



# High Tack Double Coated Tape

## 9322- 140

Technical Data

Jul, 2011

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### Product Description

9322-140 Double Coated Tape consists of tissue carrier and acrylic adhesive with excellent initial tack on both sides with “3M” logo printed white paper liner.

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### Product Construction

Product	9322-140 double coated tape
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Adhesive type:	High tack acrylic adhesive
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Adhesive carrier :	Tissue
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Tape thickness:	0.14mm (+/-) 0.02
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Liner type, color :	White polycoated paper with “3M” logo printed in blue color
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Liner caliper:	0.12mm(+/-) 0.01
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Roll size:	1200mm
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### 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
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## 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	9322-140
<b>180 degree peel</b>		
Adhesion to SUS: RT, 20min dwell	ASTM D 3330	2100g/25mm
Adhesion to PP : RT, 20min dwell		1000g/25mm
Adhesion to ABS : RT, 20min dwell		1300g/25mm
<b>Static Shear</b>		
Static shear to SUS: 1kgf load, 6.45cm <sup>2</sup> overlap at RT	ASTM D 3654	10,000 minute
<b>Liner Release (25.4mm width)</b>		
Jaw speed: 305mm/min		Max. 80gram
<b>Temperature Resistance</b>		
Short Term (minutes, hours)		100 °C
Long Term ( Days, Weeks)		80 °C
<b>Shelf Life</b>	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 22<sup>nd</sup> floor , Yoido-Dong, Yongdeungpo-Gu, Seoul, Korea. Our fax number is 82-2-786-7429.

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**ISO 9002**

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

**3M**

## Industrial Adhesive & Tape Division

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