



Guide to Converting 3M™ Dual Lock™ and Scotchmate™ Reclosable Fasteners

Technical Bulletin

September, 2010

3M™ Scotchmate™ and Dual Lock™ Reclosable Fasteners work well on items that need to be accessed or repositioned frequently such as seat cushions, covers, trade show designs, access panels and wall panels. Frequently, Dual Lock and Scotchmate reclosable fasteners are processed through automatic cutting equipment to convert from roll form to pieces of a certain shape or size for a specific application. During cutting, the polypropylene stems of the Dual Lock reclosable fasteners or the hook or loop of the Scotchmate reclosable fasteners are susceptible to damage. The following processing techniques have been found to work well with these 3M™ Reclosable Fastener products and are suggested for your evaluation.

Techniques for Processing 3M Dual Lock and Scotchmate Reclosable Fasteners

- **Die-cutting:** 3M reclosable fasteners can be flat bed or rotary cut and can be kiss cut, cross cut, lineal cut or blanked out pieces. A 86# Kraft paper liner works best and is available as standard on some products.
- **Running:** Some pressure sensitive adhesives can cause build-up during cutting and the use of a silicone or PTFE release agent* can reduce this problem. Roll wrap can help to protect the product.
- **Ejection:** Spring ejectors on the punches are suggested to prevent ooze and re-bond during die-cutting. Pre-cured silicone strips also work well in narrow areas.
- **Steel Rule:** Spot rubber, height of rule should be 937 thousandths, two pt. rule, 0.028" thick, long center bevel of a 3/4" board works best. Life is 50,000-100,000. Treatments such as PTFE can slow build-up and ease or reduce cleaning.
- **Relining:** Liners protecting the adhesive on 3M reclosable fasteners are designed to provide easy removal and minimal contamination of the adhesive. Often a customer may request an alternate liner for converted products and the alternate liner should be evaluated for ease of removal and minimizing contamination of the adhesive such as from liner release coatings.

Additional Tips:

- It is best to warehouse and process this material at temperatures between 60° to 80°F (16° to 27°C) and 40 to 60% relative humidity.
- These materials may be cut mated together or unmated.

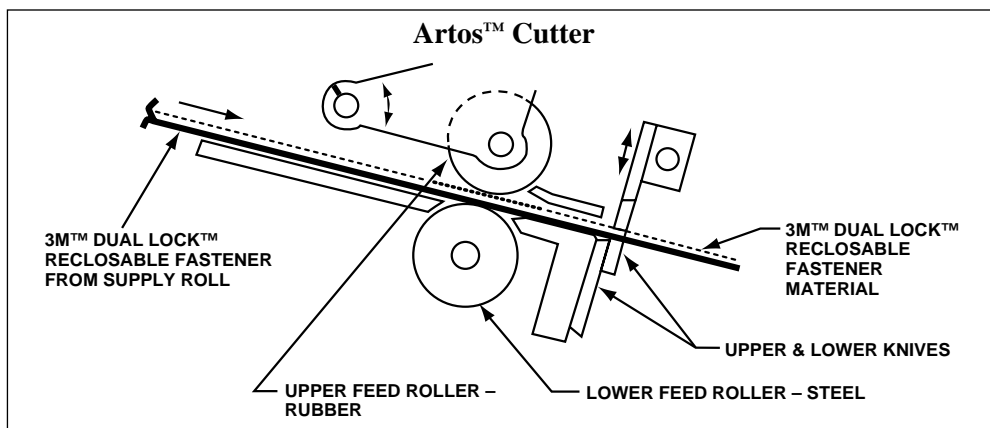
*Be sure to carefully read and follow release agent manufacturers' precautions and directions for use.

Technical Bulletin

Guide to Converting 3M™ Dual Lock™ and Scotchmate™ Reclosable Fasteners

Techniques for Processing 3M™ Dual Lock™ and Scotchmate™ Reclosable Fasteners

Automatic Measuring and Cutting Machine: The Artos™ Cutter has been found to be one system for cutting these products to a specific length. This can be done on either unmated or pre-engaged pieces.



Automatic Dispensing Equipment: For easy placement of die-cut pieces on a kiss-cut liner, the 3M™ Dispenser LS-52 and LS-56 work well and allow you to present one die-cut piece at a time.

Precautions to avoid stem crushing on 3M™ Dual Lock™ Reclosable Fastener:

- The least damage to Dual Lock reclosable fasteners is by cutting with the pieces pre-mated.
- Use minimum feed roll pressure – only what is needed to maintain cut length accuracy. Check piece length periodically.
- Use no brake tension on input rolls of product – they should be freewheeling. Brake tension requires higher feed roll pressure to feed the product.
- Examine quality of cut pieces periodically to insure that stem cut crushing is not occurring.
- Cut with stems facing into cutter blade, or cut pre-engaged pieces.

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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.

Warranty, Limited Remedy, and Disclaimer

Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of 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.

3M

Industrial Adhesives and Tapes Division

3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550 • 877-369-2923 (Fax)
www.3M.com/industrial



Recycled Paper
40% pre-consumer
10% post-consumer

3M, Dual Lock and Scotchmate are trademarks of 3M.
Artos is a trademark of Artos Engineering Company.
Printed in U.S.A.
©3M 2010 70-0709-3886-8 (9/10)