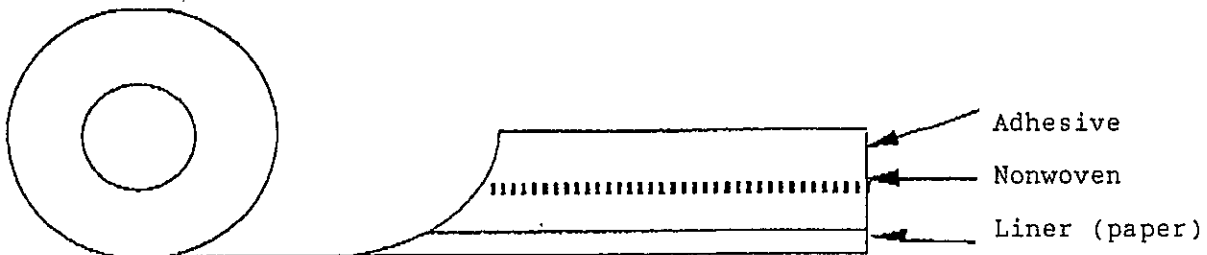# ULTRASTRONG DOUBLE-COATED ADHESIVE TAPE HJ-0240

1. OUTLINE

The ultrastrong double-coated adhesive tape HJ-0240 is double-coated adhesive tape having nonwoven fabric backing which is suited to metal joining. It has excellent adhesive strength, heat resistance and holding ability.

2. CONSTRUCTION

Adhesive

Nonwoven

Liner (paper)

3. FEATURES

3.1 Excellent initial adhesivity

This tape can be used at low temperature in winter.

3.2 High adhesive strength

3.3 Excellent holding ability

3.4 High heat resistance

(This tape can withstand baking coating process.)

4. USES

4.1 Joining of metal panels

4.2 Fixing of parts

5. STANDARD SIZE

Thickness (mm)	Width (mm)	Length (m)
0.4	25	30

Nitto can supply the tapes of other sizes (width and length) not shown in the table above. Please contact Nitto.

6. PROPERTIES

6.1 Adhesion Characteristics

Table 1 Adhesion Properties

Item \ Tape		HJ-0240
Shear adhesive strength (kgf/cm^2) (23°C)	Stainless steel plate	21
	Aluminum plate	21
	Acryl plate	14
	ABS plate	11
	Polystyrene	10
	Polypropyrene	5
180° peeling adhesive strength (gf/20 mm) (23°C)	Stainless steel plate	1600
	Aluminum plate	1600
	Acryl plate	1480
	ABS plate	1410
	Polystyrene	1180
	Polypropyrene	370
	PVC coated steel plate	1600
	Glass	1800
	Veneer board	600

6.2 Temperature Dependence

Table 2 Shear Adhesive Strength (kgf/cm^2)

Tape		HJ-0240
Thickness (mm) Backing		0.4 Nonwoven fabric
Test temperature (°C)	-10	51
	23	21
	100	7
	150	5
	200	5

6.3 Holding Ability

Table 3 Holding Ability

Test Temperature (°C)	HJ-0240
80°C x 1,000 min	Excellent
150°C x 30 min	Excellent

