VHB™ Tapes

Technical Data **October 2018**

Product Description:

3M™ VHB™ Tapes provide the convenience and simplicity of a tape fastener and are ideal for use in many interior and exterior bonding applications. In many situations, they can replace rivets, spot welds, liquid adhesives and other permanent fasteners.

These 3M™ VHB™ Tapes are made with acrylic foam which is viscoelastic in nature. This gives the foam energy absorbing and stress relaxing properties which provides these tapes with their unique characteristics. The acrylic chemistry provides outstanding durability performance.

These tapes utilize a variety of specific foam, adhesive, color and release liner types to provide each product/family with specific features. These features can include adhesion to specific or a broad range of materials, conformability, high tensile strength, high shear and peel adhesion, resistance to plasticizer migration, and UL746C recognition. All 3M™ VHB™ Tapes have excellent durability and excellent solvent and moisture resistance.

The tapes included in this data page represent products most commonly used by customers. Please refer to "3M™ VHB™ Tape Specialty Tapes" technical data sheet for additional 3M™ VHB™ Tapes that may be required in special circumstances.

3M™ VHB™ Tape Products

4941 Family

This family utilizes multi-purpose acrylic adhesive on both sides of a conformable adhesive foam core. The adhesive provides excellent adhesion to a broad range of high and medium surface energy substrates including metals, glass, and a wide variety of plastics, as well as plasticized vinyl. The conformable adhesive foam core provides good contact, even with mismatched substrates. The combination of foam strength, conformability, and adhesion makes this family one of the most capable all-around 3M™ VHB™ tapes.

Tape Number	Color	Thickness in (mm)
4919F	Black	0.025 (0.6)
4926	Gray	0.015 (0.4)
4936(F)	Gray	0.025 (0.6)
4941(F)	Gray	0.045 (1.1)
4947F	Black	0.045 (1.1)
4956(F)	Gray	0.062 (1.6)
4979F	Black	0.062 (1.6)
4991	Gray	0.090 (2.3)
4991B	Black	0.090 (2.3)

5952 Family

This family utilizes modified acrylic adhesive on both sides of a very conformable adhesive foam core, providing adhesion the broadest range of substrates, including most powder coated paints.

Tape Number	Color	Thickness in (mm)
5906	Black	0.006 (0.15)
5907	Black	0.008 (0.20)
5908	Black	0.010 (0.25)
5909	Black	0.012 (0.30)
5915(P)	Black	0.016 (0.4)
5915WF	White	0.016 (0.4)
5925(P)	Black	0.025 (0.6)
5925WF	White	0.025 (0.6)
5930(P)	Black	0.032 (0.8)
5930WF	White	0.032 (0.8)
5952(P)	Black	0.045 (1.1)
5952WF	White	0.045 (1.1)
5958FR	Black	0.040 (1.0)
5962(P)	Black	0.062 (1.6)
5962WF	White	0.062 (1.6)

RP Family

This family utilizes multi-purpose acrylic adhesive on both sides of a conformable adhesive foam core. The adhesive provides good adhesion to a broad range of high and medium surface energy substrates including metals, glass, and a wide variety of plastics. The conformable adhesive foam core provides good contact, even with mismatched substrates

Tape Number	Color	Thickness in (mm)
RP16(F)	Gray	0.016 (0.4)
RP25(F)	Gray	0.025 (0.6)
RP32(F)	Gray	0.032 (0.8)
RP45(F)	Gray	0.045 (1.1)
RP62(F)	Gray	0.062 (1.6)

(P) or (F) after the product number designates that both a paper and film liner product version are available. [e.g. 4941 (paper liner) and 4941F (film liner), 5915 (film liner) and 5915P (paper liner). See page 2 for specific details.

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.

