



# VHB™ Tapes

### 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.

**Note:** All 3M™ VHB™ Tapes should be thoroughly evaluated by the end user under actual use conditions with intended substrates to determine whether a specific tape is fit for a particular purpose and suitable for user’s method of application, especially if expected use involves extreme environmental conditions or high dead load stress.

### 3M™ VHB™ Tape Products

| Tape Number | Color   | Thickness in. (mm) | Tape Number | Color | Thickness in. (mm) | Tape Number | Color | Thickness in. (mm) |
|-------------|---------|--------------------|-------------|-------|--------------------|-------------|-------|--------------------|
| 4611        | Dk Gray | 0.045 (1.1)        | 4930 (F)    | White | 0.025 (0.64)       | 4955        | White | 0.080 (2.0)        |
| 4618        | White   | 0.025 (0.64)       | 4932        | White | 0.025 (0.64)       | 4956 (F)    | Gray  | 0.062 (1.55)       |
| 4622        | White   | 0.045 (1.1)        | 4936 (F)    | Gray  | 0.025 (0.64)       | 4957F       | Gray  | 0.062 (1.55)       |
| 4624        | White   | 0.062 (1.55)       | 4941 (F)    | Gray  | 0.045 (1.1)        | 4959 (F)    | White | 0.120 (3.0)        |
| 4646        | Dk Gray | 0.025 (0.64)       | 4943F       | Gray  | 0.045 (1.1)        | 4979F       | Black | 0.062 (1.55)       |
| 4655        | Dk Gray | 0.062 (1.55)       | 4945        | White | 0.045 (1.1)        | 4991        | Gray  | 0.090 (2.3)        |
| 4905        | Clear   | 0.020 (0.5)        | 4946        | White | 0.045 (1.1)        | 5915 (P)    | Black | 0.016 (0.4)        |
| 4910        | Clear   | 0.040 (1.0)        | 4947F       | Black | 0.045 (1.1)        | 5925 (P)    | Black | 0.025 (0.64)       |
| 4919F       | Black   | 0.025 (0.64)       | 4949        | Black | 0.045 (1.1)        | 5930 (P)    | Black | 0.032 (0.8)        |
| 4920        | White   | 0.015 (0.4)        | 4950        | White | 0.045 (1.1)        | 5952 (P)    | Black | 0.045 (1.1)        |
| 4926        | Gray    | 0.015 (0.4)        | 4951        | White | 0.045 (1.1)        | 5958FR      | Black | 0.040 (1.0)        |
| 4929        | Black   | 0.025 (0.64)       | 4952        | White | 0.045 (1.1)        | 5962 (P)    | Black | 0.062 (1.55)       |

(F) or (P) after the product number designate that both a paper and film liner product version are available. [e.g. 4930 (paper liner) and 4930F (film liner), 5915 (film liner) and 5915P (paper liner)]. See page 3 for specific details.

### 3M™ VHB™ Tapes Adhesive Types:

**Multi-Purpose Acrylic:** This adhesive bonds to a wide range of materials including metals, glass, and high and medium surface energy plastics and paints. This unique adhesive also has the ability to resist migration of plasticizers in vinyl substrates.

**Modified Acrylic:** This adhesive bonds to medium low surface energy paints and plastics, including many powder coated paints in addition to the substrates listed with the multi-purpose acrylic adhesive (except plasticized vinyl).

**General Purpose Acrylic:** This adhesive bonds to most higher surface energy substrates including metal, glass and high surface energy plastics.

**Low Temperature Applicable Acrylic:** This adhesive can make bonds down to 32°F (0°C), compared to 50°F (10°C) for most acrylic adhesives. This adhesive system bonds to most high surface energy substrates including metal, glass and high surface energy plastics.

**Low Surface Energy:** This high performance synthetic adhesive bonds to many lower surface energy substrates, including many plastics and power coated paints, plus smooth general purpose substrates.

### 3M™ VHB™ Tapes Foam Types:

**Conformable:** This foam provides high strength with the capability of conforming to the irregularities of rigid substrates, even when there might be slight mismatch.

**Very Conformable:** This foam provides the highest level of conformability while maintaining high internal strength.

**Firm:** This foam provides the highest level of foam strength in the 3M™ VHB™ Tapes family.

**Clear:** Not technically a foam, this solid acrylic material provides excellent clarity.

# 3M™ VHB™ Tapes

## 3M™ VHB™ Tape Families:

- 4941** This family utilizes multi-purpose acrylic adhesive on both sides of conformable foam. 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 foam provides good contact, even with mismatched substrates. Available in gray and black.
- 5952** This family matches the modified acrylic adhesive on both sides of very conformable foam, providing adhesion to the broadest range of substrates, including most powder coated paints. Available in black.
- 4950** This family has general purpose adhesive on both sides of firm type foam. This family is typically used on metal, glass and high surface energy plastic substrates. Available in white and black.
- 4945** This family has multi-purpose adhesive on both sides of firm foam. Available in white.
- 4910** This family of clear tapes is excellent for applications where clear or colorless is desired. The general purpose adhesive on both sides is suitable for high surface energy substrates.
- 4951** This family of tapes is based around the low temperature applicable acrylic adhesive system, utilized on both firm and conformable foam types. These products are suitable for high surface energy substrates. Available in white (firm foam) and gray (conformable foam).
- 4952** This family utilizes the low surface energy adhesive on a firm foam. Available in white.
- 4611** This family has a general purpose adhesive on both sides of firm foam. This family of tapes is typically used on metal substrates, and has the added feature of high temperature resistance, making it often suitable for bonding prior to high temperature paint processing. Available in dark gray.
- 4622** This family has general purpose adhesive on the face side (the side that typically would be bonded first) and multi-purpose adhesive on the liner side (the side exposed when the release liner is removed) of a conformable foam. Available in white.

