



# Double Coated Foam Tape

## # 4420 Black Polyethylene Foam Tape

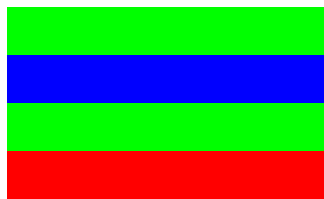
Temporary Technical Data

Jun, 1997

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

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### Tape Construction



Acrylic Adhesive  
PE Foam  
Acrylic Adhesive  
Polycoated Paper Liner

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Adhesive Type                      Cross linked, Tackified    Acrylic Adhesive

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Carrier Type                      Polyethylene foam

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Thickness      Tape only      0.40 mm

                    Release liner      0.23 mm

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Normal Tolerance                       $\pm 15\%$

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Color                      Black

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Release Liner                      Polycoated Paper Liner

   3M Logo printed

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Approximately Density                      600

Tape only(kg/cm<sup>3</sup>)

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Roll Length			
Standard	m		33
Roll width :			
Minimum	mm		6.4
Maximum	mm		1100
Slitting Tolerance	mm		± 0.8

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#### 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 <sup>2</sup>		28
to Stainless steel ; 6.45 cm <sup>2</sup> overlap			
Room Temperature 72 hour aging			
Jaw speed : 12.7 mm/min			
ASTD D 1002			
Normal Tensile	kg/6.45 cm <sup>2</sup>		30
(T-block) Al to Al ; 6.45 cm <sup>2</sup>			
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 cm <sup>2</sup> 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		

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Application Techniques

⊕ Bond strength is dependent upon the amount of

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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.

♣ deal 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.

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#### Application Ideas

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

♣ #4420BK 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.

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Additional Product  
Information

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

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

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