



# Water-Soluble Wave Solder Tape

## 5414

### Technical Data

**Product Description** 3M™ Water-Soluble Wave Solder Tape 5414 has a poly-vinyl alcohol backing which is water soluble and a synthetic water soluble adhesive to mask gold fingers on printed circuit boards during wave soldering.

Product Construction	Backing	Adhesive	Liner	Color	Standard Roll Length
	PVA film	Water soluble synthetic	Kraft paper	Hazy, transparent	36 yds. (33 m)

### Typical Physical Properties

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

		ASTM Test Method
Adhesion to Steel:	4 oz./in. width (4.4 N/100 mm)	D-3330
Tensile Strength at Break:	6 lbs./in. width (105.1 N/100 mm)	D-3759
Elongation at Break:	334%	D-3759
Total Tape Thickness:	2.1 mils (0.053 mm)	D-3652

### Features

- No adhesive residue after removal.
- Low static upon liner release and when taping board.
- Moisture barrier packaging plus desiccant.
- Humidity extremes do not affect tape properties.
- Easy manual and machine application.

### Storage

Store under normal conditions of 60° to 80°F (16° to 27°C) and 40 to 50% R.H. in the original carton.

### Shelf Life

To obtain best performance, use this product within 12 months from date of manufacture.

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## 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.

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**ISO 9001:2000**

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

# 3M

## Industrial Business Industrial Adhesives and Tapes Division

3M Center, Building 21-1W-10, 900 Bush Avenue  
St. Paul, MN 55144-1000  
800-362-3550 • 877-369-2923 (fax)  
[www.3M.com/industrial](http://www.3M.com/industrial)



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