3M™ VHB™ Tapes				Adhesive and Foam			Release Liner		
Family	Number	Color	Tape Thickness Inches (mm) Tolerance	Adhesive Type	Foam Type	Density lb/ft³ (kg/m³)	Type	Thickness Inches (mm)	Color
4941	4919F	Black	0.025 (0.6) ± 15%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
	4926	Gray	0.015 (0.4) ± 15%	Multi-Purp	Conform	45 (720)	Dk Paper	0.003 (0.08)	White (printed)
	4936	Gray	0.025 (0.6) ± 15%	Multi-Purp	Conform	45 (720)	Dk Paper	0.003 (0.08)	White (printed)
	4936F	Gray	0.025 (0.6) ± 15%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
	4941	Gray	0.045 (1.1) ± 10%	Multi-Purp	Conform	45 (720)	Dk Paper	0.003 (0.08)	White (printed)
	4941F	Gray	0.045 (1.1) ± 10%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red
	4947F	Black	0.045 (1.1) ± 10%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
	4956	Gray	0.062 (1.6) ± 10%	Multi-Purp	Conform	45 (720)	Dk Paper	0.003 (0.08)	White (printed)
	4956F	Gray	0.062 (1.6) ± 10%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
	4979F	Black	0.062 (1.6) ± 10%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
	4991	Gray	0.090 (2.3) ± 10%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
	4991B	Black	0.090 (2.3) ± 10%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
5952	5906	Black	0.006 (0.15) ± 15%	Modified	Very Conf	45 (720)	PET	0.003 (0.08)	Clear
	5907	Black	0.008 (0.20) ± 15%	Modified	Very Conf	45 (720)	PET	0.003 (0.08)	Clear
	5908	Black	0.010 (0.25) ± 15%	Modified	Very Conf	45 (720)	PET	0.003 (0.08)	Clear
	5909	Black	0.012 (0.30) ± 15%	Modified	Very Conf	45 (720)	PET	0.003 (0.08)	Clear
	5915	Black	0.016 (0.4) ± 15%	Modified	Very Conf	43 (690)	PE Film	0.005 (0.13)	Red (printed)
	5915P	Black	0.016 (0.4) ± 15%	Modified	Very Conf	43 (690)	PCK Paper	0.004 (0.10)	White (printed)
	5915WF	White	0.016 (0.4) ± 15%	Modified	Very Conf	43 (690)	PE Film	0.005 (0.13)	Red (printed)
	5925	Black	0.025 (0.6) ± 15%	Modified	Very Conf	37 (590)	PE Film	0.005 (0.13)	Red (printed)
	5925P	Black	0.025 (0.6) ± 15%	Modified	Very Conf	37 (590)	PCK Paper	0.004 (0.10)	White (printed)
	5925WF	White	0.025 (0.6) ± 15%	Modified	Very Conf	37 (590)	PE Film	0.005 (0.13)	Red (printed)
	5930	Black	0.032 (0.8) ± 15%	Modified	Very Conf	37 (590)	PE Film	0.005 (0.13)	Red (printed)
	5930P	Black	0.032 (0.8) ± 15%	Modified	Very Conf	37 (590)	PCK Paper	0.004 (0.10)	White (printed)
	5930WF	White	0.032 (0.8) ± 15%	Modified	Very Conf	37 (590)	PE Film	0.005 (0.13)	Red (printed)
	5952	Black	0.045 (1.1) ± 10%	Modified	Very Conf	37 (590)	PE Film	0.005 (0.13)	Red (printed)
	5952P	Black	0.045 (1.1) ± 10%	Modified	Very Conf	37 (590)	PCK Paper	0.004 (0.10)	White (printed)
	5952WF	White	0.045 (1.1) ± 10%	Modified	Very Conf	37 (590)	PE Film	0.005 (0.13)	Red (printed)
	5958FR	Black	0.040 (1.0) ± 10%	Modified	Very Conf	50 (800)	PE Film	0.005 (0.13)	Red (printed)
	5962	Black	0.062 (1.6) ± 10%	Modified	Very Conf	37 (590)	PE Film	0.005 (0.13)	Red (printed)
	5962P	Black	0.062 (1.6) ± 10%	Modified	Very Conf	37 (590)	PCK Paper	0.004 (0.10)	White (printed)
	5962WF	White	0.062 (1.6) ± 10%	Modified	Very Conf	37 (590)	PE Film	0.005 (0.13)	Red (printed)
RP	RP16	Gray	0.016 (0.4) ± 15%	Multi-Purp	Conform	45 (720)	Dk Paper	0.003 (0.08)	White (printed)
	RP16F	Gray	0.016 (0.4) ± 15%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
	RP25	Gray	0.025 (0.6) ± 15%	Multi-Purp	Conform	45 (720)	Dk Paper	0.003 (0.08)	White (printed)
	RP25F	Gray	0.025 (0.6) ± 15%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
	RP32	Gray	0.032 (0.8) ± 15%	Multi-Purp	Conform	45 (720)	Dk Paper	0.003 (0.08)	White (printed)
	RP32F	Gray	0.032 (0.8) ± 15%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
	RP45	Gray	0.045 (1.1) ± 10%	Multi-Purp	Conform	45 (720)	Dk Paper	0.003 (0.08)	White (printed)
	RP45F	Gray	0.045 (1.1) ± 10%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)
	RP62	Gray	0.062 (1.6) ± 10%	Multi-Purp	Conform	45 (720)	Dk Paper	0.003 (0.08)	White (printed)
	RP62F	Gray	0.062 (1.6) ± 10%	Multi-Purp	Conform	45 (720)	PE Film	0.005 (0.13)	Red (printed)

