Double Coated Polyethylene Foam Tapes 4421

Temporary Technical Data **July 1, 2006**

Product Description	Double Coated Polyethylene Foam Tape with polycoated paper liner
Product Uses	3M™ 4421 tape is specially formulated for many indoor and limited outdoor general mounting and joining application, including bonding to polyethylene and polypropylene and many other plastics without primer treatment, where moderated temperature and shear performance general purpose mounting and joining application. **Note**: All tapes should be thoroughly evaluated by the user under actual conditions with intended substrates to determine whether a specific tape is fit for a particular purpose and suitable for user's method of application, especially if expected use involves extreme environmental conditions.

	Product	**4421 White**	**4421 Black**
Construction	Tape Thickness	1 mm	
	- Tolerance	± 15%	
	Tape Color	White	Black
	Carrier Type	Polyethylene foam	
	Release Liner	0.13 mm Polycoated Paper Liner Red 3M Logo printed	0.13 mm Polycoated Paper Liner Grey 3M Logo printed
Roll Length	Standard (m)	10	
Roll width	Minimum (mm)	6.4	
	Maximum (mm)	1000	
Slitting Tolerance	mm	+/- 0.8	
Tape Density	Approximately (Kg/m^3)	150	

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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	**4421(White/Black)**
Peel Adhesion	Kg/12.7mm
Stainless Steel	1.3
Polyethylene	1.1
ASTM D-3330(90° Peel) Room temp. 72 hr aging Jaw speed : 305 mm/min	
Dynamic Shear	Kg/6.45cm^2
To Stainless Steel ASTM D-1002 With Al strip Room temp. 72 hr aging Jaw speed : 12.7 mm/min	17
Normal Tensile	Kg/6.45cm^2
T-block (Al to Al) ASTM D-897 Room temp. 72 hr aging Jaw speed : 50.8 mm/min	20
Static Shear	Minutes
To Stainless Steel ASTM D-3654 6.45 cm^2 overlap at RT 500 grams loading	10,000+
Shelf Life	12 months from date of manufacture when stored in original cartons at room temperature & 50% RH

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Application Technique

- Bond strength is dependent upon the amount of surface contact area of applied tape. Firm application pressure helps develop better adhesive contact and improve bond strength.
- To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Typical surface cleaning solvents are isopropyl alcohol and water (rubbing alcohol) or heptane. **Note** : Be sure to follow manufacturer's safety precautions and directions for use when using solvents.
- Ideal tape application temperature range is 70ºF To 100ºF (21ºC to 38ºC). Initial tape application to surfaces at temperatures below 50ºF (10ºC) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

Application Ideas

- Signs, nameplates and plaques
- Pointed of purchase and other displays
- Plastics hooks, racks and dispensers
- Wire and cable clip
- Appliance, display case and electronics equipment trim

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 82-80-533-4114. Address correspondence to : 3M Engineered Adhesives Division, 3M Korea LTD, Daehan Invest Trust BLDG 22nd Floor, Yoido Dong, Yongdeungpogu, Seoul, Korea. Our fax number is 82-2-786-7429

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ISO 9002

This Engineered Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

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