



Medium/High Tack Double Coated Film Tape

9425HT

Temporary Technical Data

April, 2001

Product Description **3M tape 9425HT** 0.005 in. (0.13 mm) thick medium/high tack double coated film tape. 9425HT features a high tack adhesive on the face side (exposed side) and a removable, medium tack adhesive on the back side (lined side). The polyester film carrier provides dimensional stability, improved handling with ease of die cutting and laminating as well as higher temperature resistance.

Construction	Product	Tape 9425HT
	Adhesive Type:	
	Face side	220
	Back side	400
	Release Liner:	58# Polycoated Kraft
	Carrier:	0.001" Clear Polyester
	Thickness: (ASTM D-3652)	
	Tape	0.005" (0.13 mm)
	Liner	0.004" (0.10 mm)
	Tape Color:	Clear
	Shelf Life:	24 months from date of dispatch by 3M when stored in the original carton at 70°F (21°C) & 50% Relative Humidity.

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.**

Adhesion to stainless steel: (ASTM D3330)	
Face side	45 oz./in. (49 N/100 mm)
Back side	12 oz./in. (13 N/100 mm)
Relative High Temperature Operating Ranges:	
Continuous (day-week)	200°F (93°C)
Short Term (minutes-hours)	250°F (121°C)
Relative Solvent Resistance:	Excellent
U.V. Resistance:	Excellent

Available Sizes	Available Lengths (subject to minimum order requirements):	
	Maximum in:	
	1/2" to 63/64" widths	180 yds. (166 m)
	1" to 50" widths	432 yds. (395 m)
	Normal Slitting Tolerance:	± 1/32 in. (0.8 mm)
	Core Size (ID):	3.0 in. (76.2 mm)

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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.

To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Some typical surface cleaning solvents are isopropyl alcohol or heptane. **Note:** Carefully read and follow the manufacturer's precautions and directions for use when working with solvents.

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.

General Information

The tape is wound so the medium-tack ("removable") adhesive is on the backside (exterior of roll) and the high-tack ("permanent") adhesive is on the face side (interior of roll). This means a liner covers the medium-tack adhesive and the high-tack adhesive is exposed.

A thin polyester carrier in the products provides dimensional stability and improved handling with ease of die cutting and lamination as well as higher temperature resistance.

Moisture stable liner improves processing of parts and ease of liner removal.

The medium-tack adhesive allows removal from many foils and films without adhesive residue. In many cases, the tape can be reused numerous times.

Application Ideas

- Reclosable bags or envelopes.
- Core starting and end tabbing of papers, foils and films.
- Novelty items.
- Removable stickers and labels.
- Point of purchase displays.
- Mounting promotional items.
- Removable/changeable advertisements.
- Temporary hold for protective packaging materials, such as foam or cardboard.

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550 or visit www.3M.com/bonding. Address correspondence to: 3M Bonding Systems Division, 3M Center, Building 220-7E-01, St. Paul, MN 55144-1000. Our fax number is 651-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-809-750-3000. In Mexico, phone: 5-728-2180.

Certification/Recognition

- **MSDS:** 3M has not prepared a MSDS for this product which is not subject to the MSDS requirements of the Occupational Safety and Health Administration's Hazard Communication Standard, 29 C.F.R. 1910.1200(b)(6)(v). When used under reasonable conditions or in accordance with the 3M directions for use, the product should not present a health and safety hazard. However, use or processing of the product in a manner not in accordance with the directions for use may affect its performance and present potential health and safety hazards.
- **TSCA:** This product is defined as an article under the Toxic Substances Control Act and therefore, it is exempt from inventory listing requirements.

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 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 product. Given the variety of factors that can affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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ISO 9002

This Bonding Systems Division product was manufactured under a 3M quality system registered to ISO 9002 standards.



Bonding Systems Division

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