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3M™ Dual Lock™ Reclosable Fastener SJ3481

Product Description

3M™ Dual Lock™ Reclosable Fasteners are positive locking, hidden fasteners designed for use in a variety of attachment solutions. They consist of continuous strips of polyolefin stems with a mushroom shaped top protruding up from the backing. When snapped together the mushroom shaped caps interlock producing a strong reliable Fastener.

The standard Dual Lock fasteners are available in three different stem densities (170, 250 and 400) referring to the approximate number of stems per square inch. (26, 39, 62 stems per square centimeter) By inter-locking different stem density combinations you can create the strength that suits your application; more total stems give higher strength. The Dual Lock Reclosable fasteners can be mated in the following combinations of increasing closure strength: Type 170 to Type 250, Type 170 to Type 400, Type 250 to Type 250 and Type 250 to Type 400. We do not recommend using the Type 170 to 170 because it does not have enough strength for a good connection. We do not recommend using the Type 400 to 400 because it is too strong and may cause stems and heads to rip out rendering the fastener no longer reclosable.

The Dual Lock Low Profile has one stem density of approximately 705 stems per square inch and they interlock to themselves. The low profile products are not intended to mate to the standard size Dual Lock. 3M™ Dual Lock™ Reclosable Fastener SJ3481 is a rigid backed strip 48 inches long which allows for a variety of attachment methods. Most commonly by applying hot melt, epoxy or liquid adhesive.



Product Features

- **Easy Alignment:** Dual Lock fasteners engage in any direction or position. The mushroom stems slide into position until they are engaged by snapping together applying firm pressure, this eliminates concerns about misalignment or spontaneous engagement.
- **Positive Locking:** Dual Lock fasteners engage/fasten with an audible snap and detectable movement assuring complete and secure closure.
- **Reclosability:** Dual Lock fasteners can be opened and closed for multiple closure applications (high cycle life).
- **Blind Attachment:** Dual Lock fasteners can be attached on the backside of substrate (i.e. trim piece) where it will not interrupt the show surface.
- **Rattle-Free:** Dual Lock fasteners will not rattle loose.
- **Ease of Assembly:** Dual Lock fasteners can be used to attach components before they enter the final assembly plant, reducing the number of parts and the assembly time. No tools are required.
- **Adjustable Strength:** By selecting different combinations of the various stem densities of the Dual Lock the fastener can be designed to meet the strength needs of the designer.
- **Product Forms:** Dual Lock fasteners come in a variety of forms: Backed with Pressure Sensitive adhesive, Non-woven, Rigid backed, Die Cut Shapes, and low profile.
- **Attachment Methods:** The wide varieties of Dual Lock fasteners allow a design engineer flexibility to be able use and attach Dual Lock to just about any substrate or application. Peel and stick pressure sensitive adhesive backed is quick and easy yet strong and secure. Non-woven backed can be used with a variety of adhesive choices such as hot melt, liquid, epoxies, sealants, etc. We have parts that can be attached with a screw or rivet; rigid and plain backed for developing your own special device.

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General Information

This product for alternative attachment methods requires a unique attachment method and, based on how this product is used, the heat resistance, tensile and shear strength can vary. This product does not have adhesive backing, so there is no release liner.

Product Family: Rigid backed strips of Dual Lock 48 inches long

These are typical values which were gathered from testing the PSA backed materials. Similar values can be expected when the Dual Lock is held securely in a rigid fashion, however the data may vary depending on the attachment method used.

Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Physical Properties

Property	Values	Values	Notes
Dual Lock Color	Black		
Thickness	5.08 mm	200 mil	
Engaged to itself or to one of the same family	8.89 mm	350 mil	Just Dual Lock not considering any added thickness for adhesive Would not typically engage to itself
Stems	62 Stems/cm ²	400 Stems/in ²	

Typical Performance Characteristics

Temperature Use Range note

Typical temperature performance for Dual Lock products with no adhesive backing on them while supporting 2.2 lbs/ in² (1.0 kg/in²) in tensile or shear loads would range from -20°F to 220°F (-12°C to 104°C). This may change depending on the attachment method used, for example if you use an adhesive to attach the Dual Lock to a substrate the temperature resistance of the adhesive most likely will dictate the overall performance.

Note

The following technical information and data is intended as a guideline to assist customers in selecting 3M™ Reclosable Fasteners for further evaluation. This technical information is not product release specifications or standards. Unless stated differently, the typical system performance and product properties were obtained using specific test methods under controlled laboratory conditions of 72°F

± 5°F and 50% ± 10% relative humidity. The user is responsible for evaluating 3M reclosable fasteners under expected use conditions to ensure suitable performance for the intended application.