## 3M™ VHB™ Tape Product Family Guide

| Thickness<br>inches<br>(mm) | Family ▶    | 4941          |         | 5952          | 4950            |       | 4945         | 4910     | 4951           |         | 4952  | 4611     | 4622      |
|-----------------------------|-------------|---------------|---------|---------------|-----------------|-------|--------------|----------|----------------|---------|-------|----------|-----------|
|                             | Color ▶     | Gray          | Black   | Black         | White           | Black | White        | Clear    | White          | Gray    | White | Dk Gray  | White     |
|                             | Foam type ▶ | Conform       | Conform | Very Conf     | Firm            | Firm  | Firm         | n/a      | Firm           | Conform | Firm  | Firm     | Conform   |
|                             | Adhesive ▶  | Multi-Purpose |         | Modified      | General Purpose |       | Multi-Purp   | Gen-Purp | Low Temp Apply |         | LSE   | Gen-Purp | Gen/Multi |
| 0.015 / 0.016<br>(0.4)      |             | 4926          |         | 5915<br>5915P | 4920            |       |              |          |                |         |       |          |           |
| 0.020<br>(0.5)              |             |               |         |               |                 |       | 4905         |          |                |         |       |          |           |
| 0.025<br>(0.64)             |             | 4936<br>4936F | 4919F   | 5925<br>5925P | 4930<br>4930F   | 4929  |              |          |                | 4932    |       | 4646     | 4618      |
| 0.032<br>(0.8)              |             |               |         | 5930<br>5930P |                 |       |              |          |                |         |       |          |           |
| 0.040<br>(1.0)              |             |               |         | 5958FR        |                 |       |              | 4910     |                |         |       |          |           |
| 0.045<br>(1.1)              |             | 4941<br>4941F | 4947F   | 5952<br>5952P | 4950            | 4949  | 4945<br>4946 |          | 4951           | 4943    | 4952  | 4611     | 4622      |
| 0.062<br>(1.55)             |             | 4956<br>4956F | 4979F   | 5962<br>5962P |                 |       |              |          |                | 4957    |       | 4655     | 4624      |
| 0.080<br>(2.0)              |             |               |         |               | 4955            |       |              |          |                |         |       |          |           |
| 0.090<br>(2.3)              |             | 4991          |         |               |                 |       |              |          |                |         |       |          |           |
| 0.120<br>(3.0)              |             |               |         |               | 4959<br>4959F   |       |              |          |                |         |       |          |           |

