

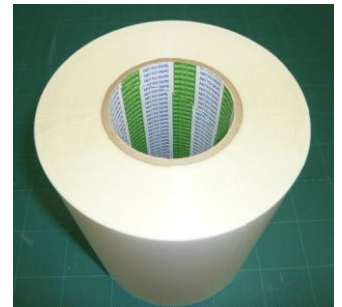
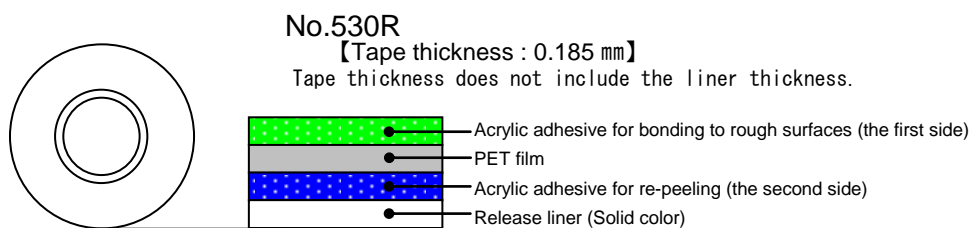
Polyester film based double-coated adhesive tape

# No.530R

### Outline

Nitto Denko No. 530R is thick polyester (PET) film based double-coated adhesive tape. Therefore it is easy to apply to the substrate. No. 530R offers excellent bonding performance to foam and seals and re-peeling performance.

### Structure



### Features

- Tape is so elastic that it's easier to work with.
- Leaves minimal adhesive residue; can be re-peeled (the second side).
- Offers superior bonding performance to many kinds of foam (the first side).
- 6 restricted substances by RoHS are not contained.

### Applications

- Bonding of cushioning and seals for OA equipment such as printers and copiers and home appliances such as televisions and air-conditioners
- Applications requiring re-peeling

### Sizes

Tape thickness (mm)	Width (mm)	Length (M)
0. 1 8 5	1 0 ~ 1, 0 0 0	5 0

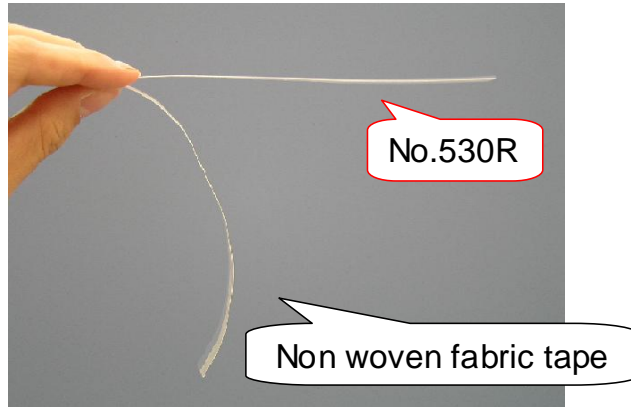
For details contact the department in charge of the product in question.

No.530R 10-P-0208\_E (1/6)

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## Properties

●Tape elasticity (shape stability)



< Sample >

Tape size : 5mm width  
Lining material : #38PET film (10mm width)

●Re-peeling properties (the second side : for re-peeling)

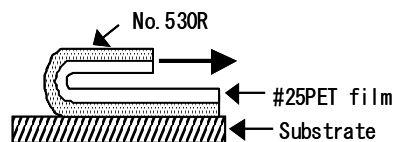
Substrate	No.530R	
	60 deg. C / 90% RH x 30 days	70 deg. C x 30 days
Stainless steel plate	○	○
Polypropyren plate	○	○
ABS plate	○	○
PCABS plate	○	○
Polystyrene plate	○	○
Polycarbonate plate	○	○

Adhesive residue

- : No adhesive residue
- △ : Some adhesive residue
- × : Large amount of adhesive residue

**【Adhesive residue test method】**

Tape width: 20 mm  
Lining material: PET film #25  
Storage condition: 60 deg. C/ 90%RH x 30days  
or 70 deg. C x 30days  
Peeling speed: 300 mm/min  
Peeling angle: 180 deg.

