



Laminating Adhesives Data Page

FOD # 0334

3M™ 9851 Double-Coated Polyester Laminating Adhesive

Product Construction

Adhesive:	1.5 mils	(38 microns)	#900A “Hi-Tack” Rubber
Carrier:	0.5 mils	(13 microns)	Polyester Film
Adhesive:	1.5 mils	(38 microns)	#900A “Hi-Tack” Rubber
Liner:	3.5 mils	(89 microns)	60# Densified Kraft

Features

- Extremely high-bond strength to most surfaces.
- Excellent versatility for lamination to foam material.
- Excellent dimensional stability with polyester carrier.
- Densified Kraft liner for rotary die cutting.

Applications

- General purpose foam or rubber laminating (54”).
- General purpose lamination of fabricated parts.

Physical Properties

(Typical values - not for specification use)

Adhesion: Dynamic Peel - 90 degree peel (ASTM-D3330 modified),
12"/min (305mm/min), 2 mil sample with aluminum foil backing.

	<u>Surface</u>	<u>Oz./In.</u>	<u>N/100mm</u>
Initial Adhesion	Stainless Steel	92	101
	Aluminum	60	66
	Polycarbonate	81	89
	Polypropylene	63	69
3 Days at Room Temperature	Stainless Steel	102	112
	Aluminum	92	101
	Polycarbonate	85	93
	Polypropylene	76	83

Environmental Performance

Properties defined are based on the adhesion of impervious faceplate materials to a stainless steel test surface.

Bond Build Up:	The adhesive bond increases as a function of time and temperature.
Heat Resistance:	200 degrees F short term.
Low temp. Resistance:	-40 degrees F (-40 degrees C).
Shelf Life:	Product retains its performance properties for two years from date of manufacture if properly stored at room conditions of 72 degrees F (22 degrees C) and 50% relative humidity.
Humidity Resistance:	9851 should not be used in applications requiring exposure to water or high humidity.

Processing

Die-cutting:	Good die-cuttability. Lubricate dies with vanishing oil or similar low lubricants for improved processing.
Roll Laminating:	Use rubber over steel roll set up with moderate application pressure. Make adhesive to substrate contact at nip area only.

Special Considerations

For maximum bond strength, surface should be thoroughly cleaned and dried. A typical cleaning solvent is heptane or isopropyl alcohol. When using cleaning solvents, vanishing oils, or lubricants, consult the manufacturer's Material Safety Data Sheet for proper handling and storage instructions.

Bond strength may be improved with firm application pressure and moderate heat causing adhesive to flow and develop intimate contact with bonding surface.

This adhesive is good for most indoor applications and can be used for outdoor applications if the adhesive is not directly exposed to the environment.

The temperature resistance is somewhat lower than our typical acrylics. Therefore, temperatures above 200 degrees F (93 degrees C) should be avoided.

Avoid contact with plasticized vinyl or plasticized rubber surfaces. Plasticizers will soften the rubber adhesive.

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