

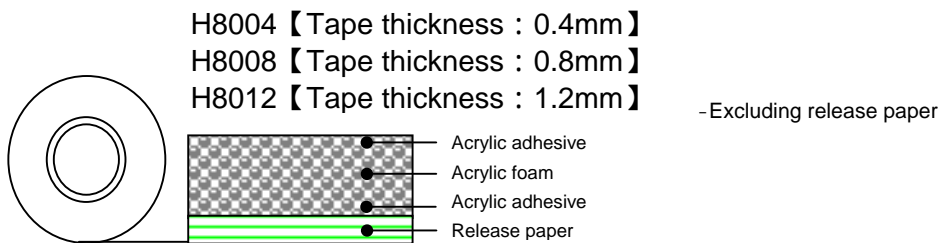
Superior adhesive performance acrylic foam Double-coated adhesive tape

Hyper Joint H8004, H8008, H8012

Outline

Nitto Denko H8004, H8008 and H8012 are double-coated adhesive tapes that have superior adhesion, heat resistance and durability using by flexible acrylic foam.

Structure



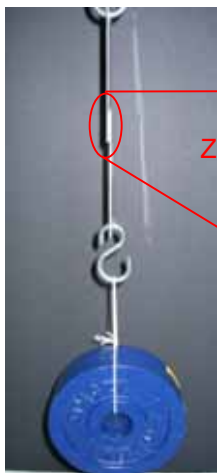
Features

- Superior adhesion, heat resistance and water resistance.
- High adhesion and holding performance exercise stable adhesion.

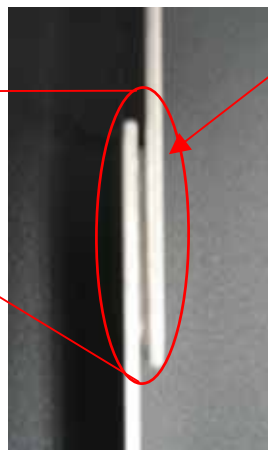


No Separation

Excellent adhesive performance by using flexible and strong acrylic foam.



Zoom in



Contact area : No Separation

The tape shows excellent bonding performance to substrate like this heavy load because of its high shear strength and holding power.

Applications

- Fixing of name plate, sign board and fittings for housing.
- Fixing of exterior components for automobile.
- Fixing of metal and plastic name plate.

Standards Sizes

Product numbers	Tape thickness [mm]	Widths [mm]	Lengths [M]
H8004	0.4	25	20
H8008	0.8	25	20
H8012	1.2	25	20

For more information, please contact a person in charge.

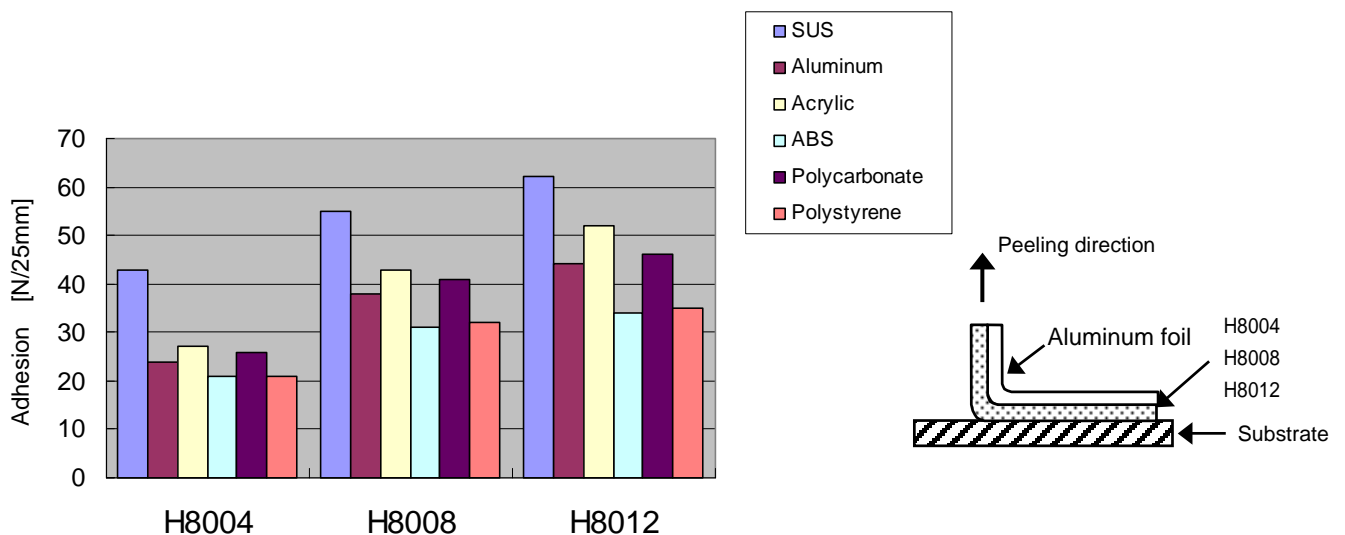
Properties

- 90 degree peeling adhesion by substrates

Substrates	H8004	H8008	H8012
Stainless steel plate	43	55	62
Aluminum plate	24	38	44
Acrylic plate	27	43	52
ABS plate	21	31	34
Polycarbonate plate	26	41	46
Polystyrene plate	21	32	35

