

NITTO DENKO

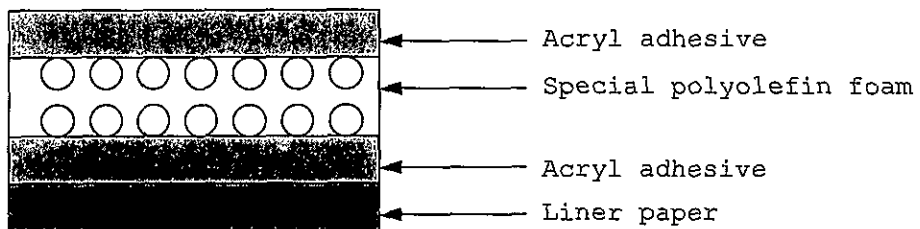
NITTO DENKO CORPORATION

DOUBLE-COATED ADHESIVE TAPE PF-370 FOR TENTATIVE FIXING OF CONSTRUCTION MATERIALS

1. Outline

The double-coated adhesive tape PF-370 is used to fix tentatively the construction materials. Its substrate is flexible special polyolefin foam, and the acryl adhesive ensuring the satisfactory adhesion to rough surfaces is uniformly applied to its both surfaces. It is suited to bonding of construction materials having relatively rough surface such as plywood, plasterboard and calcium silicate plates.

2. Construction



3. Advantages

- (1) The tape has the flexible foam backing so that it ensures excellent adhesion to rough surfaces.
- (2) The special adhesive ensures high initial adhesion as well as excellent low-temperature adhesion.
- (3) The combination of this tape with adhesive enables reduction of application time and affords beautiful appearance without using tentatively fixing nails.
- (4) The blue grids pattern is printed on the surface of liner paper, allowing the user to recognize whether or not the liner is peeled out.

4. Standard size

Thickness (mm)	Width (mm)	Length (m)
1.2	10 to 100	10

5. General Properties

Item	Temperature	Adherend	PF-370	Former type
		Plasterboard	750	80
	23°C	Veneer plywood	800	270
		Calcium silicate (for ground)	1000	300
		Calcium silicate (for decoration)	1200	350
		Plasterboard	1100	50
180° peeling adhesive strength [gf/20mm]	0°C	Veneer plywood	1350	210
		Calcium silicate (for ground)	1350	160
		Calcium silicate (for decoration)	1400	200
		Plasterboard	780	710
	40°C	Veneer plywood	810	750
		Calcium silicate (for ground)	1070	680
		Calcium silicate (for decoration)	1170	650
Shear adhesive strength [kgf/cm ²]	23°C	Plasterboard/ Veneer plywood	3.1	0.5
		Veneer plywood/ Veneer plywood	3.3	1.1
		Calcium silicate (for ground/decoration)	3.5	0.8
	40°C	Plasterboard/ Veneer plywood	Without falling down	Falls after 5 minutes
Holding strength [—]		Veneer plywood/ Veneer plywood	Without falling down	Falls after 15 minutes
		Calcium silicate (for ground/decoration)	Without falling down	Falls after 20 minutes
		Calcium silicate (for ground/decoration)	Without peeling	Peeling occurs after 2 minutes.
Repulsion [—]	23°C	Calcium silicate (for ground/decoration)	Without peeling	Peeling occurs after 2 minutes.
	0°C	Calcium silicate (for ground/decoration)	Without peeling	Peeling occurs soon.
	40°C	Calcium silicate (for ground/decoration)	Without peeling	Peeling occurs after 7 minutes.

6. Testing Method

6.1 180° peeling adhesive strength

Adherends: Plasterboard, veneer plywood and calcium silicate
(for ground and decoration)

Tape: 20 mm wide

Contact-bonding: One to-and-fro rolling with 2 kg roller

Stretching speed: 300 mm/min

Test temperature: Contact-bond in the atmosphere of 23°C, 0°C
and 40°C and soon measure.

6.2 Shear adhesive strength

Adherends: Plasterboard/veneer plywood, veneer plywood/
veneer plywood, calcium silicate (for ground)/
calcium silicate (for decoration)

Tape: 20 mm × 20 mm

Contact-bonding: One to-and-fro rolling with 5 kg roller

Stretching speed: 300 mm/min

Test temperature: Contact-bond in the atmosphere of 23°C and
soon measure.

6.3 Holding strength

Adherends: Plasterboard/veneer plywood, veneer plywood/
veneer plywood, calcium silicate (for ground)/
calcium silicate (for decoration)

Tape: 10 × 20 mm

Contact-bonding: One to-and-fro rolling with 5 kg roller

Load: 500 g

Test temperature: Contact-bond in the atmosphere of 40°C, soon
remove load. After 2 hrs. check for
falling-down.

6.4 Repulsion

Adherends: calcium silicate (for ground) / calcium silicate (for decoration)

5 mm thick

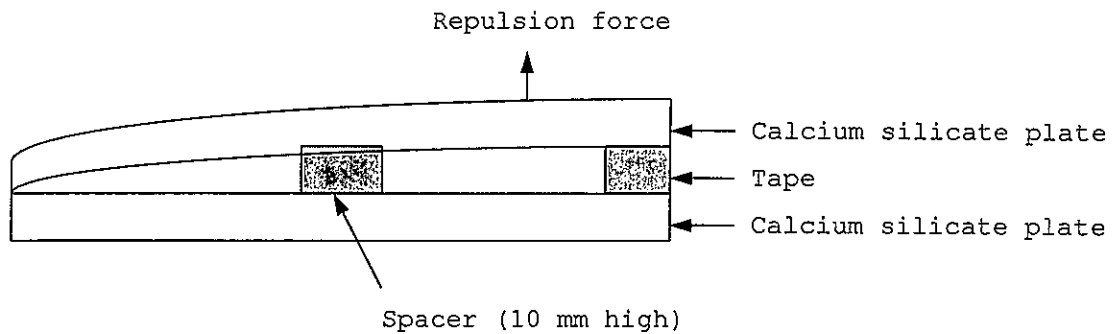
Size: 50 mm wide, 900 mm long

Tape: 50 mm wide, 10 mm long

Contact-bonding: One to-and-fro rolling with 5 kg roller

Staggering: 1 mm

Test temperature: Contact-bond in the atmosphere of 23°C, and after 2 hrs. check for peeling.



7. Cares When Using

- (1) The pressure sensitive adhesive is used. Apply a sufficient pressure to bond securely.
- (2) Thoroughly remove moisture, oils and dirt from the adherend surface.
- (3) Do not store the product at high temperature or humidity or in place where direct sun light or rain affects.
- (4) Provide the proper tape bonding area on the adherend.
 - 1) It is advisable to provide the tape bonding area of 20% or more on the adherend surface.
 - 2) It is advisable to apply the load of 10 g/cm² or less to the tape.
- (5) The PF-370 is tentative fixing tape to be used in combination with adhesive. Do not use the tape singly. If any adhesive adheres to the tape adhesive surface, its holding ability is remarkably reduced. Take due care when the adhesive is applied.

8. Others

- (1) One of versions of PF-370 series tapes enables positioning before tentative bonding. The nylon net is provided on the second surface of tape. It has reduced initial adhesivity. After positioning strongly press it so that the same adhesivity as that of 1st surface can be obtained.