



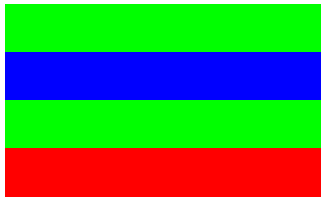
3M Brand Double Coated # 9080HL Non-woven Tape

Temporary Technical Data

Jun, 1998

Production Description # 9080HL Double Coated Non-woven
Tape with Polycoated Paper Liner

Tape Construction



Acrylic Adhesive
Non-woven
Acrylic Adhesive
Polycoated Paper Liner

Adhesive Type Cross linked, Tackified Acrylic Adhesive

Carrier Type Non-woven

Thickness Tape only 0.160 mm

Release liner 0.160 mm

Normal Tolerance \pm 15 %

Color White

Release Liner Polycoated Paper Liner
3M Logo printed

Roll Length

Standard	m	50
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Roll width :

Minimum	mm	6.4
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Maximum	mm	1200
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Slitting Tolerance	mm	± 0.8
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Typical Physical Properties and Performance Note : The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Peel Strength to SUS	grams/25 mm	1900
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ASTM D 3330

180 peel Adhesion ;

Room Temperature 72 hour aging

Jaw Speed : 305 mm/min ; with Al strip

Static Shear	min	10,000
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500 grams loading on stainless steel

6.45 cm² overlap at room temperature

ASTM D 3654

Liner Release

1 inch(25.4 mm) width	Max. 50 grams
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Jaw Speed : 12 inch/min (305 mm/min)

Temperature Resistance

Short Term(minutes, hours)	120 °C
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Long Term(Days, Weeks)	90 °C
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Shelf Life

12 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 Idea

- . #9080HL tapes are specially formulated for many indoor general purpose mounting and joining application, including bonding to Polyethylene, Polypropylene and many other plastics, where moderate temperature and shear performance are required.

- . #9080HL tape are formulated for more demanding indoor and moderated outdoor general purpose mounting and joining application.

- . Application idea for these Double coated Taps
Sign, Nameplates and Plaques
Point of purchase and other displays
Plastics Hooks, Racks and Dispensers

Wire and Cable Clips
Appliance, Display Case and Electronics Equipment Trim
Form Laminating
Light weight material bond
Splicing

For 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.

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

ISO 9002

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