

Semi-Structural Acrylic Foam Tape

#9259

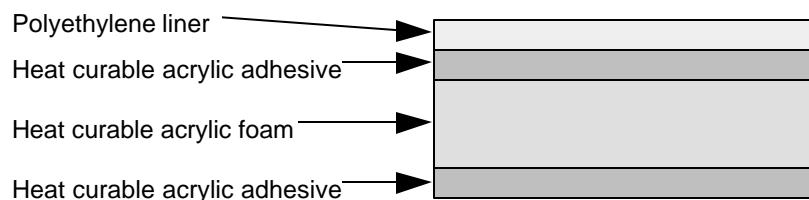
General Information :

The Semi-Structural Acrylic Foam Tapes #9259 is different from the pressure sensitive double-coated Acrylic Foam Tape. #9259 are the heat curable foam tapes that the adhesive and foam harden after heating and show a very high tape strength. Since #9259 initially perform a high initial adhesion and have a good wettability before heating, the tape application procedures are easy as the pressure sensitive Acrylic Foam Tape.

Features :

- Provides a good workability and initial adhesion before heating as the pressure sensitive tape.
- Performs a very high tape strength after heating, and can be used for the semi-structural bonding usage.
- Since a conventional paint oven can be used for the tape heating, an additional heating equipment doesn't need.
- Excels in a variety of weather, solvent and high temperature resistance.
- Provide superior property for anti-plasticizer migration from PVC sealer

Configuration :



Tapes :

| Tape No. | Tape | | Liner | | |
|----------|-----------|-------|-----------|--------|--------------|
| | Thickness | Color | Thickness | Color | Material |
| #9259 | 1.0 | White | 0.15mm | Orange | Polyethylene |

Usage :

- * Helping bonding for a spot welding, * Bonding the panels
- * Bonding the clips for the window molding fix, roof molding fix and glass line molding fix, etc.

Test results :

| | | | |
|---|----------------|----------------------|------------|
| Items | | | #9259 |
| Color | | | White |
| Thickness (mm) | | | 1.0 |
| 180 Peeling Strength N/25mm (kgf/25mm) | Before heating | Initial state | 38.0 |
| | Before heating | Initial state | 0.8 (8) |
| Shear strength MPa (kgf/sqcm) | | Normal state | 8.5(87) |
| | After heating | Heat aging | 10.8 (110) |
| | | Warm water immersion | 9.3 (95) |

*Heating condition : 140 deg.C * 20min. keep

Test methods :

(1) Thickness : Measured by a dial thickness gauge (in accordance with JIS Z0237)

(2) 180° peel strength : Peel off the tape in 180° direction and measure the adhesion to the cation electro-deposition painted plate with a tensile strength test machine after the exposures in the following conditions.

* Initial state : 23° x 20 min. * Tape size : 25 mm width, * Peeling speed : 50 mm/min.

(3) Shear strength : Measure the strength needed to shear to the cation electro-deposition painted plates with a tensile strength test machine after the exposures in the following conditions.

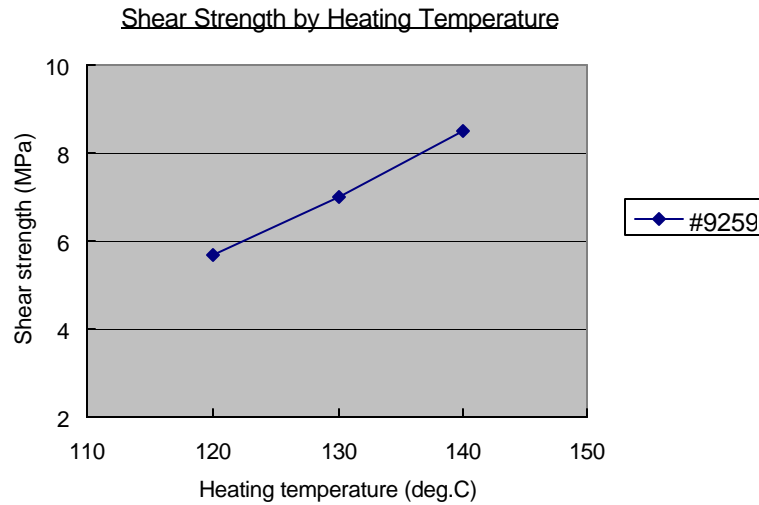
a) Initial state : 23° x 20 min.

b) Normal state : 23° x 24 hrs.

c) Heat aging : b) 80° x 240 hrs. ? b)

d) Warm water immersion : b) 40° water x 240 hrs. ? b)

Shear strength by heating temperature :



*Heating condition : 20 min keep in settled temperature conditions.

Notes :

(1) The tape performance gradually deteriorates under a room temperature storage because of a heat reactive type. Therefore, please be careful of the storage conditions, i.e. the temperature and humidity.

- Recommended storage conditions :

* In a refrigerator (at 5°) ----- within 3 months

* Under a room condition (at 23° , 60%RH) ---- within 1 month

(2) A liner shows a very easy removal at a low temperature.

If the liner removal strength is not comfortable, a special liner can be used after testing.

(3) The data cited in the tables is the actual test data, and not a guaranteed number.

Please test to see if it can work well for the application considered before using.