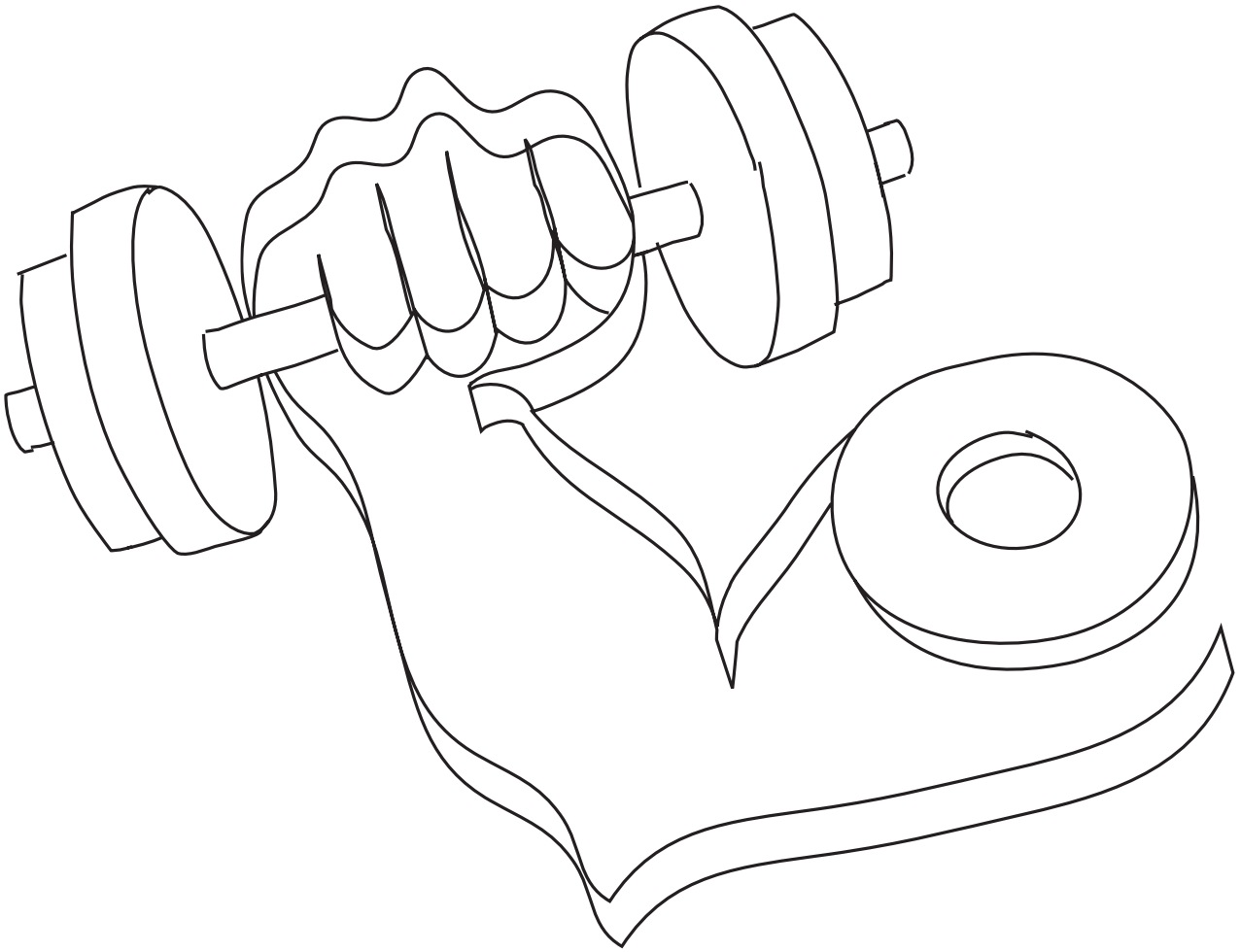


Technical Adhesive Tapes



**Superior-Performance Adhesive Tapes
Series 9000 SPT**

Coroplast
Keeping you connected.

Processing instructions

Processing instructions for adhesive tapes

General information

The following processing instructions are provided for the user with the relevant information for processing the adhesive tapes. Please do not hesitate to contact us in case your specific application requires additional information.

Processing temperature

To ensure best bonding conditions, the surface and ambient temperature should be between +15°C to 30°C (60°F and 85°F). At lower temperatures the adhesive will not develop maximum contact with the substrate. This does not apply to special types of adhesives which may be applicable at low temperatures.

Surface cleaning

To achieve an optimum bond strength, the bonding surfaces must be dry, free of dust, release agents and oil. Do not touch the bonding surface. A suitable solvent such as isopropanol should be used to clean the surfaces. Following solvent manufacturer's safety instructions is urgently required when using solvents. A lint-free cleaning cloth is recommended and should only be used one time.

Surface condition

Good bonds are achieved on smooth surfaces. Rough surfaces require a thicker layer of adhesive. Materials usually less critical to bond: metal, glass, PVC, polycarbonate. Materials usually critical to bond: PP and PE, powder-coated surfaces, rubber, plastics with lubricants, plasticised PVC and silicones.