**NOTE:** For easy product comparison, data in this product information page will be organized by product family.

# 3M™ VHB™ Tapes

## 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 |                |         | Thickness |        |            | Adhesive       |           | Foam               |                      | Density   |         | Release Liner Thickness |                 |  |  |
|----------------|----------------|---------|-----------|--------|------------|----------------|-----------|--------------------|----------------------|-----------|---------|-------------------------|-----------------|--|--|
| Family         | Product Number | Color   | Inches    | (mm)   | Tolerance  | Adhesive Type  | Type      | lb/ft <sup>2</sup> | (kg/m <sup>2</sup> ) | Type      | Inches  | (mm)                    | Color           |  |  |
| 4941           | 4919F          | Black   | 0.025     | (0.64) | ± 15%      | Multi-Purp     | Conform   | 45                 | (720)                | PE Film   | 0.005   | (0.125)                 | 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     | (0.64) | ± 15%      | Multi-Purp     | Conform   | 45                 | (720)                | DK Paper  | 0.003   | (0.08)                  | White (printed) |  |  |
|                | 4936F          | Gray    | 0.025     | (0.64) | ± 15%      | Multi-Purp     | Conform   | 45                 | (720)                | PE Film   | 0.005   | (0.125)                 | 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   | (0.125)                 | Red             |  |  |
|                | 4947F          | Black   | 0.045     | (1.1)  | ± 10%      | Multi-Purp     | Conform   | 45                 | (720)                | PE Film   | 0.005   | (0.125)                 | Red (printed)   |  |  |
|                | 4956           | Gray    | 0.062     | (1.55) | ± 10%      | Multi-Purp     | Conform   | 45                 | (720)                | DK Paper  | 0.003   | (0.08)                  | White (printed) |  |  |
|                | 4956F          | Gray    | 0.062     | (1.55) | ± 10%      | Multi-Purp     | Conform   | 45                 | (720)                | PE Film   | 0.005   | (0.125)                 | Red (printed)   |  |  |
|                | 4979F          | Black   | 0.062     | (1.55) | ± 10%      | Multi-Purp     | Conform   | 45                 | (720)                | PE Film   | 0.005   | (0.125)                 | Red (printed)   |  |  |
| 4991           | Gray           | 0.090   | (2.3)     | ± 10%  | Multi-Purp | Conform        | 45        | (720)              | PE Film              | 0.005     | (0.125) | Red (printed)           |                 |  |  |
| 5952           | 5915           | Black   | 0.016     | (0.4)  | ± 15%      | Modified       | Very Conf | 43                 | (690)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
|                | 5915P          | Black   | 0.016     | (0.4)  | ± 15%      | Modified       | Very Conf | 43                 | (690)                | PCK Paper | 0.004   | (0.10)                  | White (printed) |  |  |
|                | 5925           | Black   | 0.025     | (0.64) | ± 15%      | Modified       | Very Conf | 37                 | (590)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
|                | 5925P          | Black   | 0.025     | (0.64) | ± 15%      | Modified       | Very Conf | 37                 | (590)                | PCK Paper | 0.004   | (0.10)                  | White (printed) |  |  |
|                | 5930           | Black   | 0.032     | (0.8)  | ± 15%      | Modified       | Very Conf | 37                 | (590)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
|                | 5930P          | Black   | 0.032     | (0.8)  | ± 15%      | Modified       | Very Conf | 37                 | (590)                | PCK Paper | 0.004   | (0.10)                  | White (printed) |  |  |
|                | 5952           | Black   | 0.045     | (1.1)  | ± 10%      | Modified       | Very Conf | 37                 | (590)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
|                | 5952P          | Black   | 0.045     | (1.1)  | ± 10%      | Modified       | Very Conf | 37                 | (590)                | PCK Paper | 0.004   | (0.10)                  | White (printed) |  |  |
|                | 5958FR         | Black   | 0.040     | (1.0)  | ± 10%      | Modified       | Very Conf | 50                 | (800)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
|                | 5962           | Black   | 0.062     | (1.55) | ± 10%      | Modified       | Very Conf | 37                 | (590)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
| 5962P          | Black          | 0.062   | (1.55)    | ± 10%  | Modified   | Very Conf      | 37        | (590)              | PCK Paper            | 0.004     | (0.10)  | White (printed)         |                 |  |  |
| 4950           | 4920           | White   | 0.015     | (0.4)  | ± 15%      | Gen Purp       | Firm      | 50                 | (800)                | DK Paper  | 0.003   | (0.08)                  | White (printed) |  |  |
|                | 4929           | Black   | 0.025     | (0.64) | ± 15%      | Gen Purp       | Firm      | 50                 | (800)                | Polyester | 0.002   | (0.05)                  | Clear           |  |  |
|                | 4930           | White   | 0.025     | (0.64) | ± 15%      | Gen Purp       | Firm      | 50                 | (800)                | DK Paper  | 0.003   | (0.08)                  | White (printed) |  |  |
|                | 4930F          | White   | 0.025     | (0.64) | ± 15%      | Gen Purp       | Firm      | 50                 | (800)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
|                | 4949           | Black   | 0.045     | (1.1)  | ± 10%      | Gen Purp       | Firm      | 50                 | (800)                | Polyester | 0.002   | (0.05)                  | Clear           |  |  |
|                | 4950           | White   | 0.045     | (1.1)  | ± 10%      | Gen Purp       | Firm      | 50                 | (800)                | DK Paper  | 0.003   | (0.08)                  | White (printed) |  |  |
|                | 4955           | White   | 0.080     | (2.0)  | ± 10%      | Gen Purp       | Firm      | 45                 | (720)                | Polyester | 0.002   | (0.05)                  | Clear           |  |  |
|                | 4959           | White   | 0.120     | (3.0)  | ± 10%      | Gen Purp       | Firm      | 45                 | (720)                | Polyester | 0.002   | (0.05)                  | Clear           |  |  |
|                | 4959F          | White   | 0.120     | (3.0)  | ± 10%      | Gen Purp       | Firm      | 45                 | (720)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
| 4945           | 4945           | White   | 0.045     | (1.1)  | ± 10%      | Multi-Purp     | Firm      | 50                 | (800)                | DK Paper  | 0.003   | (0.08)                  | White (printed) |  |  |
|                | 4946           | White   | 0.045     | (1.1)  | ± 10%      | Multi-Purp     | Firm      | 50                 | (800)                | PE Film   | 0.005   | (0.125)                 | Clear           |  |  |
| 4910           | 4905           | Clear   | 0.020     | (0.5)  | ± 15%      | Gen Purp       | Solid     | 60                 | (960)                | PE Film   | 0.005   | (0.125)                 | Red (printed)   |  |  |
|                | 4910           | Clear   | 0.040     | (1.0)  | ± 10%      | Gen Purp       | Solid     | 60                 | (960)                | PE Film   | 0.005   | (0.125)                 | Red (printed)   |  |  |
| 4951           | 4951           | White   | 0.045     | (1.1)  | ± 10%      | Low Temp Appl  | Firm      | 50                 | (800)                | Polyester | 0.002   | (0.05)                  | Clear           |  |  |
|                | 4943F          | Gray    | 0.045     | (1.1)  | ± 10%      | Low Temp Appl  | Conform   | 45                 | (720)                | Polyester | 0.002   | (0.05)                  | Clear           |  |  |
|                | 4957F          | Gray    | 0.062     | (1.55) | ± 10%      | Low Temp Appl  | Conform   | 45                 | (720)                | Polyester | 0.002   | (0.05)                  | Clear           |  |  |
| 4952           | 4932           | White   | 0.025     | (0.64) | ± 15%      | LSE            | Firm      | 50                 | (800)                | DK Paper  | 0.003   | (0.08)                  | White (printed) |  |  |
|                | 4952           | White   | 0.045     | (1.1)  | ± 10%      | LSE            | Firm      | 50                 | (800)                | DK Paper  | 0.003   | (0.08)                  | White (printed) |  |  |
| 4611           | 4611           | Dk Gray | 0.045     | (1.1)  | ± 10%      | Gen Purp       | Firm      | 52                 | (840)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
|                | 4646           | Dk Gray | 0.025     | (0.64) | ± 15%      | Gen Purp       | Firm      | 52                 | (840)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
|                | 4655           | Dk Gray | 0.062     | (1.55) | ± 10%      | Gen Purp       | Firm      | 52                 | (840)                | PE Film   | 0.005   | (0.125)                 | Red             |  |  |
| 4622           | 4618           | White   | 0.025     | (0.64) | ± 15%      | Gen/Multi Purp | Conform   | 45                 | (720)                | PE Film   | 0.004   | (0.10)                  | Green           |  |  |
|                | 4622           | White   | 0.045     | (1.1)  | ± 10%      | Gen/Multi Purp | Conform   | 45                 | (720)                | PE Film   | 0.004   | (0.10)                  | Green           |  |  |
|                | 4624           | White   | 0.062     | (1.55) | ± 10%      | Gen/Multi Purp | Conform   | 45                 | (720)                | PE Film   | 0.004   | (0.10)                  | Green           |  |  |

