



Double Coated Foam Tape

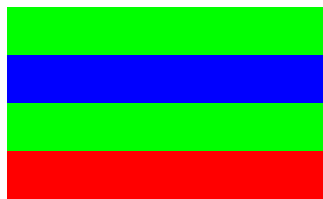
4428 Polyethylene Foam Tape

Temporary Technical Data

Mar, 1998

Production Description # 4428 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 0.90 mm

Release liner 0.22 mm

Normal Tolerance $\pm 15\%$

Color Black

Release Liner Polycoated Paper Liner

Approximately Density 256

Tape only(kg/cm³)

Roll Length

Standard m

33

Roll width :

| | | |
|---------|----|------|
| Minimum | mm | 6.4 |
| Maximum | mm | 1100 |

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

Typical Physical Properties

| | | |
|---------------|----------|-----|
| Peel Strength | kg/25 mm | 2.5 |
|---------------|----------|-----|

to Stainless steel

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 | 25 |
|---------------|-------------------------|----|

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 | 40 |
|----------------|-------------------------|----|

(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 | 1,000 |
|--------------|-----|-------|

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.

☞ 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.

Application Ideas

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

☞ # 4428 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. 22nd , 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.

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ISO 9002

This Bonding System Division products was manufactured under 3M quality system registered to ISO 9002 standards.

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