Available Sizes

Tape Thickness inches (mm)	Standard Length yards (meters)	Minimum Width inches (mm)	Maximum Width inches (mm)	Maximum Roll Length		
				Width 1/4"up to 3/8" (6.4mm up to 9.5mm) yards (meters)	Width >3/8" up to 1/2" (>9.5mm up to 12.7mm) yards (meters)	Width 1/2" and wider (12.7mm and wider) yards (meters)
< 0.015 (0.4)	72 (65.8)	0.5 (13)	46 (1168)	N/A N/A	N/A N/A	See Note Below
0.015/0.016 (0.4)	72 (65.8)	0.25 (6)	48* (1219)	144 (131.7)	175 (160.0)	360 (329.2)
0.025 (0.6)	72 (65.8)	0.25 (6)	48* (1219)	72 (65.8)	108 (98.8)	175 (160.0)
0.032 (0.8)	72 (65.8)	0.25 (6)	48 (1219)	72 (65.8)	108 (98.8)	175 (160.0)
0.040 (1.0)	36 (32.9)	0.25 (6)	48 (1219)	72 (65.8)	108 (98.8)	144 (131.7)
0.045 (1.1)	36 (32.9)	0.25 (6)	48 (1219)	72 (65.8)	108 (98.8)	144 (131.7)
0.062 (1.6)	36 (32.9)	0.25 (6)	46 (1168)	72 (65.8)	72 (65.8)	108 (98.8)
0.090 (2.3)	36 (32.9)	0.25 (6)	46 (1168)	36 (32.9)	36 (32.9)	72 (65.8)

*Exception – 5915 (P) max. width 46 inches (1168 mm); 5925 (P) max. width 47 inches (1194 mm).

Note: 5952 family tapes thinner than 0.015 in (0.4 mm) have max. length 360 yd (329.2 m) for widths 1 in (25 mm) to 8 in (203 mm) and 180 yd (164.6 m) for all other widths.

Slitting Tolerance

Standard slitting tolerance ± 1/32 inch (± 0.031 inch, ± 0.79 mm).

Precision slitting with slitting tolerance of ± 1/64 inch (± 0.016 in., ± 0.41 mm) is available on select products with minimum order of full web increments.

Core Size

All products are provided on a 3 inch ID Core (76.2 mm)

Converted Parts

In addition to standard and custom roll sizes available from 3M through the distribution network, 3M™ VHB™ Tapes are also available in limitless shapes and sizes through the 3M Converter network. For additional information, contact 3M Converter Markets at 1-800-223-7427 or on the web at www.3M.com/converter.

Shelf Life

All 3M™ VHB™ Tapes have a shelf life of 24 months from date of manufacture when stored at 40°F to 100°F (4°C to 38°C) and 0-95% relative humidity. The optimum storage conditions are 72°F (22°C) and 50% relative humidity.

Performance of tapes is not projected to change even after shelf life expires; however, 3M does suggest that 3M™ VHB™ Tapes are used prior to the shelf life date whenever possible.

The manufacturing date is available on all 3M™ VHB™ Tape cores as the lot number. The lot number, typically a 4 digit code, is a Julian date (Y D D D). The first digit refers to the year of manufacture, the last 3 digits refer to the days after January 1. Example: A lot number of 9266 would translate to a date of manufacture of Sept. 22 (266th day of year) in 2009. On most products this is found as the 4 digits after the “9” following the product number. For tapes printed continuously around the core (e.g. 3M™ VHB™ Tape 5952 family) the lot number typically will be the string of 4 digits preceding the product number.