# 3M™ VHB™ Tapes

## 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.

| Family   | 3M™ VHB™ Tapes |          |                  | Dynamic Adhesion Performance |          |                    |        |                       |       |
|----------|----------------|----------|------------------|------------------------------|----------|--------------------|--------|-----------------------|-------|
|          | Product Number | Color    | Thickness Inches | 90° Peel Adhesion            |          | Normal Tensile     |        | Dynamic Overlap Shear |       |
|          |                |          |                  | lb/in                        | N/100 mm | lb/in <sup>2</sup> | kPa    | lb/in <sup>2</sup>    | kPa   |
| 4941     | 4919F          | Black    | 0.025            | 17                           | (300)    | 90                 | (620)  | 80                    | (550) |
|          | 4926           | Gray     | 0.015            | 14                           | (245)    | 95                 | (655)  | 90                    | (620) |
|          | 4936 (F)       | Gray     | 0.025            | 17                           | (300)    | 90                 | (620)  | 80                    | (550) |
|          | 4941 (F)       | Gray     | 0.045            | 22                           | (385)    | 85                 | (585)  | 70                    | (480) |
|          | 4947F          | Black    | 0.045            | 22                           | (385)    | 85                 | (585)  | 70                    | (480) |
|          | 4956 (F)       | Gray     | 0.062            | 22                           | (385)    | 80                 | (550)  | 70                    | (480) |
|          | 4979F          | Black    | 0.062            | 22                           | (385)    | 80                 | (550)  | 70                    | (480) |
|          | 4991           | Gray     | 0.090            | 22                           | (385)    | 70                 | (480)  | 65                    | (450) |
|          | 5952           | 5915 (P) | Black            | 0.016                        | 14       | (245)              | 90     | (620)                 | 90    |
| 5925 (P) |                | Black    | 0.025            | 17                           | (300)    | 90                 | (620)  | 90                    | (620) |
| 5930 (P) |                | Black    | 0.032            | 19                           | (330)    | 90                 | (620)  | 85                    | (585) |
| 5952 (P) |                | Black    | 0.045            | 22                           | (385)    | 90                 | (620)  | 80                    | (550) |
| 5958FR   |                | Black    | 0.040            | 20                           | (350)    | 100                | (690)  | 100                   | (690) |
| 5962 (P) |                | Black    | 0.062            | 22                           | (385)    | 90                 | (620)  | 80                    | (550) |
| 4950     | 4920           | White    | 0.015            | 15                           | (260)    | 160                | (1100) | 100                   | (690) |
|          | 4929           | Black    | 0.025            | 20                           | (350)    | 160                | (1100) | 100                   | (690) |
|          | 4930 (F)       | White    | 0.025            | 20                           | (350)    | 160                | (1100) | 100                   | (690) |
|          | 4949           | Black    | 0.045            | 25                           | (440)    | 140                | (970)  | 80                    | (550) |
|          | 4950           | White    | 0.045            | 25                           | (440)    | 140                | (970)  | 80                    | (550) |
|          | 4955           | White    | 0.080            | 20                           | (350)    | 95                 | (655)  | 70                    | (480) |
|          | 4959 (F)       | White    | 0.120            | 20                           | (350)    | 75                 | (520)  | 55                    | (380) |
| 4945     | 4945           | White    | 0.045            | 25                           | (440)    | 140                | (970)  | 80                    | (550) |
|          | 4946           | White    | 0.045            | 25                           | (440)    | 140                | (970)  | 80                    | (550) |
| 4910     | 4905           | Clear    | 0.020            | 12                           | (210)    | 100                | (690)  | 70                    | (480) |
|          | 4910           | Clear    | 0.040            | 15                           | (260)    | 100                | (690)  | 70                    | (480) |
| 4951     | 4951           | White    | 0.045            | 18                           | (315)    | 110                | (760)  | 80                    | (550) |
|          | 4943F          | Gray     | 0.045            | 20                           | (350)    | 85                 | (585)  | 70                    | (480) |
|          | 4957F          | Gray     | 0.062            | 20                           | (350)    | 75                 | (515)  | 70                    | (480) |
| 4952     | 4932           | White    | 0.025            | 20                           | (350)    | 100                | (690)  | 100                   | (690) |
|          | 4952           | White    | 0.045            | 25                           | (440)    | 80                 | (550)  | 80                    | (550) |
| 4611     | 4611           | Dk Gray  | 0.045            | 18                           | (315)    | 90                 | (590)  | 65                    | (445) |
|          | 4646           | Dk Gray  | 0.025            | 15                           | (250)    | 100                | (690)  | 80                    | (550) |
|          | 4655           | Dk Gray  | 0.062            | 18                           | (315)    | 80                 | (550)  | 60                    | (415) |
| 4622     | 4618           | White    | 0.025            | 17                           | (300)    | 85                 | (580)  | 80                    | (550) |
|          | 4622           | White    | 0.045            | 20                           | (350)    | 70                 | (480)  | 65                    | (445) |
|          | 4624           | White    | 0.062            | 20                           | (350)    | 55                 | (380)  | 60                    | (410) |



