



High Tack Double Coated Tape

9322- 08

Technical Data

Jul, 2011

Product Description

9322-08 Double Coated Tape consists of non-woven carrier and acrylic adhesive with excellent initial tack on both sides with “3M” logo printed white paper liner.

Product Construction

Product	9322-08 double coated tape
---------	----------------------------

Adhesive type:	High tack acrylic adhesive
----------------	----------------------------

Adhesive carrier :	Non-woven
--------------------	-----------

Tape thickness:	0.08mm (+/-) 0.015
-----------------	--------------------

Liner type, color :	White polycoated paper with “3M” logo printed in blue color
---------------------	---



Liner caliper:	0.12mm(+/-) 0.01
----------------	------------------

Roll size:	1200mm
------------	--------

Features

- Specially formulated for many indoor general purpose mounting and joining applications, where moderate temperature and shear performance are required.
 - High initial tack for many industrial foams and plastics.
 - Good adhesion to many kinds of materials including LSE plastics.
 - Good thermal resistance
 - Good roll stability
-

9322-08 High Tack Double Coated Tape

Application Ideas

- Foam laminating
- Plastics attachment
- Sign, nameplates and plaques attachment
- Insulator attachment
- General light-weight material attachment and splicing

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.

	Test Method	9322-08
180 degree peel		
Adhesion to SUS: RT, 20min dwell	ASTM D 3330	1,500g/25mm
Adhesion to PP : RT, 20min dwell		800g/25mm
Adhesion to ABS : RT, 20min dwell		1,000g/25mm
Static Shear		
Static shear to SUS: 1kgf load, 6.45cm ² overlap at RT	ASTM D 3654	10,000 minute
Liner Release (25.4mm width)		
Jaw speed: 305mm/min		Max. 80gram
Temperature Resistance		
Short Term (minutes, hours)		100 °C
Long Term (Days, Weeks)		70 °C
Shelf Life	Shelf life is 12 months from date of manufacture when stored in original cartons at 60-80°F (15-27°C) and 40-50% relative humidity.	

Application Technique

- 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 surface must be clean, dry and well unified. Typical surface cleaning solvents are isopropyl alcohol and water (rubbing alcohol) or heptane.
Note; Be sure to follow manufacturer's safety precautions and directions for use using solvents.
- Ideal tape application temperature range is 70°F to 100°F (21°C to 38°C). Initial tape application to surface at temperatures below 50°F(10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 82-80-533-4114. Address correspondence to : 3M, Industrial Adhesive & Tape Division, 3M Korea LTD, Daehan Invest Trust BLDG 22nd floor , Yoido-Dong, Yongdeungpo-Gu, Seoul, Korea. Our fax number is 82-2-786-7429.

9322-08 High Tack Double Coated Tape

Important Notice

3M MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. 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 ITSD product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions 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 ITSD product. Given the variety of factors that can affect the use and performance of a 3M ITSE product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M ITSD product to determine whether it is fit for a particular purpose and suitable for the user's method application.

Limitation of Remedies and Liability

If the 3M product is proved to be defective, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or strict liability.

ISO 9002

This Industrial Adhesive & Tape Division Product was manufactured under a 3M quality system registered to ISO9002 standards.

3M

Industrial Adhesive & Tape Division

3M Korea LTD, Daehan Invest Trust BLDG
22nd, Yoido-Dong, Yongdeungpo-Gu, Seoul
Korea www.3M.co.kr