



High Performance Double Coated Tapes

9573 • 9586F

Technical Data

August, 1999

Product Description

9573 0.010 in. (0.250 mm) thick Double Coated Film Tape - Paper Liner

9586F 0.0094 in. (0.240 mm) thick Double Coated Film Tape - HDPE Liner

9573 and 9586F double coated film tapes feature a medium-firm acrylic pressure adhesive system. The key characteristics of this adhesive include a combination of high grab and initial adhesion with excellent static shear holding power. The adhesive shows excellent resistance to plasticizer migration, is U.V. & humidity resistant and has the resistance to natural aging associated with acrylic adhesives. The thick adhesive layers also offer a good bond to rough surfaces such as Melamine and fabrics.

Construction

Product	Tape 9573	Tape 9586F
Adhesive Type	Acrylic 340	Acrylic 340
Release Liner	Buff, Densified Kraft Paper	HDPE
Carrier	UPVC 0.002" (0.5 mm)	SOPP 0.0024" (0.06 mm)
Thickness (ASTM D-3652)		
Tape	0.010" (0.25 mm)	0.0094" (0.24 mm)
Liner	0.003" (0.08 mm)	0.0039" (0.10 mm)
Tape Color	Translucent	Translucent
Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 70°F (21°C) & 50% Relative Humidity	

Performance Characteristics

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Adhesion to Stainless Steel AFERA 4001	82 oz/in (90 N/100 mm)	73 oz/in (80 N/100 mm)
Dynamic Shear Resistance	108 lb/in ² (75 N/cm ²)	101 lb/in ² (70 N/cm ²)
Static Shear Resistance	1.0 lb/in ² gives 10,000 min+; @ R.T.	1.0 lb/in ² gives 10,000 min+; @ R.T.
Temperature Performance		
Max: Minutes/Hours	200°F (100°C)	230°F (110°C)
Max: Days/Weeks	158°F (70°C)	158°F (70°C)
Minimum	-20°F (-30°C)	-20°F (-30°C)
Solvent Resistance	Good	Good
UV Light Resistance	Good	Good

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Available Sizes	Available Lengths (subject to minimum order requirements):	
	Standard	60 yds. (54.9 m)
	Maximum in:	
	1/4" to 3/8" widths	108 yds. (98.8 m)
	3/8" and greater	288 yds. (263 m)
	Available Widths (subject to minimum order requirements):	
	Minimum	1/4" (6.35 mm)
Maximum	12" (609.6 mm)	
Normal Slitting Tolerance	± 1/32 in. (0.8 mm)	
Core Size	3.0 in. (76.2 mm)	

Typical Adhesion Properties

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

9573 and 9586F shows excellent resistance to plasticiser migration, are U.V. & humidity resistant and have the resistance to natural aging associated with acrylic adhesives. The thick adhesive layers offers a good bond to rough surfaces, eg Melamine and fabrics.

Typical Peel adhesion of 9573 to common plastics:

Polypropylene	= 36 oz/in (40 N/100 mm)
uPVC	= 82 oz/in (90 N/100 mm)
ABS	= 73 oz/in (80 N/100 mm)
Melamine covered chipboard	= 73 oz/in (80 N/100 mm)

Application Techniques

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact and thus improves bond strength.

To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. A typical surface cleaning solvent is isopropyl alcohol and water. Use proper safety precautions for handling solvents.

Note: Carefully read and follow manufacturer's directions for use and precautionary information when using cleaning solvents.

Ideal tape application temperature range is 70°F to 100°F (21°C to 38°C). Initial tape application to surfaces 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.

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Applications

Tapes 9573 and 9586F are well suited to bonding together a wide variety of similar and dissimilar materials such as wood, metals, glass papers, paints, and many plastics and fabrics.

Typical 9573 applications include:

- Trim attachment
- Point of Sale assembly where heavy duty materials are used
- Heavy basis weight-board splicing eg, Corrugators
- Roller Blind assembly

Typical 9586F applications include:

- Gasketing
- Cable Conducts
- Pipe insulation foam

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Certification/ Recognition

MSDS

3M has not prepared a MSDS for this product which is not subject to the MSDS requirements of the Occupational Safety and Health Administration's Hazard Communication Standard, 29 C.F.R. 1910.1200(b)(6)(v). When used under reasonable conditions or in accordance with the 3M directions for use, the product should not present a health and safety hazard. However, use or processing of the product in a manner not in accordance with the directions for use may affect its performance and present potential health and safety hazards.

TSCA

This product is defined as an article under the Toxic Substances Control Act and therefore, it is exempt from inventory listing requirements.

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550. Address correspondence to: 3M Bonding Systems Division, 3M Center, Building 220-7E-01, St. Paul, MN 55144-1000. Our fax number is 651-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-809-750-3000. In Mexico, phone: 5-728-2180.

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ISO 9002

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

3M

Bonding Systems Division

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