



"If you can imagine it, Nadco will make it Stick."®

1163 Double Coated Tape

Technical Data

Product Description 1163 Double Coated Tape is a 6.5 mil double coated tape utilizing a 0.5 mil hand-tearable polyester film heavily coated on both sides with 3 mils of an ultra high peel acrylic adhesive system. The heavy adhesive deposition allows for superior bonding and conformability to irregular as well as flat surfaces. The special acrylic adhesive, bonds well to most substrates including low surface energy plastics. This product provides excellent U.V. and heat resistance. Super aggressive splicing tape for demanding applications.

Construction	Carrier:	Polyester
	Adhesive:	Acrylic
	Thickness: Total (excluding liner)	6.5 mils (165 microns)
	Tape	3.0 mils (76 microns)
	Carrier	0.5 mils (13 microns)
	Tape	3.0 mils (76 microns)
	Release Liner:	55# Glassine
	Tape Color:	Clear

Typical Physical Properties	Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.	
	Adhesion to Steel: (Initial, 12 in./min.)	120 oz./in. (34.0 N/25 mm)
	Relative Temperature Operating Ranges:	
	Minimum Continuous Temperature	-40°F (-40°C)
Maximum Continuous Application Temperature (minutes, hours)	200°F (93°C)	

Typical values are not intended to be used for specification development. Technical data is believed to be true and accurate.

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Application For bonding irregular surfaces, bonding to plastics and metal profile extrusions, bonding of decorative trim; also used as a universal all-purpose double coated tape. Used extensively for seaming vinyl banners.

Available Sizes Please contact your NADCO® sales representative or customer service at 1-800-839-9018 for sizes and availability.

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.

*Note: Carefully read and follow the manufacturer’s precautions and directions for use when using solvents.

Application Equipment For additional dispenser information, contact your NADCO® sales representative.

Storage Store in original cartons at 70°F (21°C) and 50% relative humidity.

Shelf Life If stored under proper conditions, product retains its performance and properties for two years from date of manufacture.

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Certification/ Recognition

MSDS: NADCO® has not prepared an MSDS for this product which is 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 NADCO® directions for use, this product should not present a health and safety hazard. However, use or processing of this product in a manner not in accordance with the directions for use may affect its performance and present potential health and safety hazards.

TSCA: This product is not defined as an article under the Toxic Substances Control Act and therefore, it is exempt from inventory listing requirements.

Product Use

All statements, technical information and recommendations contained in this document are based upon tests or experience that NADCO® believes are reliable. However, many factors beyond NADCO® control can affect the use and performance of a NADCO® product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the NADCO® product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

Warranty and Limited Remedy

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