Bonding pressure

Pressure should be applied onto the adhesive tape by using a roller or a squeegee.

Loading

Designs that cause delamination stress or peel stress should be avoided. Shear stress and tensile stress have to be distributed over the entire bonded area. Mechanical stress at the end of the bonded components should also be avoided. The adhesive bond should be load-free for at least 24 hours.

The Coroplast Series 9000 Superior-Performance Tapes are designed for use in high demanding applications.

They won't budge an inch! Coroplast Series 9000 high-performance adhesive tapes are characterised by their homogeneous, uniformly acrylic adhesive composition. As a result, they are far superior in performance to common double-sided foam adhesive tapes.

Whether in industrial applications or in the automotive sector, using Coroplast Series 9000 Tape-Systems is a reliable and cost-saving method to reach best bonding of a wide range of materials. Coroplast high-performance adhesive tapes can also be used in many cases to replace mechanical joining methods that utilise screws, rivets, spot welds or solder.

Coroplast Series 9000 SPT is as versatile as its fields of application

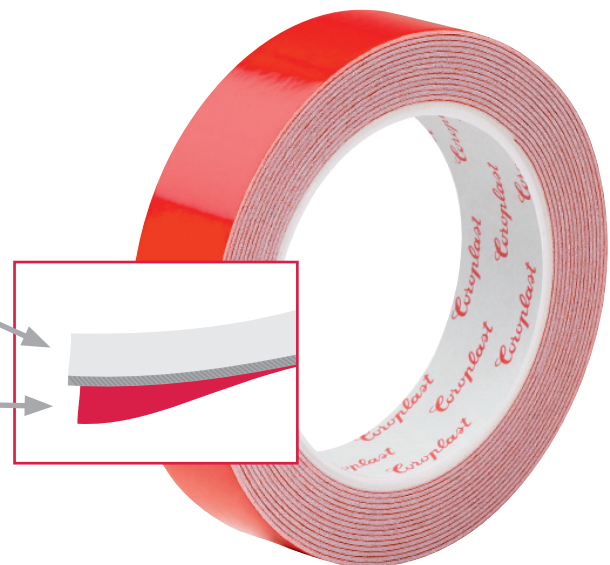
- Automotive industry
- Aerospace and other transportation industries
- Windows and wall panelling
- Advertising and displays
- Furniture
- Electronics
- White goods

Typical applications

- Bodyside mouldings
- Mounted parts, car mirrors
- Emblems, decorative parts and lettering
- Weatherstrips
- Sound and vibration dampening
- Window systems, blinds, brackets
- Reinforcement profiles, signs, seals
- Panels

Adhesive tape composition (diagram)

1. High cohesive self-adhesive and homogeneous acrylic composition (in various thicknesses and colours)
2. Polyethylene or siliconised paper-liner



Aspects of the Series 9000 SPT performance profile

- Excellent adaptability to the bonding component, even on rough surfaces
- High stress absorption because of its visco-elastic behaviour
- Good shock resistance
- Very good adhesion-/cohesion-balance
- High ageing- and weathering-resistance
- Good temperature and media resistance
- Good resistance to plasticisers
- Excellent final bond strength

Product overview

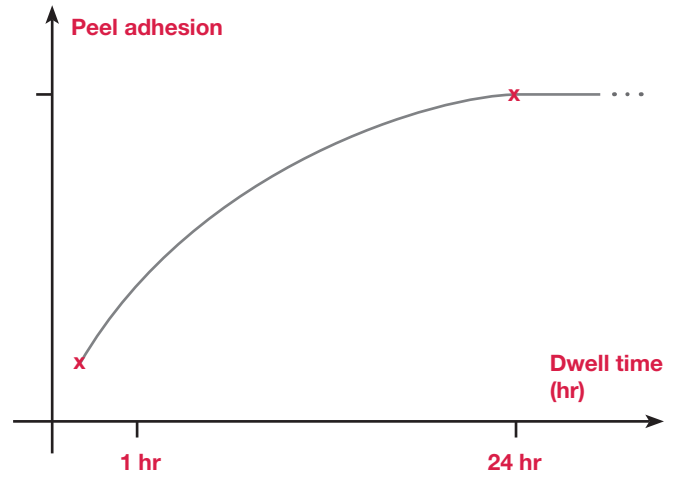
Properties	Coroplast 9005 SPT	Coroplast 9010 SPT	Coroplast 9015 SPT	Coroplast 9108 SPT	Coroplast 9111 SPT	Coroplast 9206 SPT	Coroplast 9211 SPT	Coroplast 9306 SPT	Coroplast 9311 SPT	Coroplast 9410 SPT
Thickness (mm)	0.5	1.0	1.5	0.8	1.1	0.6	1.1	0.6	1.1	1.0
Colour	Transparent	Transparent	Transparent	Grey	Grey	Grey	Grey	White	White	Translucent black
Liner	PE-film, red	PE-film, red	PE-film, red	PE-film, red	PE-film, red	PE-film, red	PE-film, red	PE-film, red	PE-film, red	PE-film, red
Density (kg/m ³)	1,000	1,000	1,000	800	800	800	800	800	800	1,000
Adhesion to steel (N/25 mm)										
10 min.	25	25	29	25	25	34	34	25	25	25
24 hr	36	39	37	30	36	34	44	25	40	39
Static shear (min.) 100 mm ² /0.5 kg										
RT	2,000	1,000	1,000	> 10,000	> 10,000	> 10,000	> 10,000	> 10,000	> 10,000	1,000
70°C	400	100	30	> 10,000	> 10,000	> 10,000	1,000	> 10,000	4,000	100
Tensile strength (N/25 mm)	10	14	29	14	16	8	17	9	19	14
Elongation at break (%)	750	750	750	600	550	550	600	550	600	750

