

April, 2013

3M™ VHB™ Adhesive Transfer Tape F9460PC

Product Description

3M™ VHB™ Adhesive Transfer Tape F9460PC utilizes the 3M™ High Performance Acrylic Adhesive 100MP, which has excellent long term holding power with much higher adhesion strength than typical pressure sensitive adhesive systems. This 3M™ VHB™ Adhesive Transfer Tape is transparent and is ideal for use in many interior and exterior industrial applications to replace rivets, spot welds, liquid adhesives, and other permanent fasteners.



Technical Information Note

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

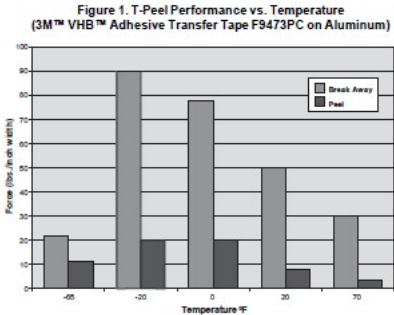
Typical Physical Properties

Property	Values		Notes
Adhesive Thickness	0.06 mm	2.3 mil	The thickness listed is based on a calculation from manufacturing controlled adhesive coat weights using a density of 1.012 g/cc. While past data pages have listed nominal thicknesses, the coat weight (and theoretical caliper) has not changed.
Density	1.012 g/cm³	0.04 lb/in³	
Liner	58# Polycoated Kraft		
Liner Thickness	0.106 mm	4.2 mil	

UL Listing

3M™ Adhesive 100MP has UL 746C listings with different temperature ratings on many commonly used substrate materials as indicated in the table below. Qualification for this listing requires high strength retention after extended exposure to high temperatures, humidity, cold, and cyclic conditions.

Substrates Temperature Rating
Stainless Steel, Glass/Epoxy, Enameled Steel, Ceramic, Phenolic: 110°C
ABS, Polycarbonate, Aluminum, Galvanized Steel: 90°C
Unplasticized PVC: 75°C



Our testing has shown that 3M™ Adhesive 100MP yielded 92% retention of peel adhesion after the roll was aged for more than 5 years at an elevated temperature of 150°F (65°C). The initial tack and liner release properties were still excellent. This testing result suggests that the tape is relatively unaffected by long-term exposure to elevated temperatures. Bonds made with 3M™ Adhesive 100MP can tolerate periodic short-term exposures to temperatures up to 500°F (260°C). 3M™ Adhesive 100MP is thermoplastic in nature, becoming softer as temperature increases and firmer as temperature decreases. As the adhesive becomes firmer, the performance generally increases. This performance increase is demonstrated graphically in Figure 1 for 3M™ VHB™ Adhesive Transfer Tape F9473PC. It shows the breakaway and peel forces as a function of temperature. The exception of the performance increase is at very low temperatures when high impact stresses along with high frequencies are encountered. At low temperatures, the tape becomes very firm and glassy; the ability to absorb impact energy is reduced.

Dynamic Mechanical Properties

For engineers who have to use adhesive properties for modeling and analysis purpose, we suggest a Young’s modulus of 4.5 × 102 kPA (measured at 23°C & 1 Hz) and a Poisson’s ratio of 0.499. For detailed adhesive modulus and damping properties, please refer to the nomograph for 3M™ VHB™ Adhesive Transfer Tapes, which is available upon request through our technical service group. The nomograph presents adhesive modulus and damping properties as functions of temperature and frequency.

Typical Performance Characteristics

Additional Test notes

3M™ VHB™ Adhesive Transfer Tapes F9460PC, F9469PC, and F9473PC are made from the same adhesive system and are thermoplastic in nature, becoming softer as temperature increases and firmer as temperature decreases. As the adhesive becomes firmer, the adhesion performance generally increases. At low temperatures (lower than -40°F [-40°C]), the 3M™ VHB™ Adhesive Transfer Tape becomes very firm and glassy; the ability to absorb impact energy is reduced. In contrast, adhesion strength reduces with increasing temperatures. Typical adhesive strength properties at room temperatures are shown below.

Solvent Resistance

No apparent degradation when exposed to splash testing of many common solvents and fluids including gasoline, JP-4 fuel, mineral spirits, motor oil, ammonia cleaner, acetone and methyl ethyl ketone.
(3 splash testing cycles: 20 seconds submersion, & 20 seconds air dry.)

Property	Values		Method	Dwell/Cure Time	Substrate	Backing	Test Condition
Peel Adhesion	12.3 N/cm	112 oz/in	ASTM D3330, Method E - Modified	72 hr	Stainless Steel	2 mil Aluminum Foil	
Normal Tensile	690 kPa	100 lb/in²	ASTM D897		Aluminum		
Dynamic Overlap Shear	550 kPa	80 lb/in²	ASTM D1002		Stainless Steel		
Short Term Temperature Tolerance	260 °C	500 °F					4-hour conditioning at the indicated temperature with 100 g static load.

