



Double Coated Foam Tape

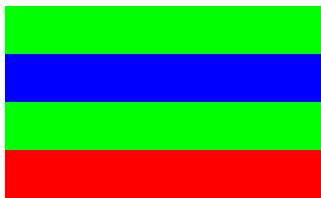
4420 Polyethylene Foam Tape

Temporary Technical Data

Jun, 1997

Production Description 4420 Double Coated Polyethylene
Foam Tape with Polycoated Paper Liner

Tape Construction



Acrylic Adhesive
PE Foam
Acrylic Adhesive
Polycoated Paper Liner

Adhesive Type Cross linked, Tackified Acrylic Adhesive

Carrier Type Polyethylene foam

Thickness Tape only 0.35 mm

 Release liner 0.23 mm

Normal Tolerance ± 15 %

Color Milky -white

Release Liner Polycoated Paper Liner

 3M Logo printed

Approximately Density 600

Tape only(kg/cm³)

Roll Length

Standard	m	20
----------	---	----

Roll width :

Minimum	mm	6.4
---------	----	-----

Maximum	mm	1100
---------	----	------

Slitting Tolerance	mm	± 0.8
--------------------	----	-------

Typical Physical Properties

Peel Strength	kg/12.7 mm	to SUS	1.5
---------------	------------	--------	-----

ASTM D 3330

90 peel Adhesion ;

Room Temperature 72 hour aging

Jaw Speed : 305 mm/min ; with Al strip

Dynamic shear	kg/6.45 cm ²	28
---------------	-------------------------	----

to Stainless steel ; 6.45 cm² overlap

Room Temperature 72 hour aging

Jaw speed : 12.7 mm/min

ASTD D 1002

Normal Tensile	kg/6.45 cm ²	30
----------------	-------------------------	----

(T-block) Al to Al ; 6.45 cm²

Room Temperature 72 hour aging

Jaw speed : 50.8 mm/min

ASTM D 897

Static Shear	min	10,000
--------------	-----	--------

500 grams loading on stainless steel

3.2 cm² overlap at room temperature

ASTM D 3654

Shelf Life	24 months from date of manufacture when stored in original cartons at room temperature & 50 % RH
------------	--

Application Techniques

☞ Bond strength is dependent upon the amount of adhesive-to-surface contact developed, firm application pressure helps develop better adhesive contact and improve bond strength.

☞ To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Typical surface cleaning solvents are isopropyl alcohol and water (rubbing alcohol) or heptane. Note ; Be sure follow the manufacturer's precautions and directions for use when using solvents.

☞ Ideal tape application temperature range is 21 °C to 38 °C. Initial tape application to surfaces at temperatures below 10 °C is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

Application Ideas

☞ The foam construction makes these products for many joining, mounting, sealing applications

☞ #4420 tape are specially formulated for many indoor and outdoor general mounting and joining application, including bonding to polyethylene and polypropylene and many other plastics, where moderate temperature and shear performance general purpose mounting and joining application.

☞ Application ideas for this polyethylene Foam tape

- Signs, Nameplates and Plaques
- Pointed of purchase and other displays
- Plastics Hooks, Racks and Dispensers
- Wire and Cable Clips
- Appliance, Display case and Electronics Equipment Trim.

Additional Information	To request additional product information for sales assistance, call 82-2-3771-4030. Address correspondence to : Bonding System Division, 3M Korea LTD, Daehan Invest Trust Bldg. 22 nd , Yoido-dong, Yongdeungpo-gu, Seoul, Korea Our Fax number is 82-2-786-7429.
------------------------	---

Additional Product Information	Values presented have been determined by standard test methods and are average values not to be used for specification purposes.
--------------------------------	--

IMPORTANT NOTICE TO PURCHASER	<p>3M MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.</p> <p>User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M BSD product in particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the condition in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M ITSD product to determine whether it is fit for a particular purpose and suitable for the user's method of application.</p>
-------------------------------	---

LIMITATIONS OF REMEDIES AND LIABILITY	<p>If the 3M product is provided to be defective, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT. 3M shall not otherwise be liable for loss or damage, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or</p>
---------------------------------------	---

strict liability.

ISO 9002

This Industrial Tape and Specialties Division products was manufactured under 3M quality system registered to ISO 9002 standards.

Bonding System Division, 3M Korea Ltd. Daehan Invest Trust Bldg. 22nd Yoido-dong,
yongdeungpo-gu, Seoul, Korea Tel : 82-2- 4771-4030 Fax : 82-2-786-7429