



3M™ Double Coated Tape 9500PC

Last Revision Date: May, 2022

Product Description

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

3M™ Double Coated Tape 9500PC features a thin polyester film for dimensional stability and improved handling with ease of die-cutting and laminating. 3M™ Adhesive 350 is a medium-firm acrylic adhesive that provides a combination of high wet grab and initial adhesion and good shear holding power to a wide variety of materials, including many plastics.

Product Features








- 3M™ Adhesive 350 is a firm acrylic adhesive that provides very high adhesion to a wide variety of materials, excellent shear holding power, high temperature resistance and excellent UV resistance.
- 3M adhesive 350 provides exceptional temperature and chemical resistance and withstands tough application environment.
- 3M™ Double Coated Tape 9500PC has a moisture resistant liner which can withstand high humidity conditions with minimal cockling or wrinkling.
- This tape has a film carrier, which can add dimensional stability to substrates. The carrier also provides easier handling during slitting and die-cutting.

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	Additional Information
Adhesive Type	Acrylic	
Adhesive Type	350	View
Test Name: Faceside		
Notes: Faceside adhesive is on the interior of the roll, exposed when unwound and liner removed.		
Adhesive Type	350	View
Test Name: Backside		
Notes: Backside adhesive is on the exterior of the roll, exposed when liner is removed.		
Adhesive Carrier	Clear PET (Polyester)	
Liner	Polycoated Kraft	

Liner Thickness	0.11 mm	
Liner Color	Natural	View 
Test Name: Primary		
Adhesive Thickness	0.058 mm	View 
Test Name: Backside		
Notes: The caliper listed is based on a calculation from manufacturing controlled adhesive coat weight. While past data pages have listed nominal thicknesses of 1 and 2 mils, the coat weight (and theoretical caliper) has not changed.		
Carrier Thickness	0.025 mm	
Total Tape Thickness	5.6 mil	View 
Test Method: ASTM D3652		
Total Tape Thickness	0.14 mm	View 
Test Method: ASTM D3652		
Adhesive Thickness	2.3 mil	View 
Test Name: Backside		
Notes: Backside adhesive is on the exterior of the roll, exposed when liner is removed.		
Adhesive Thickness	0.058 mm	View 
Test Name: Faceside		
Notes: Faceside adhesive is on the interior of the roll, exposed when unwound and liner removed.		
Adhesive Thickness	2.3 mil	View 
Test Name: Faceside		
Notes: Faceside adhesive is on the interior of the roll, exposed when unwound and liner removed.		
Carrier Thickness	1 mil	
Liner Print	None	
Liner Thickness	4.5 mil	

Typical Performance Characteristics


Property	Values	Additional Information
90° Peel Adhesion	7.7 N/cm	View 
<p>Test Method: ASTM D3330</p> <p>Dwell/Cure Time: 15.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Backing: 2 mil Aluminum Foil</p>		
90° Peel Adhesion	71 oz/in	View 
<p>Test Method: ASTM D3330</p> <p>Dwell/Cure Time: 15.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Backing: 2 mil Aluminum Foil</p> <p>Notes: 12 in/min (300 mm/min)</p>		
90° Peel Adhesion	10.1 N/cm	View 
<p>Test Method: ASTM D3330</p> <p>Backing: 2 mil Aluminum Foil</p> <p>Notes: 12 in/min (300 mm/min)</p>		
90° Peel Adhesion	93 oz/in	View 
<p>Test Method: ASTM D3330</p> <p>Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Backing: 2 mil Aluminum Foil</p> <p>Notes: 12 in/min (300 mm/min)</p>		
90° Peel Adhesion	13.2 N/cm	View 
<p>Test Method: ASTM D3330</p> <p>Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 70C Temp F: 158F Environmental Condition: 50%RH Substrate: Stainless Steel Backing: 2 mil Aluminum Foil</p> <p>Notes: 12 in/min (300 mm/min)</p>		
90° Peel Adhesion	121 oz/in	View 
<p>Test Method: ASTM D3330</p> <p>Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 70C Temp F: 158F</p>		

Environmental Condition: 50%RH
 Substrate: Stainless Steel
 Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

8.1 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
 Dwell Time Units: hr
 Temp C: 23C
 Temp F: 72F
 Environmental Condition: 50%RH
 Substrate: ABS
 Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

74 oz/in

View 


Test Method: ASTM D3330

Dwell/Cure Time: 72.0
 Dwell Time Units: hr
 Temp C: 23C
 Temp F: 72F
 Environmental Condition: 50%RH
 Substrate: ABS
 Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

4.8 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
 Dwell Time Units: hr
 Temp C: 23C
 Temp F: 72F
 Environmental Condition: 50%RH
 Substrate: Polypropylene (PP)
 Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

44 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
 Dwell Time Units: hr
 Temp C: 23C
 Temp F: 72F
 Environmental Condition: 50%RH
 Substrate: Polypropylene (PP)
 Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

6.5 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
 Dwell Time Units: hr
 Temp C: 23C
 Temp F: 72F
 Environmental Condition: 50%RH
 Substrate: Polycarbonate (PC)
 Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

60 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH

Substrate: Polycarbonate (PC)

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

8.4 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F


Environmental Condition: 50%RH

Substrate: Polyester (PET)

Backing: Aluminum Foil

90° Peel Adhesion

77 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH

Substrate: Polyester (PET)

