3M™ Double Coated Tapes provide thin bonding solutions for Silicone and other specialty hard-to-bond substrates for a variety of applications.

Proprietary single liner technology used in 3M™ Double Coated Tape 96042 and 3M™ Adhesive Transfer Tape 91022 reduces liner waste, improves processing and extends product shelf life.

3M™ Double Coated Tape 9731 has a unique value as solutions for Silicone bonding to a variety of high surface energy and low surface energy substrates.
3M™ Laminating Adhesives for Silicone Bonding
3M™ Adhesive Transfer Tape 91022 & 3M™ Double Coated Tape 96042

Bond difficult substrates with...
Silicone Pressure Sensitive Adhesive

- High shear and peel strength for hard-to-bond substrates such as Silicone rubbers and foams; polypropylene, polyethylene and other Low Surface Energy (LSE) materials and more on contact without priming
- Reliable solvent and high temperature resistance up to 500°F (260°C) for 3M™ 91022; 3M™ 96042 performs in temperatures up to 300°F (149°C) due to a PET Carrier for dimensional stability
- Good damping performance over a broad temperature range
- 12-month shelf life for extended usability and reduced waste
- Reduce liner waste by 50% and save time and cost of second liner removal and disposal
- Stable liner release over time (reference chart on back page)
- PET film liner is tear and moisture resistant, and offers improved processing and precise tooling for higher yields

Peel Strength [oz/inch] Comparative Evaluation

For more product information, view back side of brochure.
3M™ Double Coated Tapes 9731

Bond Silicone to HSE & LSE substrates
- Silicone/Acrylic differential double coated tape construction offers excellent initial tack and adhesion
- Variety of product constructions and calipers provides flexibility to specify the best product with the best fit
- Polyester carrier provides dimensional stability and improved handling with ease of die cutting and lamination
- PET and PCK double liners for easy handling, moisture stability and liner removal
- Excellent high temperature, UV and solvent resistance

Peel Adhesion [oz/inch] of 9731

Application Ideas

Automotive, Transportation & Specialty Vehicle • Appliance Medical & Electronic Devices • General Industrial

- **Gasket Attachment**: Best in class adhesion to Silicone-based substrates provides robust product performance. Primerless bonding improves productivity and yields.

- **Keypad Attachment**: Higher initial and aged adhesion to Silicone provides bonding to medical-grade Silicone substrates and quick attachment for improved processing.

- **Reducing/Eliminating buzz/squeak/rattle**: Best in class adhesion to difficult substrates for Silicone foam attachment. Primerless bonding provides a primary bonding solution with no mess.

- **High Temperature Applications**: Best in class adhesion to Silicone-based substrates provides robust product performance. Primerless bonding improves productivity and yields.

- **General Purpose Silicone Foam Attachment**: Performance on flexible silicone materials provides reliable bonding and improved productivity through processing efficiency.

- **Temporary Bond for Processing Difficult Substrates**: Best in class adhesion to difficult substrates, including varnished leather & Silicone products increases productivity and yield and provides excellent convertability.
Product Use:
Many factors beyond 3M’s control and uniquely within user’s knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user’s method of application.

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SiliconebondingV3

Product Selection Guide for Bonding Silicone Substrates

<table>
<thead>
<tr>
<th>Product Number</th>
<th>Product Construction</th>
<th>Primary Liner</th>
<th>Adhesive I Type</th>
<th>Carrier</th>
<th>Adhesive II Type</th>
<th>Secondary Liner</th>
<th>Total Tape Caliper [not including liner]</th>
<th>Size Available</th>
</tr>
</thead>
<tbody>
<tr>
<td>91022</td>
<td>ATT</td>
<td>White PET Film [2mil or .05mm]</td>
<td>Silicone 2mil [.05mm]</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>2mil [.05mm]</td>
<td>48”x60 yards*</td>
</tr>
<tr>
<td>96042</td>
<td>DCT</td>
<td>White PET Film [2mil or .05mm]</td>
<td>Silicone 2mil [.05mm]</td>
<td>Clear PET Film 1mil [.025mm]</td>
<td>Silicone 2mil [.05mm]</td>
<td>—</td>
<td>5mil [.127mm]</td>
<td>48”x60 yards*</td>
</tr>
<tr>
<td>5053</td>
<td>Secondary Liner</td>
<td>Clear PET Film [3mil or .076mm]</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>46”x360 yards*</td>
</tr>
<tr>
<td>9731</td>
<td>DCT</td>
<td>54# Tan PKC Paper [5.4mil or .137mm]</td>
<td>Clear PET Film 1mil [.025mm]</td>
<td>Silicone 2.9mil [.074mm]</td>
<td>Clear PET Film 3mil or .076mm</td>
<td>5.5mil [.140mm]</td>
<td>48”x60 yards*</td>
<td></td>
</tr>
</tbody>
</table>

Note: The caliper listed is based on a calculation from manufacturing controlled adhesive coat weights using a density of 1.110 g/cm³. Remember that our products are always available in metric dimensions as well.

Product Selection (construction details)

- **Silicone Substates**: Silicone Sponge, Silicone Foam, Silicone Film, Silicone Rubber, Medical Grade Silicone Rubber
- **Secondary Substates**: Silicone Sponge 91022 or 96042, 9731, Silicone Foam 91022 or 96042, 9731, Silicone Film 91022 or 96042, 9731, Silicone Rubber 91022 or 96042, 9731, Medical Grade Silicone Rubber 91022 or 96042, 9731

3M™ Adhesive Transfer Tape 91022 Liner Release

- **Silicone Sponge**: 91022 or 96042, 9731
- **Silicone Foam**: 91022 or 96042, 9731
- **Silicone Film**: 91022 or 96042, 9731
- **Silicone Rubber**: 91022 or 96042, 9731
- **Medical Grade Silicone Rubber**: 91022 or 96042, 9731

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