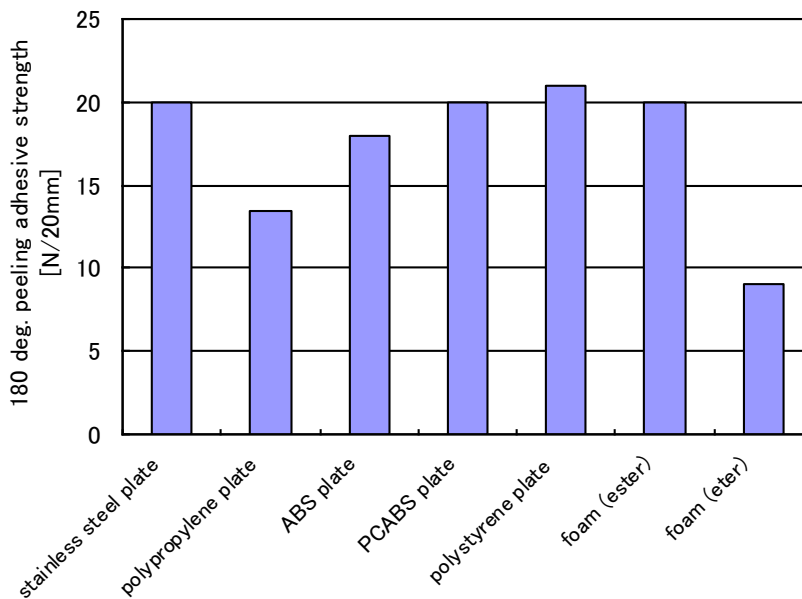


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## Properties

- 180 deg. peeling adhesive strength (the first side : for rough surfaces) - to each substrate



Substrate	No.530R
Stainless steel plate	20.0
Polypropylene plate	13.5
ABS plate	18.0
PCABS plate	20.0
Polystyrene plate	21.0
Foam (ester)	20.0*
Foam (eter)	9.0*

\* The foam is broken

(Unit: N/20 mm)

Sample size: 20mm width

Lining material: PET #25

Press method: 1 pass back and forth by 2kg roller at 23 deg. C / 50%RH

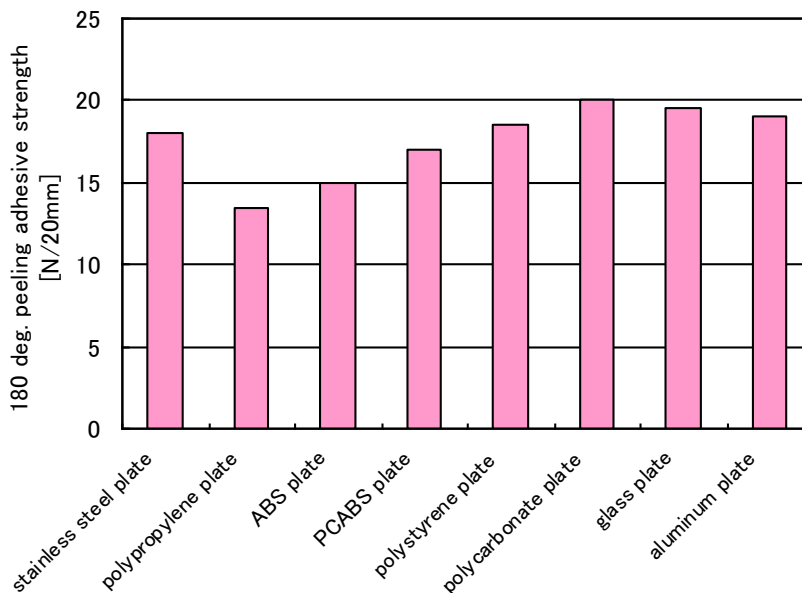
Aging condition: 23 deg. C / 50%RH x 30 minutes

Peeling speed: 300 mm/min

Peeling angle: 180 deg.

