

## PRODUCT GROUP

## DOUBLE COATED TAPES

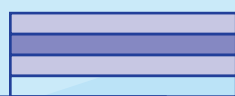
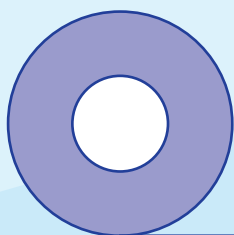
### D5304

This datasheet contains provisional product information and is therefore subject to change. The product is in a test phase and is not yet released for commercial use. Consequently the product described herein may be modified or discontinued without notice.

#### General description

Nitto double-coated D5304 is a polyester carrier based tapes with an aggressive modified acrylic adhesive used for mounting of different types of plastics.

#### Construction



- Modified acrylic adhesive
- Polyester carrier
- Modified acrylic adhesive
- Siliconised polypropylene release liner

#### Characteristics

Nitto D5304 is a double-coated tape with a high adhesion level on different substrates such as plastics, low surface energy substrates, foams and metals.

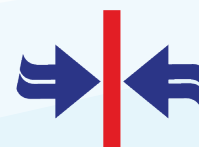
The tape is suitable for rough surface bonding. The PET carrier provides dimensional stability resulting in reduced elongation and shrinkage.

D5304 is also available in bobbin shape.

#### Application

Nitto D5304 is used for mounting decorative profiles in furniture industry (trim mounting), cable ducts. Suitable for mounting plastic parts in sign and nameplate markets for marketing devices (Point Of Sales).

### CORE FUNCTION



TO ADHERE

#### Features

- high adhesion on different plastics & rough surfaces
- high temperature resistance
- high holding power
- easy processing
- available with white and red liner
- bobbin shape
- RoHS compliant (2011/65/EC, 2015/863)



EcoVadis: World's most trusted business sustainability rating company.

Edition: April 2021  
Code: DS/06.09/ D5304 ENG  
This datasheet replaces all previous versions

## Technical Properties

### General physical properties

	Typical Value	Test Method
Tape Thickness*	0.165 mm	EN 1942
Adhesive type	Colorless modified acrylic	
Release liner type	D5304RD: Siliconised red polypropylene (0.07 mm) D5304WH: Siliconised white polypropylene (0.07 mm)	
Carrier type	Polyester (0.036 mm)	
Adhesion to BA steel	1800 cN/20mm	EN 1939
Release value	20 cN/50 mm	Nitto Belgium test method
Static shear	1.0 mm/3h	EN 1943
Optimum transport and storage conditions	Temperature 5 °C to 35 °C Relative humidity 40 to 85% RH	

\* Tape thickness = Total thickness without liner

Details from the test methods are described on the customer product specification.

CAUTION: The above are typical values and should not be used in writing specifications.

### Performance properties

Adhesion			EN 1939
PVC	2200 cN/20mm	ABS	2000 cN/20mm
PMMA	2000 cN/20mm	PP	500 cN/20mm
PC	2100 cN/20mm	PET	1800 cN/20mm
Glass	2100 cN/20mm		
Weight Added Peel Off (WAPO)		2h at 60 °C, width 20mm, 100g	
PP 5 mm	ABS 3 mm	BA 1 mm	
Dynamic shear	580 N/4cm <sup>2</sup>	Tested after 15 min., 300mm/min.	
Soft test	185 °C	0.5 °C/min, 200g, 20x15mm <sup>2</sup>	
Probe tack	925 cN/20mm <sup>2</sup>	ASTM D2979	

## Warranty

The product is guaranteed to be free from defect in material and workmanship at the time of delivery and will be suitable for use for a period of 12 months thereafter, subject to the conditions set out herein.

### Application guidelines

- Keep the tape in its original individual packaging until use.
- For optimum results, an even rub down pressure must be applied to the taped area to create the best possible adhesion between tape and the substrates.
- Remove the liner prior to usage.
- The tape should be applied to clean and dry surfaces.
- The best application conditions are obtained at a temperature between 15 °C and 40 °C.

### General conditions of use and precautions:

The properties of the product might be adversely affected by various elements such as composition, condition and surface of and impurities in or on the substrate, temperature and humidity during storage, the surrounding environment at and after application and time of exterior use. When the product is used in combination with another material or process, the user shall assure the compatibility of the product in such combination and whether this combination results in the expected performance. The same principle applies in the event of product use in extreme conditions or circumstances, whether at or after the moment of application, including extended exposure to sunlight or extreme temperatures and pressure.

### Packaging, transport and storage:

During transport and storage the product should always be protected against direct sunlight and extremes in temperature and humidity and contained in its original packaging. Once removed from its packaging, it should be promptly applied and remain shielded from direct sunlight and extreme temperature as well as protected against dust and other impurities.

### Liability:

This product is under development and Nitto will not be held to repair, replace or compensate damages in relation to this product. By using products which are under development, you waive Nitto's liability relating thereto. Replacement of products under development are at the sole discretion of Nitto. However, Nitto declares that the statements and measurements contained in this file are accurate at the mentioned date.

In no event shall Nitto be liable in respect of any indirect or consequential damages, including loss of profits. The above limitations of liability shall equally apply if Nitto Belgium has assisted in any manner with the selection, treatment or application of the product.

### Product information:

This datasheet provides a general description of the product properties and application scope. Full technical details in connection with this product are presented in the customer product specification, which is available upon request.

The information reflected in this datasheet is subject to change and the product described herein may be modified or discontinued without notice.

Nitto Belgium NV has obtained following certificates:

- ISO 9001
- ISO 14001
- IATF 16949

Please check our website for applicable scope

If you require additional information on technical properties and application as well as product sampling or testing, please contact your local Nitto sales office.

Edition: April 2021

Code: DS/10.10/E4 D5304 ENG

This datasheet replaces all previous versions