**90° Peel Adhesion** - Based on ASTM D3330 - To stainless steel, room temperature, jaw speed 12 in/min (305 mm/min). Average force to remove is measured. 72 hour dwell.



**Normal Tensile (T-Block Tensile)** - ASTM D-897 - To aluminum, room temperature, 1 in<sup>2</sup> (6.45 cm<sup>2</sup>), jaw speed 2 in/min (50 mm/min.) Peak force to separate is measured. 72 hour dwell.



**Dynamic Overlap Shear** - ASTM D-1002 - To stainless steel, room temperature, 1 in<sup>2</sup> (6.45 cm<sup>2</sup>), jaw speed 0.5 in/min (12.7 mm/min.) Peak force to separate is measured. 72 hour dwell.

# 3M™ VHB™ Tapes

## 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.**

| Family | 3M™ VHB™ Tapes |         |                  | Static Shear  |              |              |               |               | Temperature Tolerance       |       |                         |       |
|--------|----------------|---------|------------------|---|--------------|--------------|---------------|---------------|-----------------------------|-------|-------------------------|-------|
|        | Product Number | Color   | Thickness Inches | Weight (grams) that 1/2 square inch will hold 10,000 minutes (7 days) |              |              |               |               | Short Term (Minutes, Hours) |       | Long Term (Days, Weeks) |       |
|        |                |         |                  | 72°F (22°C)   | 150°F (66°C) | 200°F (93°C) | 250°F (121°C) | 350°F (177°C) | °F                          | °C    | °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)  |
| 5952   | 5915 (P)       | Black   | 0.016            | 1000  | 500          | 500          | 250           |               | 300                         | (149) | 250                     | (121) |
|        | 5925 (P)       | Black   | 0.025            | 1000  | 500          | 500          | 250           |               | 300                         | (149) | 250                     | (121) |
|        | 5930 (P)       | Black   | 0.032            | 1000  | 500          | 500          | 250           |               | 300                         | (149) | 250                     | (121) |
|        | 5952 (P)       | Black   | 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) |
| 4950   | 4920           | White   | 0.015            | 1500  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
|        | 4929           | Black   | 0.025            | 1500  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
|        | 4930 (F)       | White   | 0.025            | 1500  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
|        | 4949           | Black   | 0.045            | 1500  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
|        | 4950           | White   | 0.045            | 1500  | 1000         | 500          |               |               | 300                         | (149) | 200                     | (93)  |
|        | 4955           | White   | 0.080            | 1500  | 1000         | 750          | 750           | 750           | 400                         | (204) | 300                     | (149) |
|        | 4959 (F)       | White   | 0.120            | 1500  | 1000         | 750          | 750           | 750           | 400                         | (204) | 300                     | (149) |
| 4945   | 4945           | White   | 0.045            | 1500  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
|        | 4946           | White   | 0.045            | 1500  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
| 4910   | 4905           | Clear   | 0.020            | 1000  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
|        | 4910           | Clear   | 0.040            | 1000  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
| 4951   | 4951           | White   | 0.045            | 1250  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
|        | 4943F          | Gray    | 0.045            | 1000  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
|        | 4957F          | Gray    | 0.062            | 1000  | 500          | 500          |               |               | 300                         | (149) | 200                     | (93)  |
| 4952   | 4932           | White   | 0.025            | 1500  | 500          |              |               |               | 200                         | (93)  | 160                     | (71)  |
|        | 4952           | White   | 0.045            | 1500  | 500          |              |               |               | 200                         | (93)  | 160                     | (71)  |
| 4611   | 4611           | Dk Gray | 0.045            | 1500  | 750          | 750          | 750           | 750           | 450                         | (232) | 300                     | (149) |
|        | 4646           | Dk Gray | 0.025            | 1500  | 750          | 750          | 750           | 750           | 450                         | (232) | 300                     | (149) |
|        | 4655           | Dk Gray | 0.062            | 1500  | 750          | 750          | 750           | 750           | 450                         | (232) | 300                     | (149) |
| 4622   | 4618           | White   | 0.025            | 1000  | 250          | 250          |               |               | 250                         | (121) | 200                     | (93)  |
|        | 4622           | White   | 0.045            | 1000  | 250          | 250          |               |               | 250                         | (121) | 200                     | (93)  |
|        | 4624           | White   | 0.062            | 1000  | 250          | 250          |               |               | 250                         | (121) | 200                     | (93)  |



**Static Shear** - ASTM D3654 - To stainless steel, tested at various temperatures and gram loadings. 0.5 in<sup>2</sup> (3.22 cm<sup>2</sup>). Will hold listed weight for 10,000 minutes (approximately 7 days). Conversion: 1500 g/0.5 in<sup>2</sup> equals 6.6 lb/in<sup>2</sup>; 500 g/0.5 in<sup>2</sup> = 2.2 lb/in<sup>2</sup>.