Special Cases:

Plasticized Vinyl – Plasticizers compounded in soft vinyl can migrate into adhesives and significantly change their performance characteristics. 3M™ VHB™ Tapes 4941 family has very good plasticizer resistance and adhesion to many vinyl formulations. Because of the wide variation in vinyl formulations, however, evaluation by the user must be conducted with the specific vinyl used to ensure that performance will be satisfactory over time. Problems related to plasticizer migration can often be predicted by accelerated aging of assembled parts at 150°F (66°C) for one week).

Typical Performance Characteristics

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

3M™ VHB™ Tapes				Dynamic Adhesion Performance		
Family	Product Number	Color	Thickness Inches	90° Peel Adhesion lb/in N/cm	Normal Tensile lb/in² kPa	Dynamic Overlap Shear lb/in² kPa
4941	4919F	Black	0.025	17 (30)	90 (620)	80 (550)
	4926	Gray	0.015	14 (25)	95 (660)	90 (620)
	4936(F)	Gray	0.025	17 (30)	90 (620)	80 (550)
	4941(F)	Gray	0.045	22 (39)	85 (590)	70 (480)
	4947F	Black	0.045	22 (39)	85 (590)	70 (480)
	4956(F)	Gray	0.062	22 (39)	80 (550)	70 (480)
	4979F	Black	0.062	22 (39)	80 (550)	70 (480)
	4991	Gray	0.090	22 (39)	70 (480)	65 (450)
	4991B	Black	0.090	22 (39)	70 (480)	65 (450)
5952	5906	Black	0.006	9 (16)	100 (690)	100 (690)
	5907	Black	0.008	10 (18)	100 (690)	100 (690)
	5908	Black	0.010	12 (21)	100 (690)	100 (690)
	5909	Black	0.012	12 (21)	100 (690)	100 (690)
	5915(P)	Black	0.016	14 (25)	90 (620)	90 (620)
	5915WF	White	0.016	14 (25)	90 (620)	90 (620)
	5925(P)	Black	0.025	17 (30)	90 (620)	90 (620)
	5925WF	White	0.025	17 (30)	90 (620)	90 (620)
	5930(P)	White	0.032	19 (33)	90 (620)	85 (590)
	5930WF	Black	0.032	19 (33)	90 (620)	85 (590)
	5952(P)	Black	0.045	22 (39)	90 (620)	80 (550)
	5952WF	White	0.045	22 (39)	90 (620)	80 (550)
	5958FR	Black	0.040	20 (35)	100 (690)	100 (690)
	5962(P)	Black	0.062	22 (39)	90 (620)	80 (550)
	5962WF	White	0.062	22 (39)	90 (620)	80 (550)
RP	RP16(F)	Gray	0.016	12 (21)	95 (660)	90 (620)
	RP25(F)	Gray	0.025	17 (30)	90 (620)	80 (550)
	RP32(F)	Gray	0.032	18 (32)	85 (590)	75 (520)
	RP45(F)	Gray	0.045	20 (35)	85 (590)	70 (480)
	RP62(F)	Gray	0.062	20 (35)	80 (550)	70 (480)

90° Peel Adhesion - Based on ASTM D3330 -To stainless steel, room temperature, jaw speed 12 in/min (304.8 mm/min). Average force to remove is measured. 72 hour dwell.

Normal Tensile (T-Block Tensile) - ASTM D-897 - To aluminum, room temperature, 1 in² (6.45 cm²), jaw speed 2 in/min (50.8 mm/min) Peak force to separate is measured. 72 hour dwell.

Dynamic Overlap Shear - ASTM D-1002 - To stainless steel, room temperature, 1 in² (6.45 cm²), jaw speed 0.5 in/min (12.7 mm/min) Peak force to separate is measured. 72 hour dwell.