6.4 Change of Adhesive Strength with Time
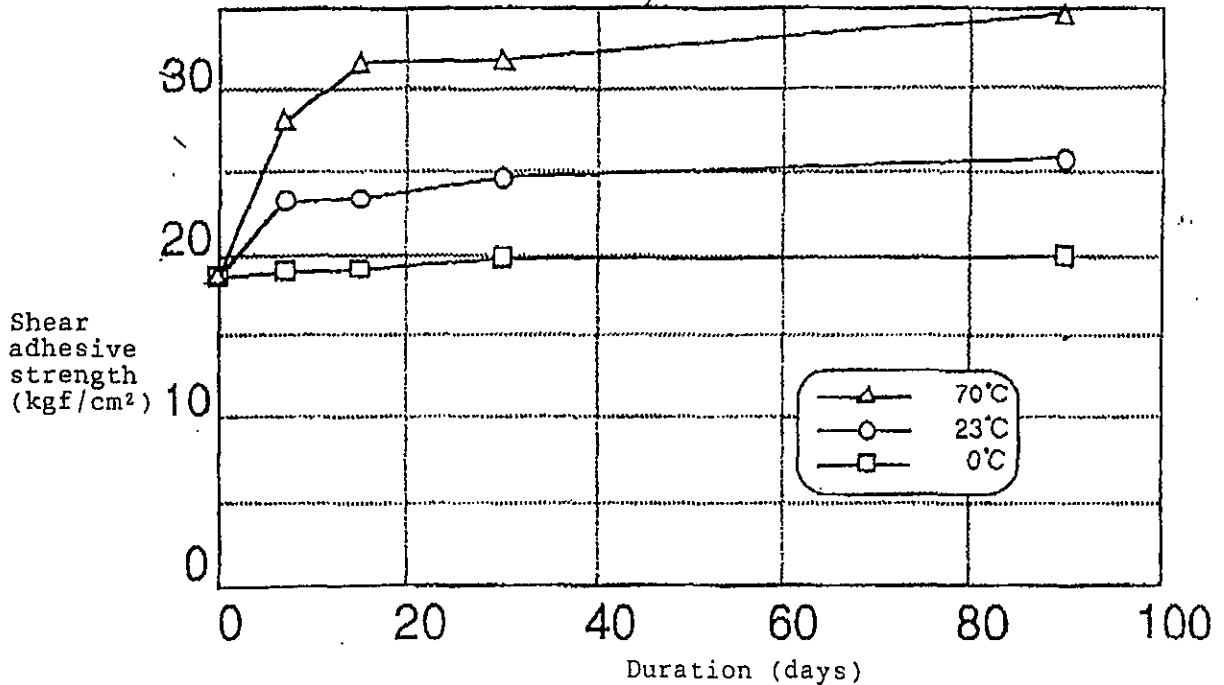
7. CARES WHEN USING

7.1 Before applying the tape, thoroughly clean the surface of substrate, removing oil, moisture, and foreign substances if any.

7.2 The adhesive of this tape is pressure-sensitive adhesive. After applying the tape sufficiently press it with roller or press.

7.3 Smooth the rough and coarse surface to get the smoothest possible surface.

7.4 Higher adhesive strength is attained after it is left untouched for a while after it is applied. Protect the applied tape from any undue force for several hours after it is applied.

3

8. CARES WHEN STORING

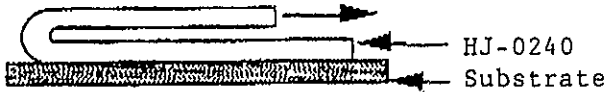8.1 To store the tape, be sure to put it into a storing case.

8.2 Store the tape in dark cool place where direct sunlight does not affect.

9. OTHERS

Data shown in this data sheet are not used for any specification purposes.

TESTING METHOD

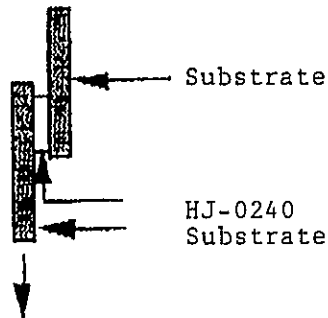### 180° PEELING ADHESIVE STRENGTH

HJ-0240
Substrate

Test at 23°C according to JIS Z 0237.
Stretching speed: 300 mm/min
PET (25 μm) lining

S-S CHARACTERISTICS

Prepare the specimen by punching with dumbbell No.2. Test at 23°C.

Tape width: 10 mm
Chuck-to-chuck distance: 20 mm
Stretching speed: 300 mm/min

SHEAR ADHESIVE STRENGTH

Substrate

HJ-0240
Substrate

Bond two substrates at 23°C, and hold them for 72 hours. Test at 23°C.
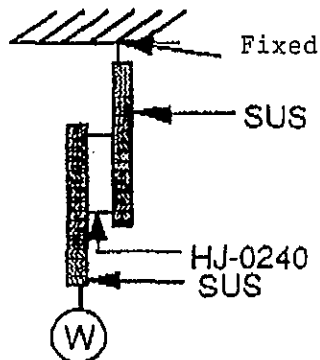
Tape area: 25 x 25 mm^2
Stretching speed: 50 mm/min
Pressing: Once to-and-fro rolling with 5 kg roller

TEMPERATURE DEPENDENCE

Bond two substrates at 23°C, and then hold them for 72 hours. After that, hold them for one hour at specified temperature, then determine the shear adhesive strength at specified temperatures.

Substrates: Aluminum/Aluminum
Tape area: 25 x 25 mm^2
Stretching speed: 50 mm/min
Pressing: Once to-and-fro rolling with 5 kg roller

HOLDING ABILITY

Bond two substrates at 23°C, and then hold them for 72 hours. After that, hold them for 30 minutes at specified temperatures start the test.

Substrates: Aluminum/Aluminum
Tape area: 25 x 25 mm^2
Load: 1,000 g
Pressing: Once to-and-fro rolling with 5 kg roller

CHANGE OF ADHESIVE STRENGTH WITH TIME

Bond two substrates at 23°C, and hold them for 72 hours. After that, hold them at specified temperatures for the specified number of days, and then determine the shear adhesive strength at 23°C.

Substrates: Aluminum/Aluminum
Tape area: 25 x 25 mm^2
Stretching speed: 50 mm/min
Pressing: Once to-and-fro rolling with 5 kg roller