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Tests were run at 12 inches per minute

Typical Performance Characteristics (continued)

Dynamic Tensile (Engage)		Substrate
9 N/cm ²	13 lb/in ²	Type 170 to 250
14.5 N/cm ²	21 lb/in ²	Type 170 to 400
15.2 N/cm ²	22 lb/in ²	Type 250 to 250
21.4 N/cm ²	31 lb/in ²	Type 250 to 400
18.5 N/cm ²	27 lb/in ²	Low Profile to Low Profile

Property: Dynamic Tensile (Engage)

Dynamic Tensile (Disengage)		Substrate
18.5 N/cm ²	27 lb/in ²	Type 170 to 250
29.6 N/cm ²	43 lb/in ²	Type 170 to 400
29.6 N/cm ²	43 lb/in ²	Type 250 to 250
41.4 N/cm ²	60 lb/in ²	Type 250 to 400

Property: Dynamic Tensile (Disengage)

Dynamic Shear		Substrate
9.8 N/cm ²	14 lb/in ²	Type 170 to 250
14.5 N/cm ²	21 lb/in ²	Type 170 to 400
15 N/cm ²	22 lb/in ²	Type 250 to 250
41.3 N/cm ²	59 lb/in ²	Type 250 to 400

Property: Dynamic Shear

Cleavage Strength		Substrate
21 N/cm width	12 lb/in width	Type 170 to 250
35 N/cm width	20 lb/in width	Type 170 to 400
42 N/cm width	24 lb/in width	Type 250 to 250
56 N/cm width	32 lb/in width	Type 250 to 400

Property: Cleavage Strength
notes: Rigid backed from Rigid backed

T-Peel Adhesion		Substrate
1.2 N/cm width	0.7 lb/in width	Type 170 to 250
2.5 N/cm width	1.4 lb/in width	Type 170 to 400
3.3 N/cm width	1.9 lb/in width	Type 250 to 250
2.6 N/cm width	1.5 lb/in width	Type 250 to 400

Property: T-Peel Adhesion
notes: Flexible from Flexible

Typical Performance Characteristics (continued)

90° Peel Adhesion		Substrate
3.2 N/cm width	1.8 lb/in width	Type 170 to 250
5.4 N/cm width	3.1 lb/in width	Type 170 to 400
8.1 N/cm width	4.1 lb/in width	Type 250 to 250
8.1 N/cm width	4.6 lb/in width	Type 250 to 400

Property: 90° Peel Adhesion
 notes: Flexible from Rigid

Cycle Life	Substrate
1000	Type 170 to 250
1000	Type 170 to 400
1000	Type 250 to 250
1000	Type 250 to 400

Property: Cycle Life
 notes: Number of closures before losing 50% of original strength

Design Considerations

- As a general rule, four square inches of fastener area per pound of static tensile or shear 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. Type 250 Dual Lock Reclosable fasteners less than 0.75" (19 mm) width should not be engaged to other type 250 Dual Lock Reclosable fastener as low disengagement values may occur.
- Whenever possible design one side of the Dual Lock reclosable fasteners to be larger than the mating side. This will allow for variability or mismatch in Dual lock alignment positions, and ensure 100% fastening area contact. Another approach would be to design two rectangular shaped fastener pieces so that they can be engaged in a cross web/perpendicular pattern (crossed).
- Dual Lock strength is proportional to the fastening contact area, and the number of stems in combination used. More stems and more Dual Lock used gives you more strength, less stems combined and using less Dual Lock will give you less strength.
- Dual Lock disengagement strength/performance is strongest in direct tensile. Peel/cleavage mode is where it is most easily removed.
- Final product performance depends upon a combination of factors: the substrate and its surface characteristics, the fastener selected, the application method and conditions, the time and environmental conditions required for the application. Because these factors are unique to each application, the user must evaluate Dual Lock and do any testing required to determine Dual Lock’s suitability for the user’s desired end use.

Storage and Shelf Life

To obtain best performance, use this product within 24 months from date of manufacture.

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References

1. 3m.com Product Page
Url: https://www.3m.com/3M/en_US/company-us/all-3m-products/~-/3M-Dual-Lock-Reclosable-Fastener-SJ3481?N=5002385+3293242265&rt=rud
2. Safety Data Sheet
Url: https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=SJ3481

ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

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.

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