Coroplast products are the result of thorough research. They reflect the state of the art. We have compiled this information and the application recommendations to the best of our knowledge. They are, however, provided without liability. The figures listed in the table above shall not be used in specifications. Advanced tests shall be performed before to confirm product suitability. Product samples may deviate from the original.

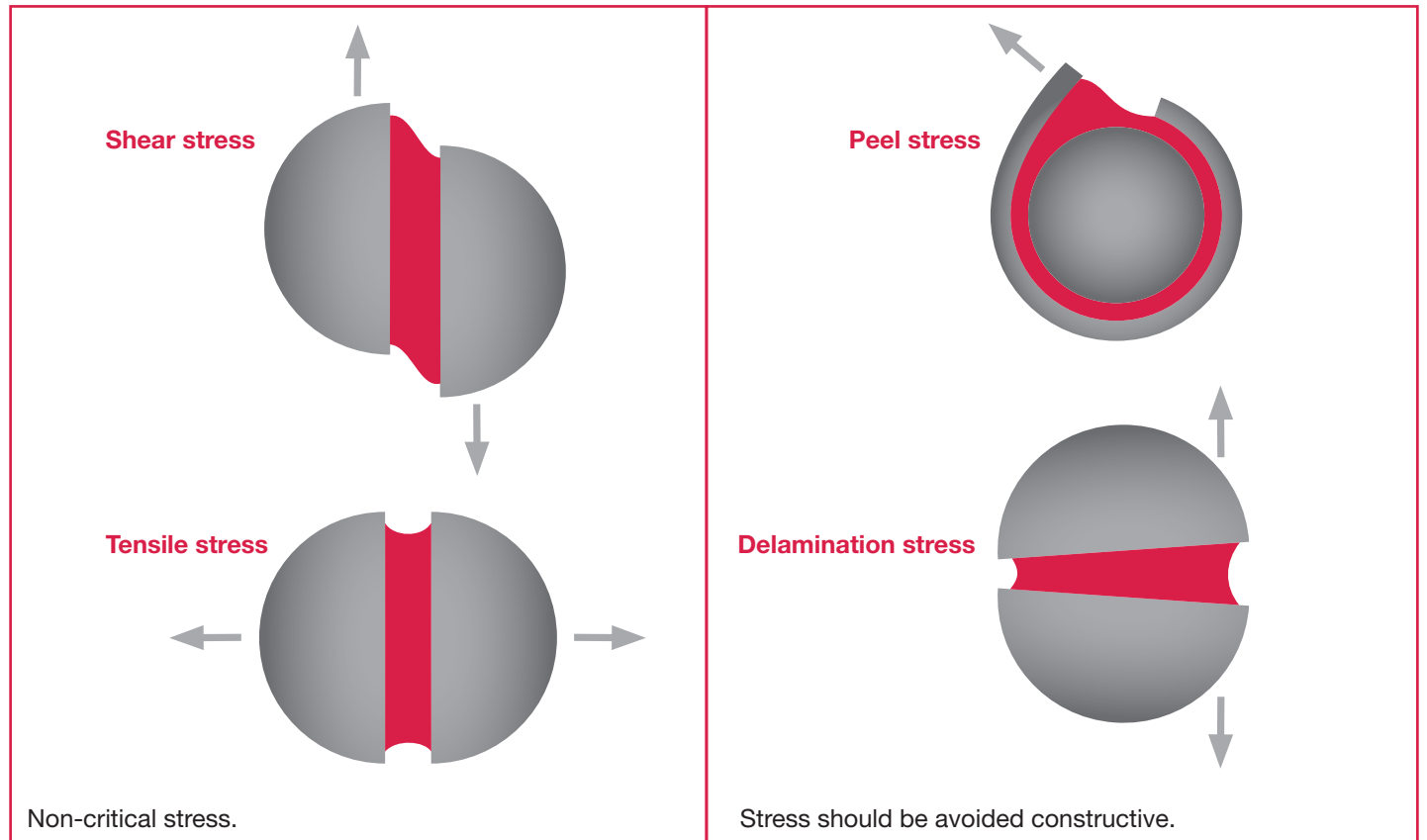
Application techniques

In order to take advantage of Coroplast's Superior-Performance Tapes' optimised performance profile, it is important to follow the processing instructions as well as the recommended dwell times. Final bond strength is reached after 24 hours.

We recommend running an application oriented test to confirm product suitability before using Coroplast's Superior-Performance Tapes.



Mechanical stresses in adhesive tape application



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