Table continued on next page

Typical Performance Characteristics (continued)

Property	Values		Method	Dwell/Cure Time	Substrate	Backing	Test Condition
Long Term Temperature Tolerance	149 °C	300 °F					Maximum temperature where tape supports 250 g in static shear for 10,000 minutes.
Note	Static shear measured at various temperatures and gram loadings on stainless steel. 1/2 sq. yd (3.22 cm²) overlap. Will hold listed weight for 10,000 minutes.						
UV Resistance	Excellent UV resistance through outdoor weathering tests and weather-O-meter tests.						

Static Shear	Test Condition
1000 g	Room Temperature
1000 g	66°C (150°F)
1000 g	93°C (200°F)
1000 g	121°C (250°F)
500 g	149°C (300°F)

Table continued on next page

Typical Performance Characteristics (continued)

Static Shear	Test Condition
500 g	177°C (350°F)

Property: Static Shear
Method: ASTM D3654

Available Sizes

Property	Values	
Note	Subject to Minimum Order Requirements	
Standard Length	55 m	60 yd
Normal Slitting Tolerance	0.8 mm	±1/32 in

Maximum Length		Width
55 m	60 yd	1/4 in to 3/8 in widths
220 m	240 yd	3/8 in to 1 in widths
330 m	360 yd	1 in to 3 in
330 m	360 yd	3 in and wider

Property: Maximum Length

Electrical and Thermal Properties

Property	Values		Method
Insulation Resistance	> 1 × 10^6 MΩ/in²		ASTM D1000
Thermal Conductivity	0.16 W/m/K	1.1 (btu-in)/(h-ft²-°F)	ASTM C177
Coefficient of Thermal Expansion	770 × 10^-6 m/m/°C		

Dielectric Strength	Method	Test Condition
1200 V	ASTM D149	Room Temperature
1000 V	ASTM D149	125°C
1000 V	ASTM D149	175°C
4.08	ASTM D150	1kHz, 86°F(30°C)

Property: Dielectric Strength

Weight Loss and Outgassing Performance

Property	Values	Method
Total Mass Loss	0.85 %	ASTM E595-77/84/90
Volatile Condensible Materials	0 %	ASTM E595-77/84/90
Note	The testing was done per ASTM E595-77/84/90 as indicated in the NASA Reference Publication 1124, Revision 4, “Outgassing Data for Selecting Spacecraft Materials”, June 1997. The results are reported as percentage of total mass loss (TML) and percentage of Volatile Condensible Materials (VCM), respectively, as shown below.	

Handling/Application Information

Application Techniques

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure helps develop better adhesive contact and improve bond strength.

To obtain optimum adhesion, the bonding surfaces must be clean, dry, and well unified. Some typical surface cleaning solvents are isopropyl alcohol/water mixture or heptane.*

Ideal tape application temperature range is 70°F to 100°F (21°C to 38°C). Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

*Note: Be sure to follow the manufacturer’s precautions and directions for use when using solvents.

Storage and Shelf Life

Humidity controlled storage: 60° to 80°F (16° to 27°C) and 40-60% R.H.

If stored properly, product retains its performance and properties for 24 months from date of manufacture. If the products have been exposed to severe weather conditions, we suggest to precondition the products at the above storage conditions for at least 24 hours before using them.

Industry Specifications

UL 746C

Information

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References

Safety Data Sheet (SDS)

https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=F9460PC

Family Group

	F9460PC	F9469PC	F9473PC
Adhesive Thickness (mm)	0.06	0.13	0.26
Liner	58# Polycoated Kraft	58# Polycoated Kraft	58# Polycoated Kraft
Liner Thickness (mm)	0.106	0.106	0.1

ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

Recognition/Certification

TSCA: These products are defined as articles under the Toxic Substances Control Act and therefore, are exempt from inventory listing requirements. MSDS: These products are not subject to the MSDS requirements of the Occupational Safety and Health Administration's Hazard Communication Standard, 29 C.F.R. 1910.1200(b)(6)(v). When used under reasonable conditions or in accordance with the 3M directions for use, the products should not present a health and safety hazard. However, use or processing of the products in a manner not in accordance with the directions for use may affect their performance and present potential health and safety hazards. Note: One of 3M's core values is to respect our social and physical environment. 3M is committed to comply with ever-changing, global, regulatory and consumer environmental, health, and safety (EHS) requirements. As a service to our customers, 3M is providing information on the regulatory status of many 3M products. Further regulation information including that for OSHA, USCPIS, FDA, California Proposition 65, REACH and RoHS, can be found at 3M.com/regs.



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