**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<sup>2</sup> in static shear for 10,000 minutes. (Represents continuous exposure for days or weeks).

# 3M™ VHB™ Tapes

## Available Sizes

| Tape Thickness<br>inches (mm) | Standard Length<br>yards (meters) | Minimum Width<br>inches (mm) | Maximum Width<br>inches (mm) | Maximum Roll Length                          |                |   |                |  |                |
|-------------------------------|-----------------------------------|------------------------------|------------------------------|--|----------------|---|----------------|--|----------------|
|                               |                                   |                              |                              | Width 1/4" up to 3/8"<br>(6.4mm up to 9.5mm) |                | Width >3/8" up to 1/2"<br>(>9.5mm up to 12.7mm) |                | Width 1/2" and wider<br>(12.7mm and wider) |                |
|                               |                                   |                              |                              | yards (meters)                               | yards (meters) | yards (meters)                                  | yards (meters) | yards (meters)                             | yards (meters) |
| 0.015/0.016 (0.4)             | 72 (65.8)                         | 0.25 (6.4)                   | 48* (1220)                   | 144 (131.6)                                  | 175 (160)      | 360 (330)                                       |                |  |                |
| 0.020 (0.5)                   | 72 (65.8)                         | 0.25 (6.4)                   | 48* (1220)                   | 72 (65.8)                                    | 108 (98.8)     | 175 (160)                                       |                |  |                |
| 0.025 (0.64)                  | 72 (65.8)                         | 0.25 (6.4)                   | 48 (1220)                    | 72 (65.8)                                    | 108 (98.8)     | 175 (160)                                       |                |  |                |
| 0.032 (0.8)                   | 72 (65.8)                         | 0.25 (6.4)                   | 48 (1220)                    | 72 (65.8)                                    | 108 (98.8)     | 175 (160)                                       |                |  |                |
| 0.040 (1.0)                   | 36 (32.9)                         | 0.25 (6.4)                   | 48 (1220)                    | 72 (65.8)                                    | 108 (98.8)     | 144 (131.6)                                     |                |  |                |
| 0.045 (1.1)                   | 36 (32.9)                         | 0.25 (6.4)                   | 48 (1220)                    | 72 (65.8)                                    | 108 (98.8)     | 144 (131.6)                                     |                |  |                |
| 0.062 (1.55)                  | 36 (32.9)                         | 0.25 (6.4)                   | 46 (1170)                    | 72 (65.8)                                    | 72 (65.8)      | 108 (98.8)                                      |                |  |                |
| 0.080 (2.0)                   | 36 (32.9)                         | 0.25 (6.4)                   | 46 (1170)                    | 36 (32.9)                                    | 36 (32.9)      | 72 (65.8)                                       |                |  |                |
| 0.090 (2.3)                   | 36 (32.9)                         | 0.25 (6.4)                   | 46 (1170)                    | 36 (32.9)                                    | 36 (32.9)      | 72 (65.8)                                       |                |  |                |
| 0.120 (4959) (3.0)            | 36 (32.9)                         | 0.5 (12.7)                   | 46 (1170)                    | N/A N/A                                      | N/A N/A        | 36 (32.9)                                       |                |  |                |
| 0.120 (4959F) (3.0)           | 36 (32.9)                         | 0.25 (6.4)                   | 46 (1170)                    | 36 (32.9)                                    | 36 (32.9)      | 36 (32.9)                                       |                |  |                |

\*Exception – 5915 (P) max. width 46 inches (1170 mm); 5925 (P) max. width 47 inches (1195 mm).

## Slitting Tolerance

Standard slitting tolerance  $\pm 1/32$  inch ( $\pm 0.031$  inch,  $\pm 0.8$  mm).

Precision slitting with slitting tolerance of  $\pm 1/64$  inch ( $\pm 0.016$  in.,  $\pm 0.44$  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](http://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.

# 3M™ VHB™ Tapes

## 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.**

### Outgassing:

| 3M™ VHB™ Tapes | % TML | %VCM | %WVR |
|----------------|-------|------|------|
| 4930           | 0.77  | 0.01 | 0.21 |
| 4932           | 2.41  | 0.66 | 0.23 |
| 4945           | 1.24  | 0.01 | 0.19 |

TML - Total Mass Loss

VCM - Volatile Condensable Materials

WVR - Water Vapor Regained

NASA Reference Publication, "Outgassing Data for Selecting Spacecraft Materials", (11/18/2004)  
Available online at <http://outgassing.nasa.gov>

### Dielectric Constant (ASTM D150)

| 3M™ VHB™ Tapes | Dielectric Constant | Dissipation Factor |
|----------------|---------------------|--------------------|
| 4941 at 1 kHz  | 2.29                | 0.0245             |
| at 1 MHz       | 1.99                | 0.0374             |
| 5952 at 1 kHz  | 2.14                | 0.0065             |
| at 1 MHz       | 1.95                | 0.0506             |
| 4950 at 1 kHz  | 2.28                | 0.0227             |
| at 1 MHz       | 1.99                | 0.0370             |
| 4910 at 1 kHz  | 3.21                | 0.0214             |
| at 1 MHz       | 2.68                | 0.0595             |
| 4611 at 1 kHz  | 2.80                | 0.0130             |
| at 1 MHz       | 2.43                | 0.0564             |