Typical Performance Characteristics

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

3M™ VHB™ Tapes				Static Shear				Temperature Tolerance	
Family	Product Number	Color	Thickness Inches	72°F (22°C)	150°F (66°C)	200°F (93°C)	250°F (121°C)	Short Term (Minutes, Hours) °F (°C)	Long Term (Days, Weeks) °F (°C)
4941	4919F	Black	0.025	1000	500	500		300 (149)	200 (93)
	4926	Gray	0.015	1000	500	500		300 (149)	200 (93)
	4936(F)	Gray	0.025	1000	500	500		300 (149)	200 (93)
	4941(F)	Gray	0.045	1000	500	500		300 (149)	200 (93)
	4947F	Black	0.045	1000	500	500		300 (149)	200 (93
	4956(F)	Gray	0.062	1000	500	500		300 (149)	200 (93)
	4979F	Black	0.062	1000	500	500		300 (149)	200 (93)
	4991	Gray	0.090	1000	500	500		250 (121)	200 (93)
	4991B	Black	0.090	1000	500	500		250 (121)	200 (93)
5952	5906	Black	0.006	1000	500	500	250	300 (149)	250 (121)
	5907	Black	0.008	1000	500	500	250	300 (149)	250 (121)
	5908	Black	0.010	1000	500	500	250	300 (149)	250 (121)
	5909	Black	0.012	1000	500	500	250	300 (149)	250 (121)
	5915(P)	Black	0.016	1000	500	500	250	300 (149)	250 (121)
	5915WF	White	0.016	1000	500	500	250	300 (149)	250 (121)
	5925(P)	Black	0.025	1000	500	500	250	300 (149)	250 (121)
	5925WF	Black	0.032	1000	500	500	250	300 (149)	250 (121)
	5930(P)	Black	0.032	1000	500	500	250	300 (149)	250 (121)
	5930WF	White	0.032	1000	500	500	250	300 (149)	250 (121)
	5952(P)	Black	0.045	1000	500	500	250	300 (149)	250 (121)
	5952WF	White	0.045	1000	500	500	250	300 (149)	250 (121)
	5958FR	Black	0.040	1000	350	250		300 (149)	200 (93)
	5962(P)	Black	0.062	1000	500	500	250	300 (149)	250 (121)
	5962WF	White	0.062	1000	500	500	250	300 (149)	250 (121)
RP	RP16(F)	Gray	0.016	1000	500	500		250 (121)	200 (93)
	RP25(F)	Gray	0.025	1000	500	500		250 (121)	200 (93)
	RP32(F)	Gray	0.032	1000	500	500		250 (121)	200 (93)
	RP45(F)	Gray	0.045	1000	500	500		250 (121)	200 (93)
	RP62(F)	Gray	0.062	1000	500	500		250 (121)	200 (93)



Static Shear - ASTM D3654 - To stainless steel, tested at various temperatures and gram loadings. 0.5 in^2 (3.23 cm^2). Will hold listed weight for 10,000 minutes (approximately 7 days). Conversion: 1500 g/0.5 in^2 equals 6.6 lb/in^2; 500 g/0.5 in^2 = 2.2 lb/in^2.

Short Term Temperature Tolerance - No change in room temperature dynamic shear properties following 4 hours conditioning at indicated temperature with 100 g/static load. (Represents minutes, hours in a process type temperature exposure).

Long Term Temperature Tolerance - Maximum temperature where tape supports at least 250 g load per 0.5 in^2 in static shear for 10,000 minutes. (Represents continuous exposure for days or weeks).

Additional Typical Performance Characteristics

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

	3M™ VHB™ Tape 4941	3M™ VHB™ Tape 5952	Units	Test Standard
Dielectric Constant	2.29 1.99	2.14 1.95	at 1 kHz at 1MHz	ASTM D150 ASTM D150
Dissipation Factor	0.0245 0.0374	0.0065 0.0506	at 1 kHz at 1MHz	ASTM D150 ASTM D150
Dielectric Breakdown Strength	14 (360)	18 (455)	V/µm (V/mil)	ASTM D140
Thermal Conductivity (k value)	0.08 (0.5)	0.05 (0.4)	W/mK (BTU•in/hr•ft²•°F)	
Volume Resisitivity	2.1 x 10^{14}	2.5 x 10^{14}	Ω-cm	ASTM D257
Surface Resisitivity	2.7 x 10^{14}	>10^{16}	Ω/sq	ASTM D257
Water Vapor Transmission Rate	25.6	37.1	g/m²•day	ASTM F1249 at 38°C/100% RH
Thermal Properties of Modeling				
Thermal Coefficient of Expansion	180 (100)		10^{-6} m/m/°C (10^{-6} in/in/°F)	
Shear Modulus (at 25°C, 1 Hz)	3 x 10^{5}		Pa	

