



Double Coated Tapes with Adhesive 300MP

9832 • 9832HL

Technical Data

October, 2006

Product Description

3M™ Double Coated Tape 9832 with Adhesive 300MP is a general purpose tape that provides excellent adhesion to a wide variety of substrates, including many foams, plastics, foil, and felt. This tape is well suited for applications requiring temperature performance up to 250°F for short term exposure and up to 150°F for long term exposure. A thin polyester film carrier provides dimensional stability and improved handling.

3M tape 9832 can be used in the woodworking market on particle board, melamine, HPL, wood, plywood, vinyl, foam and more.

Construction

Product Number	Faceside ¹ Adhesive Thickness	Carrier Type Thickness	Backside ² Adhesive Thickness	Liner Type	Liner Caliper	Total Tape Thickness (w/o liner)
3M™ tape 9832	2.3 mils (0.058mm)	0.5 mils (0.013mm)	2.0 mils (0.051mm)	Tan, 58#, Polycoated Kraft, unprinted	4.0 mils (0.10mm)	4.8 mils (0.12mm)
3M™ tape 9832HL	2.3 mils (0.058mm)	0.5 mils (0.013mm)	2.0 mils (0.051mm)	Tan, 83#, Polycoated Kraft, unprinted	6.2 mils (0.16mm)	4.8 mils (0.12mm)

Note 1: Faceside adhesive is on the interior of the roll, exposed when unwound.

Note 2: Backside adhesive is on the exterior of the roll, exposed when liner is removed.

The caliper listed is based on a calculation from manufacturing controlled adhesive coat weights using a density of 1.012 g/cc.

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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.

Product	3M™ Double Coated Tape 9832	3M™ Double Coated Tape 9832HL
Adhesion to stainless steel ASTM D3330 - 90 degree	oz/in (N/100mm)	oz/in (N/100mm)
- 15 minute RT	56 (61)	56 (61)
- 72 hour RT	58 (63)	58 (63)
- 72 hour 158°F	86 (94)	86 (94)
ASTM D3330 - 180 degree, 2.0 mil aluminum foil		
- 72 hour RT	94 (103)	94 (103)
Adhesion to other surfaces ASTM D3330 - 90 degree, 2.0 mil aluminum foil, 72 hour RT		
ABS	58 (63)	58 (63)
Polycarbonate	66 (72)	66 (72)
Polypropylene	34 (35)	34 (35)
Shear Strength - ASTM D3654 Modified - (0.5 inch square sample size)		
1000 grams at 72°F	2289 minutes	2289 minutes
500 grams at 158°F	1139 minutes	1139 minutes
Relative High Temperature Operating Ranges		
Long Term (days, weeks)	150°F	150°F
Short Term (minutes, hours)	250°F	250°F

Available Sizes

Roll length, width, slitting tolerance, core size.	
Maximum in: 1/2" to 54"	1/2 in. - 63/64 in. 180 yds. 1 in. - 54 in. 360 yds.
Normal Slitting Tolerance	± 1/32 in. (0.08 mm)
Core Size (ID) 3M tape 9832	3.0 in. (76.2 mm)
3M tape 9832 for woodworking is available only in:	1 in. x 36 yds. 2 in. x 36 yds. 6 in. x 36 yds.

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Features

- 3M™ Adhesive 300MP is a solvent free acrylic adhesive ideal for applications requiring high adhesion to a wide variety of materials, including many plastics and foams.
 - Has a film carrier, which can add dimensional stability to foams and other substrates. The carrier also provides easier handling during slitting and die-cutting.
 - 3M™ Double Coated Tape 9832HL has a heavy 83# Polycoated Kraft liner for improved lay-flat properties and moisture stability.
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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 improves 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*

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.

***Note:** When using solvents, extinguish all ignition sources, and follow the manufacturer's precautions and directions for use.

Application Ideas

- General purpose foam lamination.
- General purpose lamination for fabricated parts.

3M™ Double Coated Tape 9832 application ideas for woodworking:

- **Edge banding.**
 - **Refacing cabinets.**
 - **Applying wood veneer.**
 - **Drawer front mounting.**
 - **Mounting card holders.**
 - **Creating jigs.**
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Application Equipment

Wide web lamination

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).

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Storage	Store in original cartons at 70°F (21°C) and 50% relative humidity.
Shelf Life	If stored under proper conditions, product retains its performance and properties for two years from date of manufacture.
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ISO 9001:2000

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**Industrial Business
Converter Markets
Industrial Adhesives and Tapes Division**

3M Center, Building 21-1W-10, 900 Bush Avenue
St. Paul, MN 55144-1000
800-223-7427 • 651-778-4244 (fax)
www.3M.com/converter



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