

# 3M Double Coated Non-woven Tapes

## 9480, 9480B

page 1 of 3

Technical Data

August, 2011

**Product Description** 3M™ 9480 and 9480B are non-woven tape coated on both side with a high adhesion acrylic pressure sensitive adhesive. This tape is protected by a polycoated white paper release liner. 3M™ High Performance Acrylic Adhesive provides high bond strength to most surfaces, especially on low surface energy materials such as Polypropylene and plastics.

**Application Idea**

- General purpose joining and mounting application at indoor and outdoor use
- Holding and bonding of electronic devices
- Electronic Components Bonding / Attachments
- Appliance parts Bonding / Attachments
- Foam lamination

| Construction    | Product  |       |
|-----------------|--|-------|
|                 | 9480   | 9480B |
| Adhesive Type   | High Performance Acrylic adhesive                          |       |
| Tape Thickness  | 0.14mm (+/- 0.02mm)  |       |
| Tape Color      | Off-White  | Black |
| Carrier         | Non-woven  |       |
| Release Liner   | Silicone treated Poly Coated Kraft (White 3M logo printed) |       |
| Liner Thickness | 0.115mm (+/- 0.02mm)                                       |       |

**Typical Physical Properties and Performance Characteristics**

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

| Product                | 9480/ 9480B   |
|------------------------|---------------|
| 180 ° Peel Strength    | <u>kgf/in</u> |
| ASTM D-3330            |               |
| Peel speed : 305mm/min |               |
| Initial                |               |
| SS                     | 1.6           |
| PC                     | 1.6           |
| Acrylic                | 1.2           |
| ABS                    | 1.8           |
| PP                     | 1.6           |

# 3M Double Coated Non-woven Tapes

|                               |   |
|-------------------------------|---|
| RT 72hrs                      |   |
| SS                            | 1.8   |
| PC                            | 1.7   |
| Acrylic                       | 1.4   |
| ABS                           | 1.8   |
| PP                            | 1.8   |
| <hr/>                         |   |
| Dynamic Shear Strength        | <u>Kgf/ Inch<sup>2</sup></u>  |
| ASTM D-1002                   |   |
| Peel speed :12.7mm/min        |   |
| Initial                       |   |
| SS                            | 12  |
| RT 72hrs                      |   |
| SS                            | 15  |
| <hr/>                         |   |
| Static Shear Strength         |   |
| ASTM D-3654 modified –        |   |
| (1 inch <sup>2</sup> ) on SUS |   |
| 1000gram at 72°F(22°C)        | >10,000min  |
| <hr/>                         |   |
| Relative High Temperature     |   |
| Operating Ranges :            |   |
| Long Term(days, weeks)        | 158°F(70°C)   |
| Short Term(minutes, hours)    | 250°F(120°C)  |
| <hr/>                         |   |
| Release Level                 | 25 g/inch   |
| ASTM D-5375                   |   |
| <hr/>                         |   |
| Shelf Life                    | 12months from date of manufacture when stored in original cartons at room temperature & 50% RH  |
| <hr/>                         |   |
| <b>Application Technique</b>  | <ul style="list-style-type: none"> <li>• Bond strength is dependent upon the amount of adhesive to surface contact developed. Firm application pressure helps develop better adhesive contact and improve bond strength.</li> <li>• To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Typical surface cleaning solvents are isopropyl alcohol and water (rubbing alcohol) or heptane.</li> </ul> <p><b>Note</b> : Be sure to follow manufacturer’s safety precautions and directions for use when using solvents.</p> <ul style="list-style-type: none"> <li>• 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.</li> </ul> |

# 3M Double Coated Non-woven Tapes

page 3 of 3

---

## For Additional Information

To request additional product information or to arrange for sales assistance, call 82-2-3771-4097. Address correspondence to : 3M Industrial Adhesives & Tapes Division, 3M Korea LTD, Hana Daetoo Securities BLDG 22<sup>nd</sup> Floor, Yoido Dong, Yongdeungpogu, Seoul, Korea. Our fax number is 82-2-786-7429

---

## Important Notice

3M MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M IATD product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M IATD product. Given the variety of factors that can affect the use and performance of a 3M IATD product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M IATD product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

---

## Limitation of Remedies and Liability

If the 3M product is provided to be defective, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the theory asserted, including negligence, warranty, or strict liability.

---

**ISO 9002**

This Tape & Adhesives Organization product was manufactured under a 3M quality system registered to ISO 9002 standards.



Industrial Adhesives & Tapes Division

www.3M.com