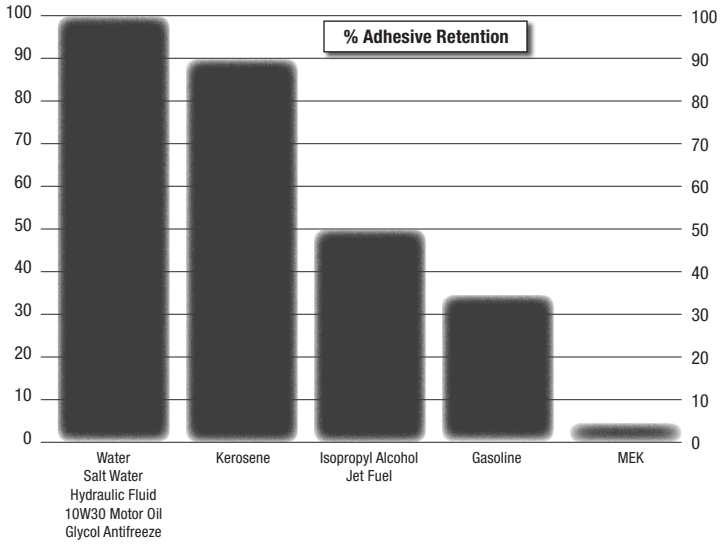
3M™ VHB™ Tapes
UL746C Listings - File MH 17478

Category QOQW2 Component - Polymeric Adhesive Systems, Electrical Equipment

3M™ VHB™ Tapes/ Product Families	Substrates	Temperature Rating Minimum	Maximum
4919F, 4926, 4936, 4936F, 4941, 4941F, 4947F, 4956, 4956F, 4979F	Ceramic	-35°C	110°C
	Aluminum, Galvanized Steel, Stainless Steel, Enameled Steel, Nickel Coated ABS, Glass (with or without Silane Coating) PVC, Glass/Epoxy, PBT, Polycarbonate, Acrylic/Polyurethane Paint, Polyester Paint	-35°C	90°C
	ABS	-35°C	75°C
4991	Polycarbonate, Aluminum, Acrylic/ Polyurethane Paint, Polyester Paint	-35°	90°C
5915, 5915P, 5915WF 5925, 5925P, 5925WF, 5930, 5030P, 5930WF, 5952, 5952P, 5952WF, 5962, 5962P, 5962WF	Polycarbonate, Primer 94 Coated Polycarbonate, Aluminum, Acrylic/ Polyurethane Paint, Galvanized Steel, Polyester Paint, Epoxy Paint, Silane Coated Glass, Uncoated Glass, Stainless Steel, Enameled Steel, Glass Epoxy, Polybutylene Terephthalate, Nylon, Polyphenelene Ether (PPE), Acrylic	-35°C	90°C
	Rigid PVC, ABS	-35°C	75°C
5952, 5952P, 5952WF	Cellulose Acetate Butyrate	-35°C	90°C
RP16	Aluminum, Silane Coated Glass	-35°C	90°C
	PVC, ABS	-35°C	75°C
RP16, RP25, RP32, RP45, RP62	Galvanized Steel, Enameled Steel, Nylon, Polycarbonate, Glass Epoxy, Phenolic, PPE/PS Blend, PBT, Epoxy Paint, Polyester Paint, Adhesion Promoter 111 Coated Epoxy Paint, Promoter 111 Coated Polyester Paint, Acrylic Urethane Paint, Epoxy/ Polyester Paint	-35°C	90°C
RP62	Stainless Steel, Glass, Acrylic	-35°C	90°C
	PVC, ABS	-35°C	75°C

A current list can be found at www.ul.com (select certifications, search file MH17478)

Solvent and Fuel Resistance



Test Method

- Tape between stainless steel and aluminum foil
- 72 hours dwell at room temperature
- Solvent immersion for 72 hours
- Test within 45 minutes after removing from solvent
- 90° peel angle
- 12 in/min rate of peel
- Peel adhesion compared to control

Note: Continuous submersion in chemical solutions is not recommended. The above information is presented to show that occasional chemical contact should not be detrimental to tape performance in most applications in ordinary use.

