English-US

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Technical Data Sheet

3M™ Double Coated Tape 9828PC

Product Details

Regulatory Info/SDS

Product Description

3M™ Double Coated Tapes with 3M™ Adhesive 340 provide a combination of high initial adhesion and good shear holding power to a wide variety of materials, including many plastics and foams. These tapes are available with a thin polyester film or a tissue for dimensional stability and improved handling.

Product Features

• 3M™Adhesive 340 is a medium-firm acrylic that provides a combination of high initial adhesion to a wide variety of materials, including many plastics.
• 3M™Double Coated Tape 9828PC a film carrier, which can add dimensional stability to foams and other substrates. The carrier also provides easier handling during slitting and die-cutting.
• Tape 9828PC has a 74# polycoated kraft liner for moisture stability.

Technical Information Note

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

Typical Physical Properties

Attribute Name	Test Method	Test Condition	Value
Adhesive Type			340 Acrylic
Adhesive Carrier			Clear PET (Polyester)
Adhesive Thickness		Faceside	0.051 mm (2 mil) [1]
Carrier Thickness			0.013 mm (0.5 mil)
Adhesive Thickness		Backside	0.038 mm (1.5 mil) [2]
Total Tape Thickness	ASTM D3652		0.084 mm (3.3 mil)
Liner			PCK
Liner Thickness			0.1 mm (4.2 mil)

[1] Faceside adhesive is on the interior of the roll, exposed when unwound and liner removed.

[2] Backside adhesive is on the exterior of the roll, exposed when liner is removed.

Typical Performance Characteristics

Substrate: Stainless Steel
Temperature: 23 °C (73 °F)
Dwell Time: 72 h
Backing: 2 mil Aluminum Foil

Attribute Name	Test Method	Value
180° Peel Adhesion	ASTM D3330	9.9 N/cm (91 oz/in) [1]

[1] 304 mm/min (12 in/min)

90° Peel Adhesion

Backing: 2 mil Aluminum Foil
Test Method: ASTM D3330

Dwell Time	Temperature	Substrate	Value
15 min	23 °C (73 °F)	Stainless Steel	6.9 N/cm (63 oz/in) [1]
72 h	23 °C (73 °F)	ABS	5.7 N/cm (52 oz/in) [1]
72 h	23 °C (73 °F)	Polycarbonate (PC)	7.3 N/cm (67 oz/in) [1]
72 h	23 °C (73 °F)	Polypropylene (PP)	3.5 N/cm (32 oz/in) [1]
72 h	70 °C (158 °F)	Stainless Steel	10 N/cm (94 oz/in) [1]

[1] 304 mm/min (12 in/min)

Static Shear

Test Method: ASTM D3654

Temperature	Test Condition	Value
23 °C (73 °F)	1000 g	31 min [1]
70 °C (158 °F)	500 g	3 min [1]

[1] 13 x 25 mm (0.5 x 1 in) sample area, test terminated at 10,000 minutes

Attribute Name	Value
Short Term Temperature Resistance	82 °C (180 °F) [1]
Long Term Temperature Resistance	71 °C (160 °F) [2]

[1] Short Term (minutes, hour)
[2] Long Term (day, weeks)

Attribute Name	Value
Additional Test notes	Not recommended for high temperature, high shear performance applications. For such applications, please refer to the 3M™ Adhesive 350 and 300MP product families.

Handling/Application Information

Application Examples

- General purpose foam lamination
- General purpose lamination for fabricated parts.

Application Techniques

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure helps develop 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 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.

Application Equipment

To apply adhesives in a wide web format, lamination equipment is required to ensure acceptable quality. To learn more about working with pressure-sensitive adhesives please refer to technical bulletin, Lamination Techniques for Converters of Laminating Adhesives (70-0704-1430-8).

For additional dispenser information, contact your local 3M sales representative, or the toll free 3M sales assistance number at 1-800-362-3550.

Storage and Shelf Life

Store under normal conditions of 16° to 27°C (60° to 80°F) and 40 to 60% relative humidity in the original packaging, out of direct sunlight. When storing rolls, lay flat in a horizontal position with release treated wafers between the rolls. For best performance, use this product within 24 months from date of manufacture.

Available Sizes

Attribute Name	Width	Value
Core Size (ID)		76.2 mm (3 in)
Maximum Length	1/2 to 54 in widths	329 m (360 yd)
Normal Slitting Tolerance		±0.08 mm (±1/32 in)

Recognition/Certification

MSDS:3M has not prepared a MSDS for these products which are 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, these products should not present a health and safety hazard. However, use or processing of the products in a manner not in accordance with the directions for use may affect their performance and present potential health and safety hazards.
TSCA: These products are defined as articles under the Toxic Substances Control Act and therefore, are exempt from inventory listing requirements.

Automotive Disclaimer

Select Automotive Applications:
This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

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ISO Statement

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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