



Low VOC Double Coated Tape 9599

Technical Data

March, 2008

Product Description 3M™ Low VOC Double Coated Tape 9599 has a non-woven tissue carrier with acrylic adhesive on both sides. It provides high adhesion to a wide variety of materials and is suitable for automobile interior applications

Product Construction	Adhesive	Carrier	Liner	Tape Thickness	Liner Thickness
	Acrylic	Non-woven tissue	Paper with 3M logo	5.0 mils	4.5 mils

Features

- VOC analysis (micro g / pcs): measured at external organization which is approved by AOEM.

Formaldehyde:	0.07	Sample Size: 80mm x 100mm/pcs Dwell Temp.: 149°F (65°C) Dwell Time: 120 minutes Gas trapping volume: 4L with Tedlar bag Absorption pipe: Tenax-TA, DNPH cartridge
Acetaldehyde:	0.07	
Toluene:	0.11	
Xylene:	0.02	
Ethylbenzene:	ND	
Stylene:	ND	
Tetradecane:	0.03	
Dibutyl phthalate:	ND	
Di-2-ethylhexyl phthalate:	ND	

Absorb air in tedlar bag with each absorption pipe after heating and measure with gas chromatograph mass spectrometer or high speed liquid chromatograph.

Available Sizes

Core Size:	3 in.
Available Widths:	1 - 40 in.
Available Lengths:	10 - 100 yds.
Normal Slitting Tolerance:	1/16 in.
Precision Slitting Capability:	-0 to +1/16

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Typical Peel Adhesions

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

Peel Adhesion (ASTM D3330 - Modified for 90°)

Surface:	Oz./in.	Faceside
Stainless Steel:	Initial	70
	72 Hr. Room Temp.	96
ABS:	Initial	57
	72 Hr. Room Temp.	91
Polypropylene:	Initial	46
	72 Hr. Room Temp.	57

Application Techniques

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. 15 psi momentary pressure is typical.

Ideal tape **application temperature** range is 70°F to 100°F (21°C to 37°C). Initial tape application to surface at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once applied, low temperature holding is generally satisfactory. Surfaces should be **clean and dry** prior to bonding. We recommend a final surface cleaning with a mixture of 50% isopropyl alcohol and water.

Note: Carefully read and follow the manufacturer's precautions and directions for use when using cleaning solvents.

Storage

Store under normal conditions of 70°F (21°C) and 50% relative humidity in the original carton.

Shelf Life

To obtain best performance, use this product within 12 months from date of manufacture.

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Product Use

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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.



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