

3M

High Performance Double Coated Tape

9456 Tissue • 9828 Film

Technical Data

August, 1999

Product Description	9456	0.0045 in. (0.11 mm) thick Double Coated Tissue Tape
	9828	0.0035 in. (0.09 mm) thick Double Coated Film Tape

3M™ Double Coated Tapes 9456 and 9828 feature a medium-firm acrylic pressure sensitive adhesive system. The key characteristics of this adhesive include a combination of high initial adhesion and good shear holding power to a wide variety of materials, including many plastics.

Construction	Product	Tape 9456	Tape 9828
	Adhesive Type	Acrylic 340	Acrylic 340
	Release Liner	55# Densified Kraft Paper	55# Densified Kraft Paper
	Carrier	Tissue	0.005" (0.0013 mm) Polyester
	Thickness (ASTM D-3652)		
	Tape	0.0045" (0.25 mm)	0.0035" (0.089 mm)
	Liner	0.003" (0.08 mm)	0.0032" (0.08 mm)
	Tape Color	Translucent	Translucent
	Shelf Life	24 months from date of despatch by 3M when stored in the original carton at 70°F (21°C) & 50% Relative Humidity	

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.

Adhesion to Steel (ASTM D-3330):	55 oz/in (60 N/100 mm)	50 oz/in (55 N/100 mm)
Relative High Temperature Operating Ranges:		
Continuous (day-week):	150°F (65°C)	150°F (65°C)
Short Term (minutes-hours):	180°F (82°C)	180°F (82°C)
Short Term (less than 20 seconds):	400°F (204°C)	–
Relative Solvent Resistance:	Very Good	Good
U.V. Resistance:	Fair	Fair

Available Sizes

Available Lengths (subject to minimum order requirements):	Standard	72 yds. (65.8 m)	250 yds. (228.6 m)
	Maximum in: 1/2" to 54" widths	360 yds. (329 m)	360 yds. (329 m)
Available Widths (subject to minimum order requirements):	Minimum	1/2" (12.7 mm)	1/2" (12.7 mm)
	Maximum	54" (1372 mm)	54" (1372 mm)
Normal Slitting Tolerance	± 1/32 in. (0.8 mm)		± 1/32 in. (0.8 mm)

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

To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Some typical surface cleaning solvents are isopropyl alcohol and or heptane. **Note:** Carefully read and follow the manufacturer's precautions and directions for use when working with 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.

- General Information**
- Tape 9456 has a tissue carrier, which can add dimensional stability to the substrates being bonded. The carrier also makes it easier to handle the tape including slitting and die-cutting.
 - Tape 9828 has a film carrier, which can add dimensional stability to foams and other substrates. The carrier also makes it easier to handle the tape including slitting and die-cutting.

Application Ideas	Tape 9456	Tape 9828
	End Tabbings	General purpose foam laminating
	Bonding fabric to rigid cardboard	
	Attaching foam to plastics	
	Closing CD chipboard mailers	

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.

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 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 product. Given the variety of factors that can affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

Limitation of Remedies and Liability

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



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