

NES	Pressure-Sensitive Adhesive Double-Coated Tapes for Automobiles							
Company Name	INTERNAL		Part Name	FM 2454		Date	1-1-25	
Classification	Class 2 No. 1		NES Symbol	NISSAN M8506				
Division	Test items			Class 2 No. 1 Criteria	Result		Test Method No.	Judgement
					Test result	Specimen failure mode		
General properties	Storage stability 40°C x 168hr	90° peel strength N/25mm		27.4 or more	49.1	CF	5.8	OK
		Shear strength kPa		314 or more	403.5	CF		OK
Work-abilities	Re-adhesion	Primary peel		During primary peel, the tape shall peel interfacially from the substrate.	12.5	AF	5.9	OK
		90° peel strength after re-adhesion N/25mm		90% or more of initial strength to be held	54.1	CF		OK
	Adhesive property	Profile followability %	30 seconds 5°C x 24 hr		80 or more	Not Tested	-	5.10
Physical properties	Adhesive strength immediately after affixing	90° peel strength N/25mm	5°C x 30 sec later	3.9 or more	10.0	AF	5.11	OK
			23°C x 30 sec later	14.7 or more	11.7	AF		NG
			23°C x 30 min later	Shall be reported	56.4	CF		OK
		L jig peel holding force hr		0.5 or more	5.65	AF		OK
	Room temp adhesion performance (23°C)	90° peel strength N/25mm		27.4 or more	58.5	CF	5.12	OK
		Shear strength kPa		314 or more	511.1	CF		OK
		L jig peel strength N/25mm		78.4 or more	127.6	AF		OK
		Shear holding force hr	1.5kg	168 or more	168.0	No Failure		OK
			4.0kg	Shall be reported	40.7	CF		Reported
		L jig peel holding force hr	2.0kg	96 or more	66.42	AF		NG
			4.0kg	Shall be reported	6.42	AF		Reported
		High temp adhesive performance Class2:Level areas 90°C Vertical areas 80°C	90° peel strength N/25mm		11.8 or more	49.2		CF
	Shear strength kPa		69 or more	125.1	CF	OK		
	L jig peel strength N/25mm		49 or more	199.2	CF	OK		
	Share holding force hr		1.0kg	168 or more	168.00	No Failure	OK	
			2.0kg	Shall be reported	0.26	CF	Reported	
	L jig peel holding force hr		0.5kg	168 or more	23.00	CF	NG	
			2.0kg	Shall be reported	1.98	CF	Reported	
	Low temp adhesion performance (-40°C)		Shear strength kPa		1470 or more	839.6	CF	5.14
		L jig peel strength N/25mm		98	212.7	CF	OK	
Endurance capability	Heat aging (90°Cx168hr)	90° peel strength N/25mm		90% or more of initial strength 27.4 to be held	43.8	CF	5.17	OK
		Shear strength kPa		90% or more of initial strength 314 to be held	560.7	CF		OK
	Warm water resistance (40°Cx168hr)	90° peel strength N/25mm		60% or more of initial strength 27.4 to be held	44.2	CF	5.19	OK
		Shear strength kPa		60% or more of initial strength 314 to be held	537.0	CF		OK
	Chemical resistance (gasoline, wax remover)	90° peel strength N/25mm		50% or more of initial strength 27.4 to be held	53.8	Gas CF	5.20	OK
					54.7	Wax CF		OK
		Shear strength kPa		50% or more of initial strength 314 to be held	511.4	Gas CF		OK
					630.7	Wax CF		Reported
	Weathering resistance (2000hr)	Shear strength kPa		90% or more of initial strength 314 to be held	Not Tested		5.21	NG
		L jig peel strength N/25mm		90% or more of initial strength 0.5 to be held	Not Tested	0		NG