(Unit: N/25mm)
 Backing: Aluminum foil (0.13 mm thickness)
 Peeling speed: 300 mm/min
 Peeling angle: 90 degree
 Application condition:
 1 pass back and forth with 5-kg roller at 23 degree C.
 measured adhesion after allowing it to set 30 minutes
 Measurement condition: 23 degree C. x 50%RH

90 degree peeling adhesion by substrates



• 90 degree peeling adhesion by temperatures

Measurement temperatures		H8004	H8008	H8012
90 degree Peeling adhesion [N/25mm]	0 degree C.	46	70	90
	23 degree C.	43	55	62
	40 degree C.	36	50	54
	80 degree C.	32	48	50
	100 degree C.	31	46	49

(Unit: N/25mm)

Backing: Aluminum foil (0.13 mm thickness)

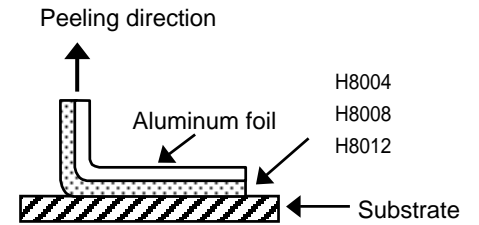
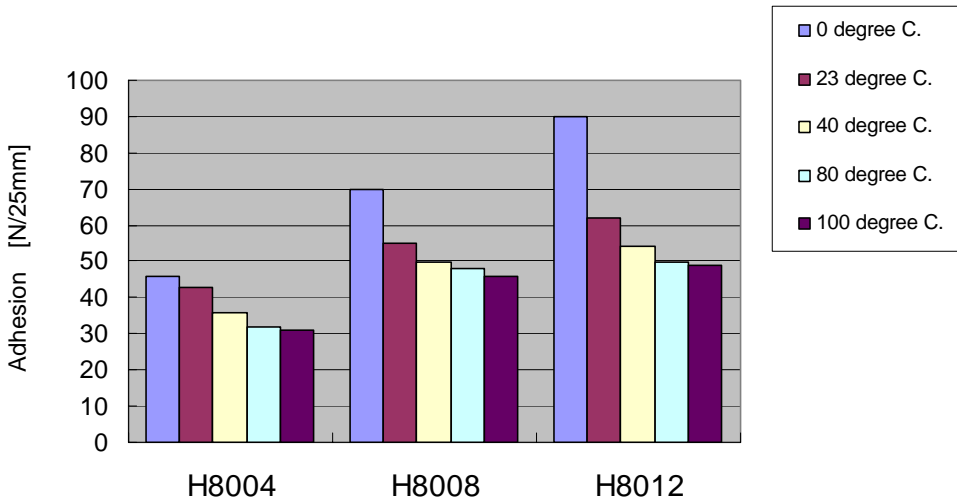
Peeling speed: 300 mm/min:

Application condition:

1 pass back and forth with 5-kg roller at 23 degree C. measured adhesion under various temperatures after allowing it to set 30 minutes

Peeling angle: 90 degree

90 degree peeling adhesion by temperatures



• Shear strength by temperatures

Measurement temperature		H8004	H8008	H8012
Shear strength [N/cm ²]	0 degree C.	245	175	135
	23 degree C.	130	103	80
	40 degree C.	100	69	55
	80 degree C.	65	43	36
	100 degree C.	44	31	26

(Unit: N/cm²)

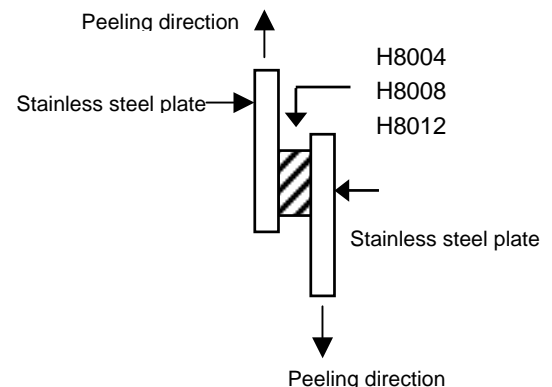
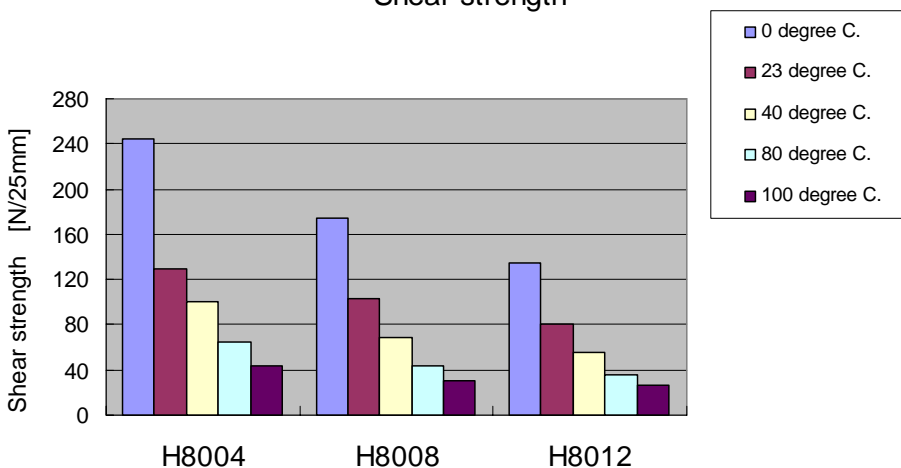
Substrate: Stainless steel plate

