



# 9080HL Double Coated Splicing Tape

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## Temporary Product Data Sheet

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Updated : May 2000  
Supersedes : New

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**Product Description** 9080HL is a Double Coated Non-woven Tape with Polycoated Paper Liner.

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**Physical Properties**  
Not for specification purposes

<b>Adhesive Type</b>	Cross linked, Tackified Acrylic Adhesive
<b>Carrier Type</b>	Non-woven
<b>Thickness</b> (ASTM D-3652) Tape Release Liner	0.160 mm 0.160 mm
<b>Normal Tolerance</b>	15 %
<b>Release Liner</b>	Polycoated Paper Liner – 3M Logo Printed
<b>Tape Colour</b>	White
<b>Shelf Life</b>	12 months from date of manufacture by 3M when stored in the original carton at room temperature & 50 % Relative Humidity

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**Performance Characteristics**  
Not for specification purposes

<b>Peel Strength</b> (ASTM-D3330) 180° Peel Adhesion; Room Temperature 72 hour ageing, Jaw Speed : 305 mm/min; with A1 Strip.	1900 grams/25mm
<b>Static Shear</b> (ASTM-D3654) 500 grams loading on stainless steel 6.45 cm <sup>2</sup> overlap at room temperature.	10,000 min
<b>Liner Release</b> 1 inch (25.4mm) width Jaw Speed : 12 inches/min (305mm / min)	Max. 50 grams
<b>Hot Splicing</b> (BTM 220) 1Kg/sq.in (1.25Kg/30mm x 25mm test area), overlap shear, held for 60 seconds	In excess of 170°C (test program on-going)
<b>Bonding strength</b>	Delaminates most papers
<b>Instant adhesion</b>	Excellent (for flying splices)

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**Application Techniques** Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact & thus improves bond strength. For splicing applications, rubbing down the tape prior to removing the liner to expose the splicing adhesive will improve the splice performance. Ideal tape application temperature range is 21°C to 38°C. Initial tape application to surfaces at temperatures below 10°C is not recommended because the adhesive may become too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

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**Applications** 9080HL tape is specially formulated for low- and high-speed splicing applications, followed if required by heat-setting or other oven-based processing conditions. The tape makes an excellent bond to paper and board, and many plastic film substrates including Polyethylene, Polypropylene and PVC.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



**Tapes & Adhesives Group**

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