Double Coated PET Tapes

8228B, 8229B

Technical Data **Jan, 2021**

Product Description

3M™ Double Coated Tape 8228B and 8229B feature a medium-firm acrylic pressure sensitive adhesive system. The key characteristics of this adhesive include a combination of high performance in adhesion and good shear holding power to a wide variety of materials, including many plastics.8228B and 8229B are specially designed for appliance market applications, such as block feature bonding, foam, isolative film fixing, and system assembly.

Constructions Product Number	Adhesive Type/ Color[1]	Carrier Type/ Color	Adhesive Thickness (mm)	Liner Color, Type, Print	Liner Caliper
3M™ 8228B	Acrylic Opaque	PET Black	0.05 mm	Clear PET	0.05mm
3M™ 8229B	Acrylic Opaque	PET Black	0.10 mm	Clear PET	0.05mm

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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.

I. Adhesion to Surfaces (Unit: kgf/in)

ASTM D3330 modified (180° peel, 2 mil aluminum foil backing)

Dwell	8228B	8229B
20min RT SUS	1.7	2.5
72 hour RT SUS	1.8	2.8
20min RT Glass	1.5	2.0
20min RT ABS	1.7	2.3
20min RT PP	1.4	1.9
20min RT PET	1.7	2.3

II. Relative High Temperature Operating Ranges

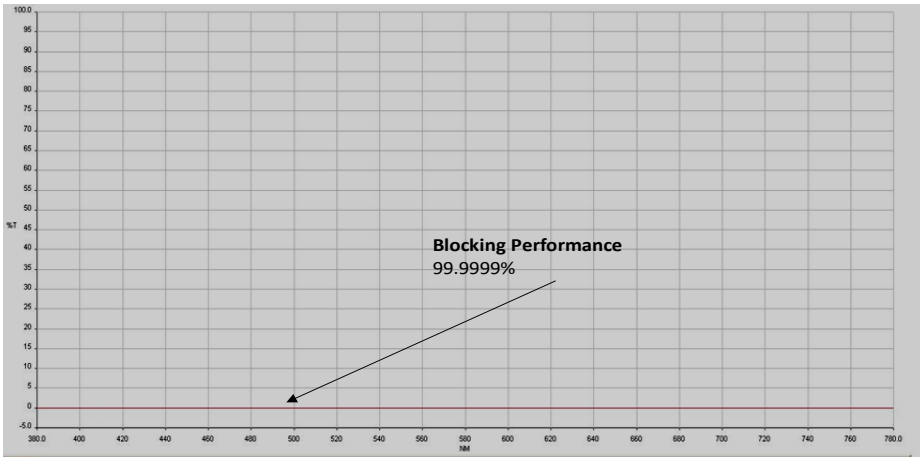
Short term (minutes/hours)	121°C
Long term (days/weeks)	93°C

III. Static Shear

ASTM D3654 - 1" x 1" sample area - aluminum foil to stainless steel

		Minutes to Failure	
Temperature	**Load**	**8228B**	**8229B**
23°C	1Kg	10000+	

IV. Light Blocking Performance



Application Techniques

For maximum bond strength (during installation of the final part) the surface should be thoroughly cleaned and dried. Typical cleaning solvents are heptane***** (for oily surfaces) or isopropyl alcohol***** for plastics. Use reagent grade solvents since common household materials like rubbing alcohol frequently contain oils to minimize the drying affect on skin and can interfere with the performance of a pressure-sensitive adhesive.

It is necessary to provide pressure during lamination (1.5-20 pli recommended) and during final part installation (10-15 psi) to allow the adhesive to come into direct contact with the substrate. Using a hard-edged plastic tool, which is the full width of the laminated part, helps to provide the necessary pressure at the point of lamination. Heat can increase bond strength when bonding to metal parts (generally this same increase is observed at room temperature over longer times, weeks). For plastic parts, the bond strength is not enhanced with the addition of heat.

The ideal adhesive application temperature range is 60°F (15.6°C) to 100°F (38°C). Application is not recommended if the surface temperature is below 50°F (10°C) because the adhesive becomes too firm to adhere readily. Once properly applied, at the recommended application temperature, low temperature holding is generally satisfactory.

Application Ideas

- Long term bonding of graphic nameplates and overlays ("subsurface" printed polycarbonate or polyester) to metal and high surface energy plastics in the aerospace, medical and industrial equipment, automotive, appliance and electronic markets.
- Bonding metal nameplates and rating plates in the aerospace, medical and industrial equipment, automotive, appliance and electronic markets.
- Bonding graphic overlays for membrane switches and for bonding the complete switch to the equipment surface.
- High speed processing of parts in the medical, telecommunications and electronics markets (medical components, durable labels, flexible circuits).
- Lamination to industrial foams for rotary die-cutting of small gaskets for industrial and electronics markets.

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Shelf Life	To obtain best performance, store under normal conditions of 21°C and 50% R.H. in the original carton and follow the shelf life shown on Certification of Analysis (COA)
Product Use	Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.
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ISO 9001: 2015

This EDB product was manufactured under a 3M quality system registered to ISO 9001: 2015 standards.

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Electric Device Assembly
3M Taiwan