

DuploCOLL® 6311

Art. No. 11 01 25

Double sided adhesive mounting tape with a closed-cell polyethylene copolymeric foam and high loading capacity

Product construction			
	Name	Colour	Thickness [mm]
Liner	Polyethylene paper, non-abresive	white	approx. 0,16
Adhesive covered side	Pure acrylic		
Carrier	Polyethylene vinylacetate copoly- meric foam	black	approx. 0,90 ±0,1
Adhesive open side	Pure acrylic		
Total thickness:			approx. 1,06

Product advantages

- High final adhesion.
- Excellent initial adhesion (tack).
- High resistance to temperature, ageing, UV-radiation and weathering.
- Excellent resistance to solvents and plasticizers.
- The compressible, permanently resilient foam carrier gives an extremely effective adhesion immediately after application even on rough and slightly uneven surfaces.
- DuploCOLL® 6311 absorbs vibration and compensates for different expansion coefficients of substrates that are joined.
- DuploCOLL® 6311 meets specifications in the automotive industry for interior and exterior applications.

Main application fields

- Permanent bonding of decorative and functional trims, nameplates, emblems, face plates, holder and extruded rubber profiles in the automotive industry.

Product features		Applicability on	
Initial adhesion	● ● ○	Foam	○ ○ ○
Final adhesion	● ● ●	Rubber	○ ○ ○
Dimensional stability	● ○ ○	Lacquer	● ● ●
Adhesion on even surfaces	● ● ●	Glass/Ceramics	● ● ○
Adhesion on rough surfaces	○ ○ ○	Wood	● ● ○
Ageing resistance	● ● ●	High energy plastics: PVC, PC, ABS,...	● ● ●
Weathering resistance	● ● ●	Low energy plastics: PE, PP,...	● ● ○
Chemical resistance	● ● ●	Metal	● ● ●
Resistance to plasticizers	● ● ●	Paper/Cardboard	● ● ○
● ● ● very suitable ● ● ○ suitable ● ○ ○ suitable with reductions ○ ○ ○ not suitable			

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Specific technical data*	
Temperature range	-40 °C to +95 °C
Temperature range in a rising heat test	-40 °C to +150 °C**
Resistance to cold shock	no loss of adhesion at -40 °C
Meets specification	GM TM 5907 00
Rising heat test at a steel-PET-bonding, beginning at 20 °C, increasing temperature every 30 min. by 10 °C	no loss of adhesion up to 106 °C

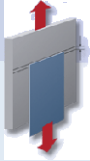
* Specific test results, statistically not approved.

** Reached temperature in a rising heat test according to the internal test method PM-211 following DIN EN 1943 at 0,5 kg strength, beginning at 30 °C, increasing of temperature every 30 minutes by 10 °C.

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Technical Data			
Dynamic shear strength	According to LOHMANN specification 0401, at +23 °C after storage of the samples in isooctane toluene dilution	115-300 N / 500 mm²	
Static shear strength	According to LOHMANN specification 0402 at +85 °C	> 30 min	

Application	
Recommended application temperature	18 °C to 35 °C
Application guidelines	www.lohmann-tapes.com

Storage
Adhesive tapes should be stored at room temperature and normal humidity (50-70 %).
The storage stability is two years after delivery.

Product presentation		
Converted product	Rolls	Spools on request
Width [mm]	> 6	> 9
Length [m]	50	100
Max. log width: 1260 mm	Other dimensions, die-cuts and sheets on request.	

For mechanical mounting of this adhesive tape we also offer a wide range of application devices.

The physical characteristics contained in our data sheets represent typical or average values. They do not represent any warranties or guarantees and must not be used for technical specification purposes. All application related statements, information and recommendations herein are given to the best of our knowledge and practical experience. The buyer is responsible for determining the suitability of the specific tape for its intended use in connection with user's method of application. Please consult our Technical Applications Department for specific advice. Our general Term and Conditions of Sale apply, particularly with regard to warranty and liability.

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