Peeling speed: 50 mm/min:

Application condition:

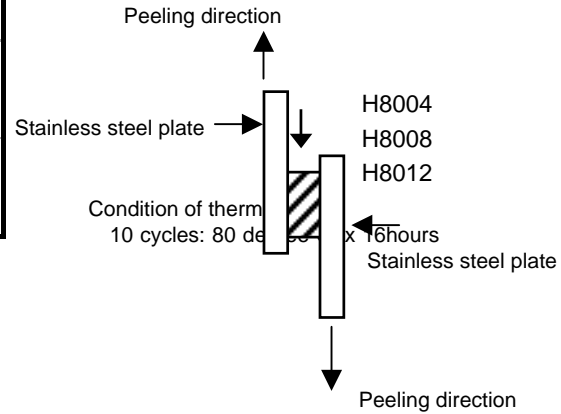
1 pass back and forth with 5-kg roller at 23 degree C. measured shear strength under various temperature after allowing it to set 30 minutes

Shear strength



Evaluation	H8004	H8008	H8012
Initial (23 x 30minutes)	130	103	80
Ordinary state (23 x 24hours)	165	115	97
Heat resistance (80 x 250hours)	208	174	130
Water resistance (40 hot water x 250hours)	130	90	71
Thermal cycle resistance	132	91	75

(Unit: N/c m²)
 Substrate: Stainless steel plate
 Peeling speed: 50 mm/min
 Tape area: 10mm x 20 mm:
 Application condition:
 1 pass back and forth with 5-kg roller at 23 degree C.
 measured adhesion under various conditions
 after allowing it to set 30 minutes
 Measurement condition: 23 degree C. x 50%RH
 Peeling speed: 50mm/min

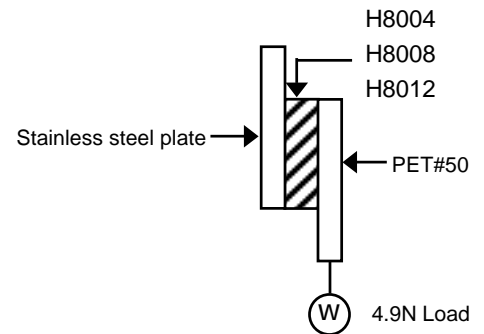


23 degree C. x an hour 50 degree C. x 98%RH x 24hours
 23 degree C. x an hour - 30 degree C. x 8hours 23 degree C. x an hour

• Holding power(Amount of transformation)

Measurement temperature	H8004	H8008	H8012
80 degree C. amount of transformation	0.2	0.6	0.8

(Unit: mm/2hours)
 Substrate: Stainless steel plate
 Backing: Polyester film #50
 Tape area: 10mm x 20 mm
 Load: 4.9N
 Measurement temperature: 80 degree C.
 Measured amount of transformation after 2hours



Precautions when using

Remove all oil, moisture and dirt from the surface of the substrate before applying.

The tape employs pressure-sensitive adhesive. Be sure to apply pressure with a roller or press when applying. Failure to do so could affect properties or appearance.

The tape may not adhere well to significantly uneven or distorted surfaces. Level off the surface as much as possible before applying.

Because it is very thin, you should avoid applying large loads for at least several hours following application.

Precautions when storing

Be sure to keep the tape in its box when not using.

Keep in a cool dark place not exposed to direct sunlight.

Safety precautions



Warning

Make sure the product is suitable for the application (objective and conditions) before attempting to use. The tape may come off depending on the substrate to or conditions under which it is applied.

Use in combination with another method of joining if there is possibility of an accident.

Published in February 2007

The data provided herein are not guaranteed values, but rather measurement values given as an example. Nitto Denko does not guarantee that the tape can be used for the example applications provided herein. You should make sure the tape is suitable for the substrate by applying to some of the material prior to using for practical application. This document is the property of Nitto Denko Corp. This document may not be copied or transferred without the permission of Nitto Denko Corp. If you have any questions concerning the content of this document, please contact the person in charge of publication.

- For inquiries, contact the Customer Center of Bonding & Joining Products DIV. +at 81-532-41-8400

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