

3M™ Automotive Converted Optically Clear Adhesive

ACO 03U-XXX Series

- Excellent durability in reliability testing
- High conformability to surfaces steps
- Superior mura resistance

Product Description

3M™ Automotive Converted OCA (ACO) films are specialized optically clear adhesives offering excellent clarity and adhesion to various transparent display substrates. 3M ACO 03U-XXX is designed for applications that require soft OCA for filling thick ink step (lens border frame), ITO compatibility and high adhesion. 3M ACO 03U-XXX is UV curable which makes it suitable for film touch panel and LCM bonding applications.



Construction

Product	3M ACO 03U-050	3M ACO 03U-100
Adhesive Type:	Acrylic	Acrylic
Adhesive Carrier:	None	None
Approximate Thickness:		
Release Liner:	50 um (2.0 mils) Clear Polyester	50 um (2.0 mils) Clear Polyester
Adhesive:	50 um (2.0 mils)	100 um (4.0 mils)
Release Liner:	75, 100 or 125 um (3.0, 4.0, or 5.0 mils) Clear Polyester	75, 100 or 125 um (3.0, 4.0, or 5.0 mils) Clear Polyester

Product	3M ACO 03U-175	3M ACO 03U-200	3M ACO 03U-250
Adhesive Type:	Acrylic	Acrylic	Acrylic
Adhesive Carrier:	None	None	None
Approximate Thickness:			
Release Liner:	50 um (2.0 mils) Clear Polyester	50 um (2.0 mils) Clear Polyester	50 um (2.0 mils) Clear Polyester
Adhesive:	175 um (7.0 mils)	200 um (8.0 mils)	250 um (10.0 mils)
Release Liner:	75, 100 or 125 um (3.0, 4.0, or 5.0 mils) Clear Polyester	75, 100 or 125 um (3.0, 4.0, or 5.0 mils) Clear Polyester	75, 100 or 125 um (3.0, 4.0, or 5.0 mils) Clear Polyester

Typical Physical Properties and Performance Characteristics

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

Performance to Environmental Conditions:

The following environmental tests were conducted in the 3M laboratory under the conditions specified without any appreciable deterioration in visible appearance (no bubbles, delamination, haze <0.2%, b* <1). Sample construction is cover glass/3M ACO 03U-XXX/cover glass.

	Condition	Duration
High Temperature	+105°C	1200 hours
Low Temperature	-40°C	1200 hours
High Temp/Humidity-1	+65°C/90%RH	1200 hours
High Temp/Humidity-2	+85°C/85%RH	1200 hours
Thermal Shock	-40°C and +85°C (1 hour dwell, <1 min ramp time)	650 cycles
UV	.55 W/m ² at 340nm, Daylight filter	500 hours

Peel Adhesion:

ASTM D3330 modified, 180 degree peel from glass, 1 cm wide peel strips, 12 in/min (305 mm/min), 2.0 mil polyester backing, 3M ACO 03U-XXX cured 3J/cm²

Peel Adhesion to Glass		
Dwell Time	20 min dwell at 25°C/50%RH	3 days dwell at 25°C/50%RH
Units	N/cm	N/cm
3M ACO 03U-050	7.1	11.1
3M ACO 03U-250	9.9	15.8

Color:

Ultra Scan Pro (Hunter Lab), ASTM E308, D65/10°
 3M ACO 03U-XXX on LCD glass, uncured

3M ACO 03U-050	3M ACO 03U-250
L* = 97.0	L* = 97.0
a* = -0.01	a* = 0.00
b* = 0.15	b* = 0.20

Refractive Index: 3M ACO 03U-XXX uncured and cured (3J/cm²)

(+ 0.0005 Metricon measurements)

3M ACO 03U-XXX			
	405 nm	532 nm	633 nm
Uncured	1.4879	1.4765	1.4717
Cured	1.4903	1.4783	1.4735

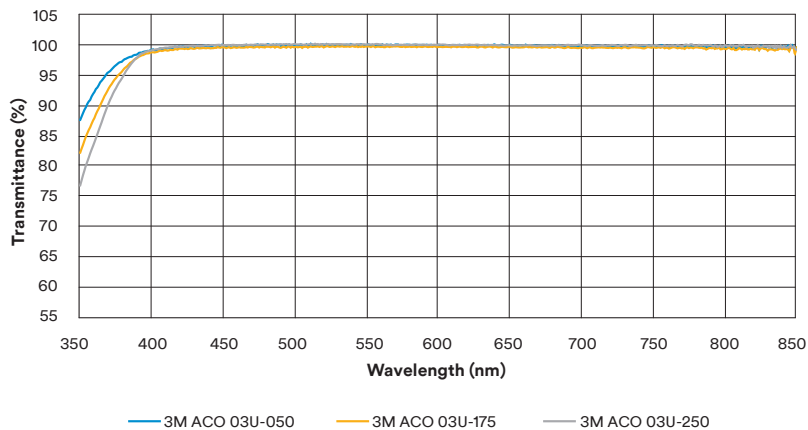
Haze:

Haze is measured according to ASTM D1003-92,
 3M ACO 03U-XXX on LCD glass, uncured.

3M ACO 03U-050	3M ACO 03U-250
0.1%	0.2%

Transmission Curve:

Transmission vs. Wavelength (Corrected for Reflection
 Loss of LCD) for 3M ACO 03U-XXX on Glass



Typical Electrical Properties of 3M™ ACO 03U-XXX at Room Temperature

ASTM-D150-92. 3M ACO 03U-XXX cured 3J/cm²

Dielectric Constant:

3M ACO 03U-XXX	
Frequency (kHz)	Dielectric Constant
100	4.2
500	3.9

Suggested Lamination Process

Step 1: Remove secondary liner, and then laminate 3M ACO 03U-XXX to first adherent substrate by roller at room temperature

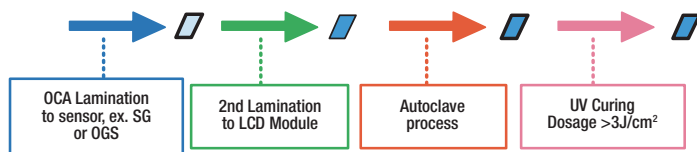
Recommendation: roller pressure 0.1 – 0.2 MPa, roller speed 0.5 – 1 m/min

Step 2: Remove primary liner, and then laminate 3M ACO 03U-XXX/first adherent to second adherent by vacuum lamination

Recommendation: Vacuum condition < 50 Pa, pressure around 0.1 – 0.2 MPa

Step 3: Autoclave process recommendation: 30-60°C/3-5kgf/cm²/20-30 min

Step 4: UV curing with minimum 3J/cm² dosage



UV Cure Guidance

- UV range: 340-375nm (max absorption = 342nm)
- Minimum UV dosage and intensity: 3 J/cm², 10 mW/cm²
- Suggest using lower wavelengths of the UV-A spectra. Suitable UV sources would be Fusion D bulb and medium pressure Hg.
- LED sources, which output at longer UV-A wavelengths would be less ideal.

Storage

- Avoid applying pressure or resting objects on the product to prevent marking, denting, or deforming the surface.
- Wear gloves to prevent fingerprints or nail marks when handling.
- Product needs to be unpacked and handled in a clean-room facility.
- Product must be protected from light exposure.
- Store in sealed, foil bag under -20°C to 30°C and less than 70% relative humidity. If removed from cold storage, ensure no condensation on packaging.



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Regulatory

For regulatory information about this product, please contact your 3M representative.

Technical Information

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

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