Burn Characteristics 3M™ VHB™ Tape 5958FR
Meets FAR 25.853 (a) 12 second vertical burn, Appendix F, Part I (a)(ii)
Meets NBS Smoking Density (ASTM F814/E662)
Meets Toxicity (Draeger Tube ABD0031, AITM 3.0005)

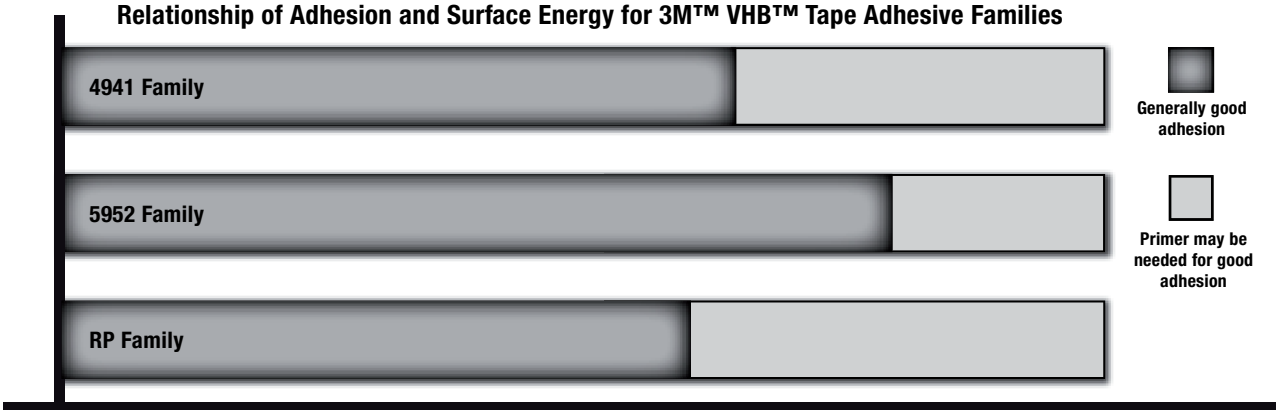
Design and Tape Selection Considerations

► **Choose the right tape for the substrate:** Adhesives must flow onto the substrate surfaces in order to achieve intimate contact area and allow the molecular force of attraction to develop. The degree of flow of the adhesive on the substrate is largely determined by the surface energy of the substrate.



This illustration demonstrates the effect of surface energy on adhesive interfacial contact. High surface energy materials draw the adhesive closer for high bond strength.

Relationship of Adhesion and Surface Energy for 3M™ VHB™ Tape Adhesive Families



1100-400	50-42	39-38	37-36	33-18
(High)		**(Medium)**		**(Low)**

Surface Energy (Dynes/cm)

Aluminum	Polyimide	ABS	PVA	EVA
Stainless Steel	Phenolic	Polycarbonate	Polystyrene	Polyethylene
Copper	Nylon	PVC	Acetal	Polypropylene
Zinc	Alkyd Enamel	PPE	PVDF Paint	PVF
Tin	Polyester	Acrylic	Powder Paint	Silicone
Lead	Epoxy Paint	PU Enamel		PTFE
Anodized Aluminum	Polyurethane	Powder Paint		
Glass				

NOTES: There are a wide variety of formulations, surfaces finishes and surface treatments available on substrate materials which can affect adhesion. This chart is intended to provide only a rough estimate of the adhesion levels which can be expected on some common materials relative to a reference surface such as aluminum.

Foam type can affect and/or limit maximum adhesive strength.

► **Use the right tape thickness:** The necessary thickness of tape depends on the rigidity of substrates and their flatness irregularity. While the 3M™ VHB™ Tapes will conform to a certain amount of irregularity, they will not flow to fill gaps between the materials. For bonding rigid materials with normal flatness, consider use of tapes with thickness of 45 mils (1.1 mm) or greater. As the substrate flexibility increases thinner tapes can be considered.

► **Use the right amount of tape:** Because 3M™ VHB™ Tapes are viscoelastic by nature their strength and stiffness is a function of the rate at which they are stressed. They behave stronger with relatively faster rate of stress load (dynamic stresses) and will tend to show creep behavior with stress load acting over a long period of time (static stresses). As a general rule, for **static loads,** approximately four square inches of tape should be used for each pound (57 cm^2 of tape per kg) of weight to be supported in order to prevent excessive creep. For **dynamic loads,** the dynamic performance characteristics provided on page 4 should be useful, factoring in the appropriate safety factors.

► **Allow for thermal expansion/contraction:** 3M™ VHB™ Tapes can perform well in applications where two bonded surfaces may expand and contract differentially. Assuming good adhesion to the substrates, the tapes can typically tolerate differential movement in the shear plane up to 3 times their thickness.

