

# 3M™ Structural Bonding Tape 9259

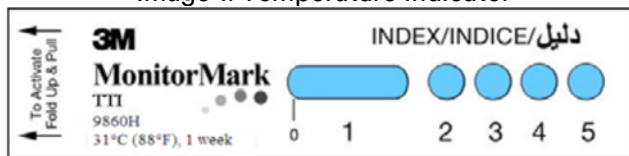
## Clip Storage and Handling Guide

The following guideline outlines the proper storage and handling of clips attached with 3M™ Structural Bonding Tape (SBT). Clips attached with 3M SBT must be stored in a controlled environment to maintain optimal adhesion.

### Shipping

- 3M recommends that clips are shipped in trays.
- Being a heat reactive product, 3M SBT 9259 is sensitive to temperature exposure. To minimize the risk of prolonged heat exposure, 3M™ MonitorMark™ Time Temperature Indicators are included with each shipment. MonitorMark indicators signal when a threshold temperature has been exceeded and provide an easy-to-read visual signal to estimate the amount of time the product has spent above the threshold temperature. A MonitorMark indicator has a high contrast indicator that turns blue as a result of exposure above a threshold temperature. The indicator is irreversible, providing a permanent record of temperature exposure even after temperatures return to acceptable levels.
- As a default, clips should not be used if the last window (circle 5) of the MonitorMark indicator has completely changed color, unless reviewed with a 3M technical representative. The need to set a different limit may exist depending on the end user situation. This adjustment should be based on clip performance requirements and determined on an individual basis.

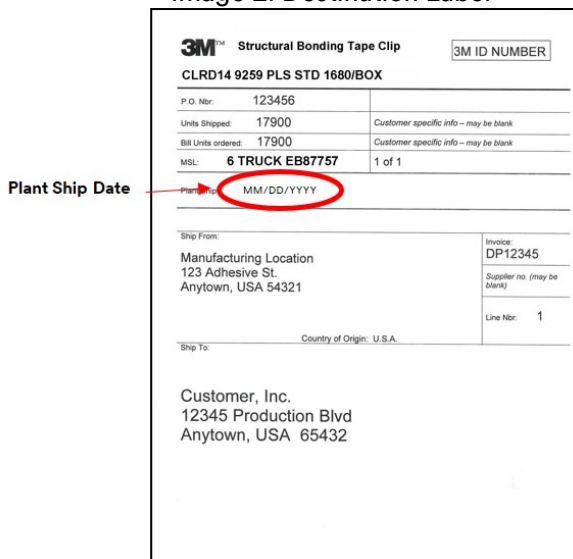
Image 1: Temperature Indicator



### Storage and Shelf Life

The shelf life is measured starting from the date that the material is shipped from 3M to the customer. The “Plant Ship Date” can be found on the destination label, which is located on the outside of the pallet or tote. Image 2 is an example of a destination label.

Image 2: Destination Label



## Storage and Shelf Life (continued)

The shelf life of 3M SBT is dependent on temperature and humidity over time. Shelf life will decrease with higher temperatures and/or higher humidity. When the tape is stored outside of these guidelines, the tape gradually reacts and the performance of the tape is decreased. Please see Table 1 for the maximum shelf life at various storage conditions.

Table 1: 3M™ Structural Bonding Tape 9259 Shelf Life at Various Storage Conditions

Storage Condition	Shelf Life
≤23°C and ≤50%RH	1 month
≤5°C or less	3 months

Please note:

- If used in elevated temperatures or humid environments, such as a paint shop, a refrigerator (23°C [73.4°F]) is recommended for storage of the taped clips. Return un-used taped clips to the refrigerator every day.
- Pay attention to humidity in storage. When the tape is exposed to a high humidity condition (above 50% RH), the tape will absorb moisture, causing the tape to expand in thickness and/or detach from the paint during paint bake.
- Do not use clips that have exceeded their expiration date. 3M highly recommends using the “first in, first out” stock rotation method to help prevent quality problems due to expired material.
- During line shut-downs, clips that will expire should be disposed of and all remaining clips stored in a refrigerator. Uncured clips should not be left on vehicles.

## Handling

- The handling of packaged parts should be minimized in cold storage. Under cold storage conditions, the tackiness of the adhesive is reduced, making it easier for the parts to become dislodged from the liner if the packaging is dropped or similarly mishandled.
- If a tray is dropped, it should be inspected for part misalignment prior to being used in production. At a minimum, the tray should be labeled that it was dropped/mishandled.

## Safety and Regulatory

Observe proper handling precautions as outlined in the Safety Data Sheet (SDS), which is available on request. The website address for 3M SDSs is [www.3M.com/msds](http://www.3M.com/msds).

## Contact Information

The information provided in this technical document is intended as a guide for these products. For more information or help in selecting a 3M product, please contact your 3M technical service representative or call 1-800-328-1684.

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