Measurement temperature: 23 deg. C / 50% RH

- 180 deg. peeling adhesive strength (the second side: for rough surfaces) - to each substrate



Substrate	No.530R
Stainless steel plate	18.0
Polypropylene plate	13.5
ABS plate	15.0
PCABS plate	17.0
Polystyrene plate	18.5
Polycarbonate plate	20.0
Glass plate	19.5
Aluminum plate	19.0

(Unit: N/20 mm)

Sample size: 20mm width

Lining material: PET #25

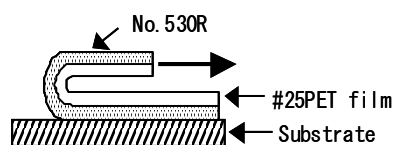
Press method: 1 pass back and forth by 2kg roller at 23 deg. C / 50%RH

Aging condition: 23 deg. C / 50%RH x 30 minutes

Peeling speed: 300 mm/min

Peeling angle: 180 deg.

Measurement temperature: 23 deg. C / 50% RH

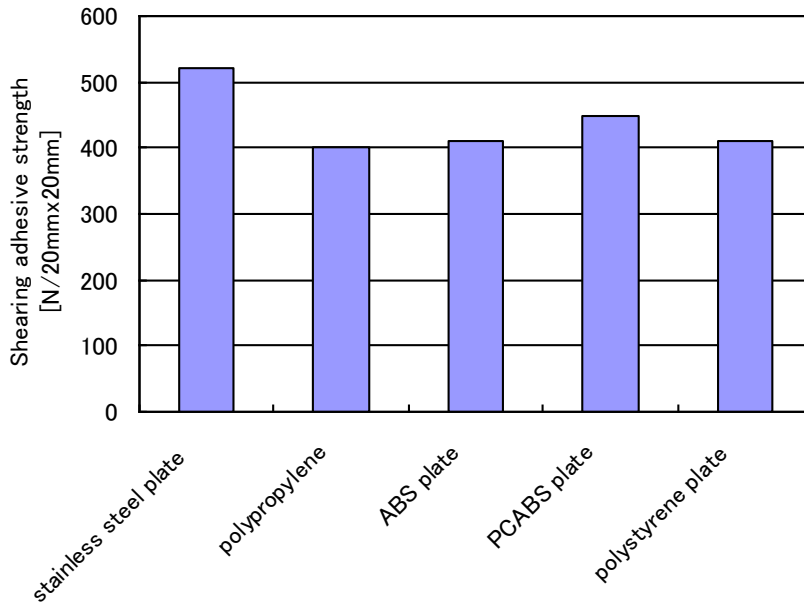


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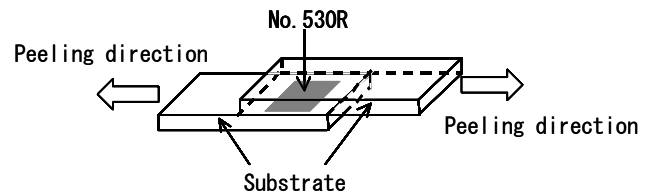
## Properties

### ● Shearing adhesive strength for each substrate - to each substrate



Substrate	No.530R
Stainless steel plate	520
Polypropylene plate	400
ABS plate	410
PCABS plate	450
Polystyrene plate	410

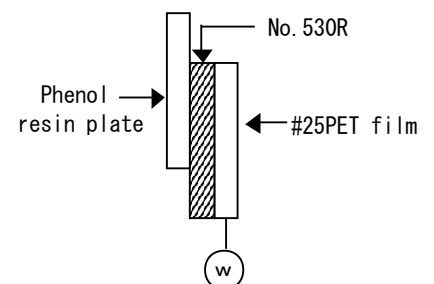
(Unit: N/20mm x 20mm)  
 Sample size: 20mm x 20mm  
 Press method: 1 pass back and forth by 5kg roller at 23 deg. C / 50%RH  
 Aging condition: 23 deg. C / 50%RH x 30 minutes  
 Measurement temperature: 23 deg. C / 50% RH  
 Peeling speed: 50 mm/min