► **Bond Flexibility:** While an advantage for many applications where allowing differential movement is a benefit, the tape bonds are typically more flexible than alternative bonding methods. Suitable design modifications or periodic use of rigid fasteners or adhesives may be needed if additional stiffness is required.

► **Severe Cold Temperature:** Applications which require performance at severe cold temperatures must be thoroughly evaluated by the user if the intended use will subject the tape product to high impact stresses. A technical bulletin "3M™ VHB™ Tape Cold Temperature Performance" (70-0707-3991-0) is available for additional information.

Application Techniques

► **Clean:** Most substrates are best prepared by cleaning with a 50:50 mixture of isopropyl alcohol (IPA*) and water prior to applying 3M™ VHB™ Tapes.

Exceptions to the general procedure that may require additional surface preparation include:

- **Heavy Oils:** A degreaser or solvent-based cleaner may be required to remove heavy oil or grease from a surface and should be followed by cleaning with IPA/water.
- **Abrasion:** Abrading a surface, followed by cleaning with IPA/water, can remove heavy dirt or oxidation and can increase surface area to improve adhesion.
- **Adhesion Promoters:** Priming a surface can significantly improve initial and ultimate adhesion to many materials such as plastics and paints.
- **Porous surfaces:** Most porous and fibered materials such as wood, particleboard, concrete, etc. need to be sealed to provide a unified surface.
- **Unique Materials:** Special surface preparation may be needed for glass and glass-like materials, copper and copper containing metals, and plastics or rubber that contain components that migrate (e.g. plasticizers).

Refer to 3M Technical Bulletin "Surface Preparation for 3M™ VHB™ Tape Applications" for additional details and suggestions. (70-0704-8701-5)

***Note:** These cleaner solutions contain greater than 250 g/l of volatile organic compounds (VOC). Please consult your local Air Quality Regulations to be sure the cleaner is compliant. When using solvents, be sure to follow the manufacturer's precautions and directions for use when handling such materials.

► **Pressure:** Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact and helps improve bond strength. Typically, good surface contact can be attained by applying enough pressure to insure that the tape experiences approximately 15 psi (100 kPa) pressure. Either roller or platen pressure can be used. Note that rigid surfaces may require 2 or 3 times that much pressure to make the tape experience 15 psi.

► **Temperature:** Ideal application temperature range is 70°F to 100°F (21°C to 38°C). Pressure sensitive adhesives use viscous flow to achieve substrate contact area. Minimum suggested application temperatures:

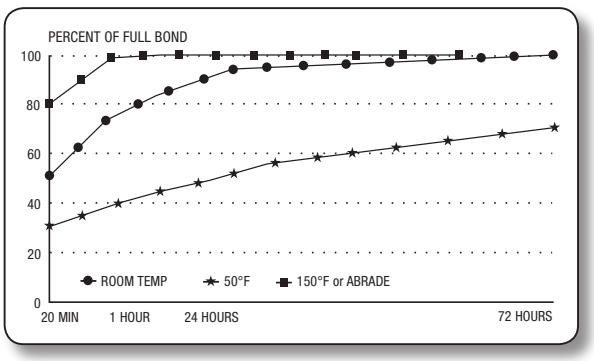
- 50°F (10°C): 3M™ VHB™ Tapes 5952 and RP families.
- 60°F (15°C): 3M™ VHB™ Tape 4941 family.

Note: Initial tape application to surfaces at temperatures below these suggested minimums is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

To obtain good performance with all 3M™ VHB™ Tapes, it is important to ensure that the surfaces are dry and free of condensed moisture.

► **Time:** After application, the bond strength will increase as the adhesive flows onto the surface (also referred to as "wet out"). At room temperature approximately 50% of ultimate bond strength will be achieved after 20 minutes, 90% after 24 hours and 100% after 72 hours. This flow is faster at higher temperatures and slower at lower temperatures. Ultimate bond strength can be achieved more quickly (and in some cases bond strength can be increased) by exposure of the bond to elevated temperatures (e.g. 150°F [66°C] for 1 hour). This can provide better adhesive wetout onto the substrates. Abrasion of the surfaces or the use of primers/ adhesion promoters can also have the effect of increasing bond strength and achieving ultimate bond strength more quickly.

Bond Typical Build vs. Time



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Industrial Adhesives and Tapes Division

3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550 • 877-369-2923 (Fax)
www.3M.com/vhb

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