



Structural Bonding Tape 9259

Technical Data Sheet

November 2008

Supersedes Technical Data Sheet dated August 2008

General Description 3M™ Structural Bonding Tape (SBT) 9259 is formulated for bonding of mechanical attachment clips to vehicle bodies. 3M SBT 9259 may be used to attach plastic or metal mechanical clips to e-coat, sealer or primer. It is applied as a pressure-sensitive tape, and then heat-cured to develop structural strength. The adhesive and foam of the tape are both made from epoxy-modified acrylic material.

Key Features

Design flexibility

- Used in a wide variety of roof ditch and body sheet metal designs
- Used with a wide variety of plastic and steel clip designs
- Eliminates the need to stamp holes or form upturned flanges in sheet metal

Ease of handling

- Pre-applied to the clips
- Pressure sensitive adhesive holds clip position prior to the curing process
- Cures to full strength in the OEM paint process
- Reduces the need to finesse sealer

Additional advantages

- Helps eliminate weld splash and risk of rust related to T-studs
- Helps eliminate alignment problems related to upturned flanges and T-studs
- Improved application time versus liquid adhesive
- Provides high retention strength, while still allowing for serviceability when used in conjunction with a mechanical clip
- Designed to cure with paint shop conditions

Material

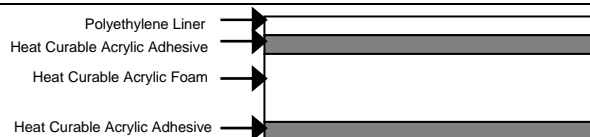
- Excellent performance due to less degradation from plasticizer migration when using pumpable sealers

Shelf Life

One month at 23°C (73.4°F) and RH 50% from receipt of material. Three months at 5°C (41°F) from receipt of material. Shelf life will decrease with higher temperatures.. Therefore, 3M recommends using a refrigerator to store material when not in use.

3M highly recommends using the “first in, first out” stock rotation method to help prevent quality problems due to expired material. For further information, please see 3M™ Structural Bonding Tape (SBT) Clip Handling Guidelines.

Product Construction (Uncured Tape)



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Physical Properties	Product Number	Tape	
		Thickness	Color
	9259	1.0 mm	White

Cure Conditions Designed to cure with paint shop conditions. 30-minute hold at 130°C (266°F) minimum. Maximum temperature and time should not exceed 180°C (356°F) for 90 minutes for 3M SBT; however, the maximum temperature and time may be lower depending on the clip material.

Health and Safety Information Read all health hazards, precautionary and first aid statements found in the Material Safety Data Sheet (MSDS) and/or product label prior to handling or use. MSDSs can be found at www.3m.com/msds.

Performance Please contact your 3M sales representative or technical service representative for testing and/or performance data, or for any additional information.

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75-3470-8839-7
Printed in U.S.A.



ISO/TS 16949:2002
File No. A3904