### Resistivity (ASTM D257)

| 3M™ VHB™ Tapes | Volume Resistivity (in ohm-cm) | Surface Resistance (in ohms/square) |
|----------------|--------------------------------|-------------------------------------|
| 4941           | $2.1 \times 10^{14}$           | $2.7 \times 10^{14}$                |
| 5952           | $2.5 \times 10^{14}$           | $>10^{16}$                          |
| 4950           | $1.5 \times 10^{15}$           | $>10^{16}$                          |
| 4920           | $1.7 \times 10^{15}$           | $>10^{16}$                          |
| 4910           | $3.1 \times 10^{15}$           | $>10^{16}$                          |
| 4611           | $1.4 \times 10^{15}$           | $>10^{16}$                          |

### Water Vapor Transmission Rate (WVTR) (ASTM F1249) at 38°C/100% RH

| 3M™ VHB™ Tapes | WVTR                        |
|----------------|-----------------------------|
| 4950           | 14.0 g/(m <sup>2</sup> day) |
| 4941           | 25.6 g/(m <sup>2</sup> day) |
| 5952           | 37.1 g/(m <sup>2</sup> day) |

### Typical 3M™ VHB™ Tape Properties for Modeling

#### Thermal Coefficient of Expansion

$1 \times 10^{-4}$  in/in/°F

$1.8 \times 10^{-4}$  mm/mm/°C

#### Shear Modulus (@25°C, 1 Hz)

4950 Family:  $6 \times 10^9$  Pa

4941 Family:  $3 \times 10^9$  Pa

(Shear Modulus is both temperature and frequency dependent).

Youngs Modulus: For VHB tapes the Youngs Modulus will be about 3 times the Shear Modulus.

Poisson's Ratio  
0.49

### 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)

### Dielectric Breakdown Strength (ASTM D149)

| 3M™ VHB™ Tapes | (in volts/mil) |
|----------------|----------------|
| 4941           | 360            |
| 4926           | 330            |
| 5952           | 455            |
| 5925           | 520            |
| 4950           | 460            |
| 4920           | 640            |
| 4910           | 630            |
| 4611           | 330            |

### Thermal Conductivity - K-value

| 3M™ VHB™ Tapes | BTU in/hr ft <sup>2</sup> °F | (w/mK) |
|----------------|------------------------------|--------|
| 4941           | 0.53                         | (0.08) |
| 5952           | 0.37                         | (0.05) |
| 4950/4945      | 0.63                         | (0.09) |
| 4910           | 1.09                         | (0.16) |
| 4611           | 0.77                         | (0.11) |

R-Value =  $\frac{\text{thickness}}{\text{K-value}}$   
(When units of K-value are BTU-in/hr ft<sup>2</sup> °F and thickness is given in inches.)

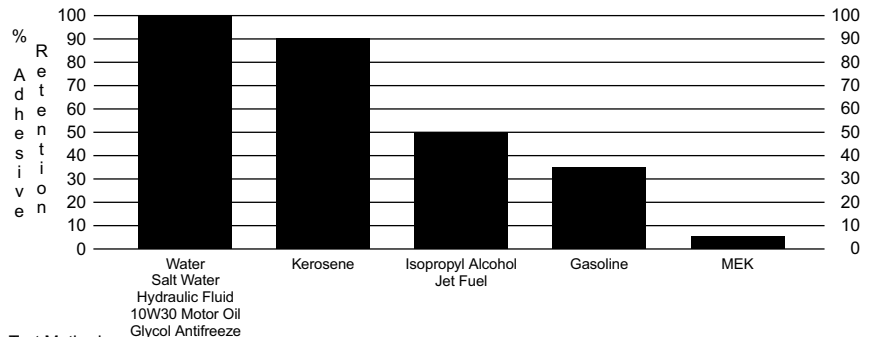
## 3M™ VHB™ Tapes UL746C Listings - File MH 17478

Category QQW2 Component - Polymeric Adhesive Systems, Electrical Equipment

| 3M™ VHB™ Tapes/<br>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    |
| 4920, 4930, 4950   | Aluminum, galvanized steel, enameled steel, stainless steel, ceramic, glass/epoxy  | -35°C              | 110°C   |
|  | PBT, Acrylic   | -35°C              | 90°C    |
|  | ABS, Polycarbonate, Rigid PVC  | -35°C              | 75°C    |
| 4945, 4946   | Phenolic, aluminum, galvanized steel, alkyd enamel   | -35°C              | 110°C   |
|  | ABS, polycarbonate, polyimide, stainless steel, acrylic/polyurethane paint, polyester paint  | -35°C              | 90°C    |
|  | unplasticized PVC  | -35°C              | 75°C    |
| 5915, 5915P, 5925, 5925P, 5930, 5930P, 5952, 5952P, 5962, 5962P  | Polycarbonate, Primer 94 coated polycarbonate, aluminum, acrylic/polyurethane paint, galvanized steel, polyester paint, epoxy/polyester paint, epoxy paint, glass (with or without silane coating), stainless steel, enameled steel, glass epoxy, polybutylene terephthalate, Nylon®, Noryl® (PPE) polyphenylene ether | -35°C              | 90°C    |
|  | Rigid PVC, ABS   | -35°C              | 75°C    |
| 5915, 5925, 5930, 5952   | Acrylic  | -35°C              | 90°C    |
| 5962   | Acrylic  | -35°C              | 80°C    |
| 5952   | Cellulose Acetate Butyrate   | -35°C              | 90°C    |
| 4991   | Polycarbonate, aluminum, acrylic/polyurethane paint, polyester paint   | -35°C              | 90°C    |
| 4611, 4646, 4655   | Stainless steel, aluminum, galvanized steel, glass, glass/epoxy, phenolic  | -35°C              | 110°C   |
|  | Nylon, polycarbonate   | -35°C              | 90°C    |
|  | ABS, rigid PVC   | -35°C              | 75°C    |
| 4905, 4910   | Polycarbonate, aluminum, acrylic/polyurethane paint  | -35°C              | 90°C    |

