

January, 2011

3M™ Adhesive Transfer Tape 91022

Product Description

Finite Element Analysis (FEA) data is available for this product at: 3m.com/FEA

3M™ Adhesive Transfer Tape 91022 with 3M™ Silicone Adhesive provide high bond strength to most silicones and difficult-to-bond to substrates, including many low surface energy plastics and select varnished leathers.

Product Features

- Single liner tapes with a stable differential release.
- Good initial quick stick and adhesion build over time.
- Adhesion to silicone rubbers and silicone foams.
- Excellent solvent resistance.
- Superior temperature performance.



Technical Information Note

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

Typical Physical Properties

Property	Values	
Total Tape Thickness without liner	0.05 mm	2 mil
Adhesive Type	Silicone	
Liner	PET	
Liner Thickness	0.05 mm	2 mil
Liner Color	White	

Typical Performance Characteristics

90° Peel Adhesion		Substrate
4.4 N/cm	40 oz/in	Stainless Steel
4.4 N/cm	40 oz/in	ABS
4.4 N/cm	40 oz/in	Polycarbonate (PC)
3.8 N/cm	35 oz/in	Polypropylene (PP)
3.8 N/cm	35 oz/in	Silicone Rubber

Property: 90° Peel Adhesion
 Method: ASTM D3330
 Dwell/Cure Time: 24
 Dwell Time Units: hr
 Temp C: 22C
 Temp F: 72F
 Environmental Condition: 52%RH
 notes: 12 in/min (300 mm/min)

Property	Values		Method	Test Condition	Notes
Maximum Service Temperature	260 °C	500 °F			
Static Shear	>10,000 min		ASTM D3654	1000 g @ Room Temperature	1 in ² sample size
Static Shear	>10,000 min		ASTM D3654	500 g @ 70°C (158°F)	1 in ² sample size
Solvent Resistance	Excellent				

Available Sizes

Property	Values		Attribute Modifier
Note	Subject to Minimum Order Requirements		
Maximum Available Width	48 in		
Normal Slitting Tolerance	±0.8 mm	±1/32 in	
Core Size	76.2 mm	3 in	ID

Maximum Length		Width
66 m	72 yd	1/2 in to 1 in widths
329 m	360 yd	3 in and wider

Property: Maximum Length

Environmental Resistance

Humidity Resistance: High humidity has minimal effect on adhesive performance.

No significant reduction in bond strength is observed after exposure for 7 days at 90°F (32°C) and 90% relative humidity.

UV Resistance: When properly applied, nameplates and decorative trim parts are not adversely affected by exposure.

Water Resistance: Immersion in water has no appreciable effect on the bond strength. After 100 hours at room temperature, the high bond strength is maintained.

Temperature Cycling Resistance: High bond strength is maintained after cycling four times through:

- 8 hours at 194°F (90°C)
- 16 hours at -40°F (-40°C)
- 8 hours at 100.4°F (38°C/100% RH)
- 16 hours at -40°F (-40°C)

Chemical Resistance: When properly applied, nameplate and decorative trim parts will hold securely after exposure to numerous chemicals including oil, mild acids and alkalis.

Handling/Application Information

Application Ideas

- General purpose silicone bonding.
- Vibration damping.
- High temperature applications.
- Ideal for single liner applications.

Application Techniques

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure and moderate heat, from 100°F (38°C) to 130°F (54°C), will assist the adhesive in developing intimate contact with the bonding surface.

To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Some typical surface cleaning solvents are isopropyl alcohol or heptane.* 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.

*Carefully read and follow the manufacturer’s precautions and directions for use when working with solvents. These cleaning recommendations may not be compliant with the rules of certain Air Quality Management Districts in California; consult applicable rules before use.

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Handling/Application Information (continued)

Application Equipment

To apply adhesives in a wide web format, lamination equipment is required to ensure acceptable quality. To learn more about working with pressure-sensitive adhesives please refer to technical bulletin, Lamination Techniques for Converters of Laminating Adhesives (70-0704-1430-8). For additional dispenser information, contact your local 3M sales representative, or the toll free 3M sales assistance number at 1-800-362-3550.

Storage and Shelf Life

Store in original cartons at 70°F (21°C) and 50% relative humidity.
If stored under proper conditions, product retains its performance and properties for one year from date of manufacture.

Trademarks

3M is a trademark of 3M Company.

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/company-us/all-3m-products/~/-/3M-Adhesive-Transfer-Tape-91022?N=5002385+3293240965&rt=rud
Safety Data Sheet (SDS)	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=91022

Family Group

	91022	96042
Total Tape Thickness without liner (mm)	0.05	0.13
Adhesive Type	Silicone	Silicone
Liner	PET	PET
Liner Thickness (mm)	0.05	0.05
Liner Color	White	White

ISO Statement

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

Information

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