <sup>1</sup>	Crepe Paper/Rubber	Tan	4.7 (0.12)	28 (31)	22 (385)	8	Up to 200°F (93°C)**	Good price/value relationship.
2209	Crepe Paper/Rubber	Tan	5.1 (0.13)	22 (24)	23 (403)	10	Up to 150°F (66°C)*	Most economical light duty holding and sealing.
2214	Crepe Paper/Rubber	Tan	5.2 (0.13)	22 (24)	22 (385)	9	Up to 150°F (66°C)*	Good for holding and bundling.
2307 <sup>1</sup>	Crepe Paper/Rubber	Tan	5.2 (0.13)	28 (31)	23 (403)	8	Up to 200°F (93°C)*	Solvent-free construction; non-critical paint masking.
<sup>1</sup> Meets ASTM D6123/D6123M-97 *Up to 30 minutes **Up to 60 minutes								
<b>Medium Temperature (Paint Masking)</b>								
202 <sup>1</sup>	Crepe Paper/Rubber	Tan	6.3 (0.16)	41 (44)	27 (472)	8	Up to 250°F (121°C)*	Good holding power.
232 <sup>1</sup>	Crepe Paper/Rubber	Tan	6.3 (0.16)	41 (44)	27 (472)	8	Up to 250°F (121°C)*	Good paint lines.
234 <sup>1</sup>	Crepe Paper/Rubber	Tan	6.0 (0.15)	34 (37)	27 (472)	8	Up to 250°F (121°C)*	Excellent control unwind.
2308 <sup>1</sup>	Crepe Paper/Rubber	Tan	5.3 (0.13)	35 (38)	22 (385)	10	Up to 250°F (121°C)*	Good transfer resistance.
<sup>1</sup> Meets ASTM D6123/D6123M-97 *Up to 30 minutes								
<b>High Temperature (Paint Masking)</b>								
213 <sup>1</sup>	Crepe Paper/Rubber	Tan	6.5 (0.16)	41 (45)	30 (525)	9	Up to 350°F (177°C)*	Good on anodized aluminum.
214 <sup>1</sup>	Crepe Paper/Rubber	Tan	6.7 (0.17)	27 (29)	24 (420)	10	Up to 350°F (177°C)*	Stain resistant.
231/231A <sup>1</sup>	Crepe Paper/Rubber	Tan	7.6 (0.19)	38 (41)	28 (490)	10	Up to 300°F (149°C)*	Best all-purpose paint masking tape.
2364 <sup>1</sup>	Crepe Paper/Natural Synthetic/Rubber Blend	Tan	6.5 (0.165)	36 (39)	30 (525)	10	Up to 300°F (149°C)*	Cost effective, high temp performance.
2380 <sup>1</sup>	Crepe Paper/Natural Synthetic/Rubber Blend	Tan	7.5 (0.19)	43 (47)	27 (472)	10	Up to 325°F (163°C)*	High temperature. Best holding to widest variety of surfaces.
2393 <sup>1</sup>	Mini-Crepe Paper/Rubber	Tan	7.6 (0.185)	32 (36)	28 (490)	11	Up to 325°F (163°C)*	Low holding; use where clean removal is a problem.
2693 <sup>1</sup>	Mini-Crepe Paper/Synthetic	Tan	8.5 (0.21)	46 (50)	26 (455)	10	Up to 325°F (163°C)*	Very aggressive holding; excellent for multi-bake paint cycles.

<sup>1</sup>Meets ASTM D6123/D6123M-97 \*Up to 30 minutes

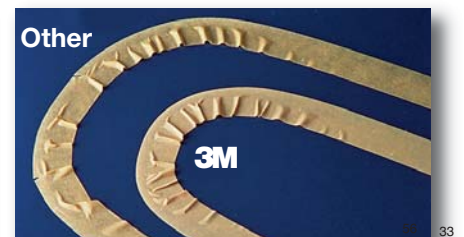
Note: This technical information and data should be considered representative or typical only and should not be used for specification purposes.



Some masking tapes leave a ragged paint edge that may require rework. 3M™ Masking Tapes feature a thin, smooth backing for a sharp paint line.



With sliver-resistant crepe backing, 3M™ Masking Tapes peel off neatly without breaking into pieces. Saves time and work for removal.



With an engineered balance of crepe and adhesive, 3M™ Masking Tapes conform to compound surfaces and around curves without tearing the backing.