A current list can be found at [www.ul.com](http://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 immersion 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.

# 3M™ VHB™ Tapes

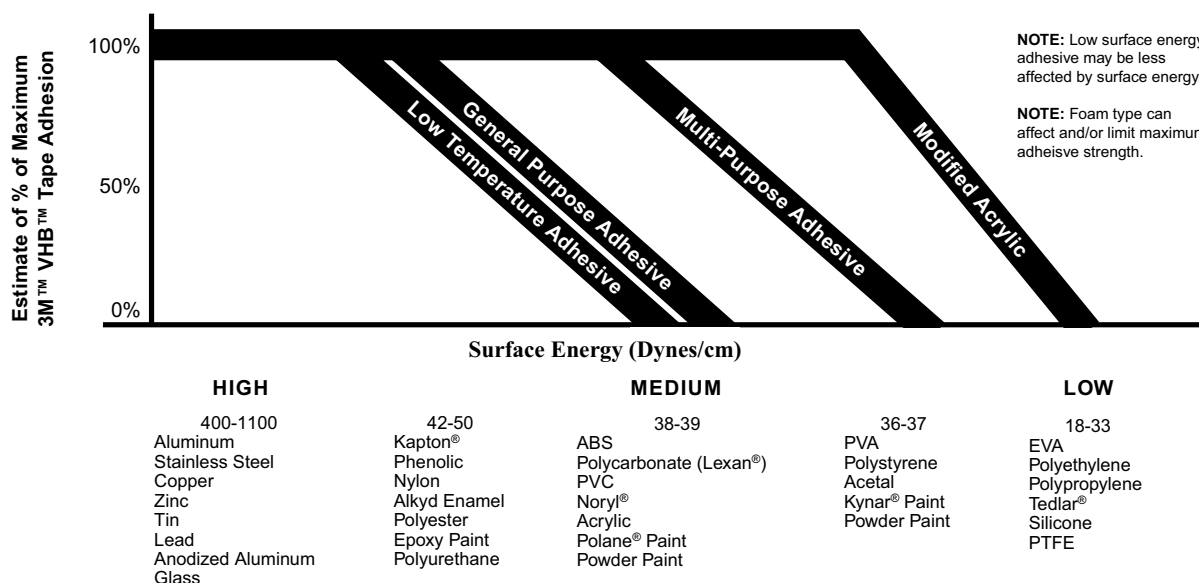
## Design and Tape Selection Considerations

- **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**



NOTE: Low surface energy adhesive may be less affected by surface energy.  
NOTE: Foam type can affect and/or limit maximum adhesive strength.

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. Light abrasion of surface will significantly increase adhesion levels on many materials, except when using tapes 4952/4932.

- **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 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.



# 3M™ VHB™ Tapes

## 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 fibred 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.

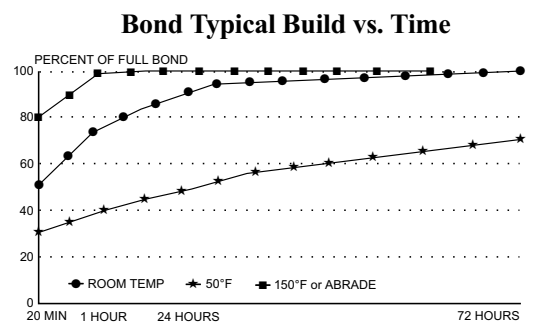
- **Temperature:** Ideal application temperature range is 70°F to 100°F (21°C to 38°C). Pressure sensitive adhesives use viscous flow to achieve substrate contact area. Minimum suggested application temperatures:

- 50°F (10°C): 3M™ VHB™ Tapes 4950, 5952, 4910, 4952, 4611, 4622 families.
- 60°F (15°C): 3M™ VHB™ Tapes 4941, 4945 families.
- 32°F (0°C): 3M™ VHB™ Tape 4951 families.

**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.



# 3M™ VHB™ Tapes

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## Special Cases:

Rough Surfaces with 3M™ VHB™ Tapes 4932/4952 – 3M™ VHB™ Tapes 4932/4952 were designed to adhere to many low surface energy substrates. Rough surfaces created by light abrasion or textured molds are typically detrimental to bond strength with this tape family.

Plasticized Vinyl – Plasticizers compounded in soft vinyl can migrate into adhesives and significantly change their performance characteristics. 3M™ VHB™ Tapes 4941 and 4945 families have 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).

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## Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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## Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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## Limited Warranty

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