Backing: Aluminum Foil

90° Peel Adhesion

3.6 N/cm

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH

Substrate: High Density Polyethylene (HDPE)

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion

33 oz/in

View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0

Dwell Time Units: hr

Temp C: 23C

Temp F: 72F

Environmental Condition: 50%RH





Substrate: High Density Polyethylene (HDPE)

Backing: 2 mil Aluminum Foil

Notes: 12 in/min (300 mm/min)





Short Term Temperature Resistance

350 °F

Short Term Temperature Resistance	177 °C	
Long Term Temperature Resistance	93 °C	
Long Term Temperature Resistance	200 °F	
Static Shear	10000 min	View 
<p>Test Method: ASTM D3654</p> <p>Notes: 0.5 in² sample size</p>		
Static Shear	10000 min	View 
<p>Test Method: ASTM D3654</p> <p>Notes: 0.5 in² sample size</p>		
180° Peel Adhesion	15.3 N/cm	View 
<p>Test Method: ASTM D3330</p> <p>Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Backing: Aluminum Foil</p> <p>Notes: 12 in/min (300 mm/min)</p>		
180° Peel Adhesion	140 oz/in	View 
<p>Test Method: ASTM D3330</p> <p>Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Backing: Aluminum Foil</p> <p>Notes: 12 in/min (300 mm/min)</p>		

Available Sizes

Property	Values	Additional Information
Note	Subject to Minimum Order Requirements	
Standard Roll Length	33 m	
Standard Roll Length	36 yd	

Maximum Length	132 m	View 
Width: 1/4in - 1/2in		
Maximum Length	144 yd	View 
Width: 1/4in - 1/2in		
Maximum Length	329 m	View 
Width: 1/2 in to 48 in		
Maximum Length	360 yd	View 
Width: 1/2 in to 48 in		
Minimum Available Width	6.35 mm	
Minimum Available Width	1/4 in	
Maximum Available Width	1220 mm	
Maximum Available Width	48 in	
Normal Slitting Tolerance	0.8 mm	
Normal Slitting Tolerance	±1/32 in	
Core Size (ID)	76.2 mm	
Core Size (ID)	3 in	

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 24 months from date of manufacture.

Recognition/Certification

MSDS: 3M has not prepared a MSDS for these products which are not subject to the MSDS requirements of the Occupational Safety and Health Administration's Hazard Communication Standard, 29 C.F.R. 1910.1200(b)(6)(v). When used under reasonable conditions or in accordance with the 3M directions for use, the products should not present a health and safety hazard. However, use or processing of the products in a manner not in accordance with the directions for use may affect their performance and present potential health and safety hazards.

TSCA: These products are defined as articles under the Toxic Substances Control Act and therefore, are exempt from inventory listing requirements.

Bottom Matter

3M

Industrial Adhesives and Tapes Division

Converter Markets

3M Center, Building 21-1W-10, 900 Bush Avenue

St. Paul, MN 55144-1000

800-223-7427 • 651-778-4244 (fax)

www.3M.com

Trademarks

3M is a trademark of 3M Company.

Automotive Disclaimer

Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, including, but not limited to, automotive electric powertrain battery or high voltage applications. This product does not fully adhere to typical automotive design or quality system requirements, such as IATF 16949 or VDA 6.3. This product may not be manufactured in an IATF certified facility and may not meet a Ppk of 1.33 for all properties. The product may not undergo an automotive production part approval process (PPAP). Customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's automotive application and for conducting incoming inspections before use of the product. Failure to do so may result in injury, death, and/or harm to property. No written or verbal statement, report, data or recommendation by 3M related to automotive use of the product shall have any force or effect unless in an agreement signed by the Technical Director of 3M's Automotive Division. Customer assumes all responsibility and risk if customer chooses to use this product in an automotive electric powertrain battery or high voltage application, and 3M will not be liable for any loss or damage arising from or related to the 3M product or customer's use of the product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity or recall costs), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability. In no event shall 3M be liable for any damages in excess of the purchase price paid for the product.

NOTWITHSTANDING ANY OTHER STATEMENT TO THE CONTRARY, 3M MAKES NO REPRESENTATIONS, WARRANTIES OR CONDITIONS WHATSOEVER, EXPRESS OR IMPLIED, REGARDING THE PRODUCT IF USED IN AN AUTOMOTIVE ELECTRIC POWERTRAIN BATTERY OR HIGH VOLTAGE APPLICATION, INCLUDING, BUT NOT LIMITED TO, ANY WARRANTY ON PERFORMANCE, LONGEVITY, SUITABILITY, COMPATIBILITY, OR INTEROPERABILITY, OR ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE.

Handling/Application Information

Application Examples

- Dissimilar materials joining, such as metal to plastic.
- High performance joining and bonding.

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.

*Carefully read and follow the manufacturer's precautions and directions for use when working with solvents.

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.

References

Property	Values
----------	--------

[3m.com Product Page](https://www.3m.com/3M/en_US/p/d/b40071894/)https://www.3m.com/3M/en_US/p/d/b40071894/[Safety Data Sheet SDS](https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=9500PC)https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=9500PC

ISO Statement

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

Information

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and 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. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

Disclaimer: 3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and limitations, and the user must take any action required under any recall, field action or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, or death. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit www.3M.com.