# 3M™ Masking Tapes – Fine Line, Flatback, and Specialty

## Holding power, line sharpness, and removal the way you want

With a core capability of coating technology, 3M combines paper or film backings with different adhesives for demanding applications.

### 3M™ Fine Line Tapes

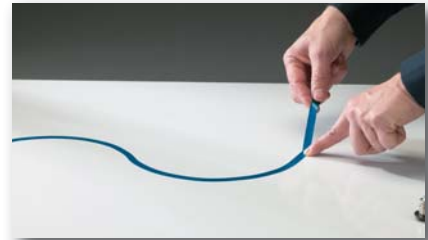
- Sharpest possible paint lines
- Conformability to stretch and adhere around sharp curves
- Film or vinyl backings flex easily for creating curved paint edges
- Resist edge lifting

### 3M™ Flatback Tapes

- High strength paper backing for surface protection when applying thick-coat paint or caulk
- Versatile for many holding, edging, binding, and splicing applications requiring easy visibility



A combination of 3M™ Fine Line Masking Tape and 3M™ Crepe Masking Tape readies a motorcycle gas tank for custom painting that creates a sharp, high impact graphic image.



With blue vinyl backing and rubber adhesive, 3M™ Fine Line Masking Tape 4737S offers best-in-class conformability and line sharpness for curves in high value processes.



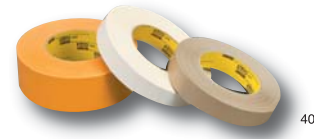
For splicing paper or fabric, 3M™ Flatback Tapes provide high machine direction tensile strength and easy cross tear. Rubber adhesive holds securely on materials ranging from kraft paper to nonwoven fabric.



With a specialty processed film backing, 3M™ Fine Line Masking Tape 218 tapes over fresh paint sooner than crepe tapes with less chance of imprint damage.

## Streamlined selection

In the guide below you will quickly find fine line and flatback solutions for most industrial applications. If not, other 3M masking tapes are available for more specialized requirements. See the next page.



	Fine line tapes for sharpest possible paint lines	Flatback paper tapes with high strength backing for surface protection
<b>CLASS I MASKING</b> <b>Increasing conformability and clean removal</b>	<b>Best-in-class for conformability on sharper curves in high value processes</b> Product number <b>4737T</b> up to 325°F (163°C) <b>4737S</b> up to 325°F (163°C) <b>4735</b> up to 300°F (149°C)	<b>Best-in-class holding power and backing strength for thick-coat paint or caulk</b> Product number <b>2525</b> up to 300°F (149°C)
	<b>CLASS II MASKING</b> <b>Heavy duty workhorse for long, straight lines on flat surfaces</b> Product number <b>218</b> up to 250°F (121°C)	<b>Holding power and backing strength for thick-coat paint or caulk</b> Product number <b>2517</b> up to 300°F (149°C)
	<b>CLASS III MASKING</b> <b>Increasing holding power and backing strength</b>	<b>General purpose splicing, holding and bundling</b> Product number <b>2515</b> up to 200°F (93°C)
	<b>Increasing temp performance*</b>	<b>Increasing temp performance*</b>