### ● Holding strength

Measurement temperature	No.530R	
	The first side: for rough surfaces	The second side: for re-peeling
40 deg.C	0.6	0.2
60 deg.C	0.9	0.2
80 deg.C	1.3	0.2

(Unit: mm/hr)  
 Application area: 20 mm x 10 mm  
 Lining material: PET #25  
 Substrate: Phenol resin plate  
 Weight: 500g (4.90N)  
 Measurement temperature: 40, 60, 80 deg. C



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● 180 deg. peeling adhesive strength —kept in each condition after application (durability)

Condition		No.530R	
		The first side: for rough surfaces	The second side: for re-peeling
Standard Condition (23 deg. C / 50%RH × 30min)		20.0	18.0
80 deg. C	1 day	31.0	28.0
	7 days	32.5	31.0
	14 days	35.0	34.5
	30 days	38.0	36.7
40 deg. C / 92%RH	14 days	26.0	24.3
	30 days	27.5	26.3

(Unit: N/20 mm)  
 Substrate: Stainless steel plate  
 Sample size: 20mm width  
 Lining material: PET #25  
 Press method:  
 1 pass back and forth by 2kg roller  
 at 23 deg. C / 50%RH  
 Storage condition: See the left table.  
 Peeling speed: 300 mm/min  
 Peeling angle: 180 deg.  
 Measurement temperature:  
 23 deg. C / 50% RH

● 180 deg. peeling adhesive strength — various aging time

Aging time	No.530R	
	The first side: for rough surfaces	The second side: for re-peeling
1 minute	17.5	16.5
30 minutes (standard)	20.0	18.0
1 hour	20.5	18.7
4 hours	22.3	19.7
8 hours	23.5	20.3
24 hours	24.8	21.5
72 hours	25.5	22.0

(Unit: N/20 mm)  
 Substrate: Stainless steel plate  
 Sample size: 20mm width  
 Lining material: PET #25  
 Press method:  
 1 pass back and forth by 2kg roller  
 at 23 deg. C / 50%RH  
 Aging time: See the left table.  
 Aging temperature:  
 23 deg. C / 50% RH  
 Peeling speed: 300 mm/min  
 Peeling angle: 180 deg.  
 Measurement temperature:  
 23 deg. C / 50% RH

● 180 deg. peeling adhesive strength — various press strength

Press strength	No.530R	
	The first side: for rough surfaces	The second side: for re-peeling
0.1 kg roller	15.5	13.5
0.5 kg roller	18.7	15.5
2 kg roller	20.0	18.0
5 kg roller	22.3	18.2

(Unit: N/20 mm)  
 Substrate: Stainless steel plate  
 Sample size: 20mm width  
 Lining material: PET #25  
 Press method:  
 1 pass back and forth by 0.1, 0.5, 2 or  
 5 kg roller at 23 deg. C / 50%RH  
 Aging condition:  
 23 deg. C / 50%RH x 30 minutes  
 Peeling speed: 300 mm/min  
 Peeling angle: 180 deg.  
 Measurement temperature:  
 23 deg. C / 50% RH

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### Precautions when using

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- Remove all oil, moisture and dirt from the surface of the substrate before applying.
- Since the tape is pressure-sensitive adhesive, be sure to apply enough pressure with a roller or press when applying. Otherwise it might be affected to its properties and appearance.
- The tape may not adhere well to extremely uneven or distorted surfaces. Enough Leveling off the surface should be required before applying.
- It takes certain time to get full adhesive strength after applying, keep away the tape from any stress for a several hours after applying.

### Precautions when storing

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- Please be sure to keep the tape in its box when not using.
- Please keep in a cool and dark place away from direct sunlight.

### Safety precautions

 WARNING
<ul style="list-style-type: none"><li>● Make sure the product is suitable for the application (objective and conditions) before attempting to use. The tape may come off depending on the substrate to which it is applied or conditions under which it is applied.</li><li>● Use in combination with another method of joining if there is possibility of an accident.</li></ul>

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