\*30 min. bake

**Product Information:**

Product	Tape Structure (Backing/Adhesive)	Color	Total Thickness mils (mm)	Adhesion oz./in. (N/100 mm)	Tensile Strength lbs./in. width (N/100 mm)	Elongation at Break %	Temperature Range °F (°C)	Comments
<b>Fine Line Masking Tapes</b>								
215	Plastic Film/Rubber	Blue	4.7 (0.12)	42 (46)	10 (175)	830	Up to 250°F (121°C) Up to 30 min.	Medium temperature. Excellent conformability.
218	Matte Finish, Polypropylene Film/Rubber	Green	5.0 (0.13)	37 (40)	13 (228)	720	Up to 250°F (121°C) Up to 30 min.	Medium temperature. conformability yet good for straight.
222	Polyester Film/Acrylic	White	2.4 (0.06)	24 (26)	26 (455)	127	Up to 325°F (163°C) Up to 1 hour	High temperature. Thin low profile lines.
265	Matte Finish, Polypropylene	Green	5.1 (0.13)	21 (23)	21 (368)	881	Up to 200°F (121°C) Up to 30 min.	In-mold composite masking where sharp, clean, gel-coat color separation lines are desired.
4735	Vinyl Film/Rubber	Orange	5.5 (0.14)	15 (16)	15 (260)	130	Up to 300°F (149°C) Up to 30 min.	High temperature. More comfortable than 4737.
4737S	Vinyl Film/Rubber	Blue (opaque)	5.1 (0.13)	14 (15)	14 (245)	150	Up to 325°F (163°C) Up to 1 hour	High temperature.
4737T	Vinyl Film/Rubber	Blue (translucent)	5.1 (0.13)	14 (15)	16 (280)	150	Up to 325°F (163°C) Up to 30 min.	High temperature. Good conformability.
<b>Flatback Tapes</b>								
250	Flat Stock Paper/Rubber	Tan	5.9 (0.15)	70 (77)	58 (1016)	4	Up to 200°F (93°C) Up to 30 min.	Meets ASTM D6123M-97* Used in paint adhesion testing.
256	Flat Stock Paper/Rubber	Red/White/Green	6.7 (0.17)	25 (27)	20 (350)	5	Up to 200°F (93°C) Up to 30 min.	Printable, accepts marking inks.
2515	Flat Stock Paper/Rubber	Tan	6.7 (0.17)	55 (60)	36 (630)	3	Up to 200°F (93°C) Up to 30 min.	General purpose splicing, holding and bundling applications.
2517	Flat Stock Paper/Rubber	Tan	6.4 (0.16)	78(85)	35 (543)	2	Up to 300°F (149°C) Up to 30 min.	Excellent splicing, holding and bundling applications.
2525	Flat Stock Paper/Rubber	Orange	9.5 (0.241)	69 (75)	49 (858)	2	Up to 300°F (149°C) Up to 30 min.	Premium splicing, bright color.
2526	Flat Stock Paper/Rubber	White	9.8 (0.242)	69 (75)	50 (858)	4	Up to 300°F (149°C) Up to 30 min.	Excellent adhesion and strength for textile applications.
<b>Specialty Masking Tapes</b>								
225	Crepe Paper/Rubber		5.8 (0.15)	33 (36)	21 (368)	9	Up to 200°F (93°C) Up to 30 min.	Outdoor
226	Polyethylene Saturated Crepe Paper/Rubber	Tan	10 (0.25)	40 (43)	30 (526)	8	Up to 250°F (121°C) Up to 30 min.	Outdoor
2510	Black Crepe Paper/Rubber	Tan	5.6 (0.14)	35 (37)	20 (350)	9	Up to 200°F (93°C) Up to 1 hour	Indoor
2497ST	Polyester/Rubber	Transparent	3.3 (0.09)	17 (18)	52 (910)	112	Up to 300°F (149°C) Up to 30 min.	High temperature. Tear-resistant backing.
5903	Polyethylene/Synthetic rubber	Red	7.0 (0.18)	81 (89)	23 (403)	72	Up to 200°F (93°C)	UV and weather resistant for outdoor masking, holding, patching, bundling, marking and more. 30-day clean removal.

Note: This technical information and data should be considered representative or typical only and should not be used for specification purposes.



# Environmental Highlights of 3M™ Masking Tapes

Product Name	Environmental Claim/Attribute
3M™ Paper Masking Tape 200	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
3M™ General Purpose Masking Tape 203	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® Paint Masking Tape 231/231A	Greater than 95% of the organic solvents used in manufacturing this product are recovered and used again. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
3M™ Masking Tape 2307	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® Masking Tape 2308	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® General Purpose Masking Tape 234	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.

Product Name	Environmental Claim/Attribute
Scotch® Performance Masking Tape 232	Uses solvent free manufacturing process. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® Premium High Performance Masking Tape 2393	Greater than 95% of the organic solvents used in manufacturing this product are recovered and used again. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® Performance Masking Tape 2380	Greater than 95% of the organic solvents used in manufacturing this product are recovered and used again. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® Performance Masking Tape 2364	Greater than 95% of the organic solvents used in manufacturing this product are recovered and used again. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.
Scotch® High Performance Masking Tape 2693	Greater than 95% of the organic solvents used in manufacturing this product are recovered and used again. In addition, this product meets the heavy metals content as stated in Article 11 of European Directive 94/62/EC on packaging and packaging waste and the laws based on CONEG model legislation.



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**Product Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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