



# 3M™ Acrylic Foam and Acrylic Plus Tapes

## Technical Update: Branded Liners

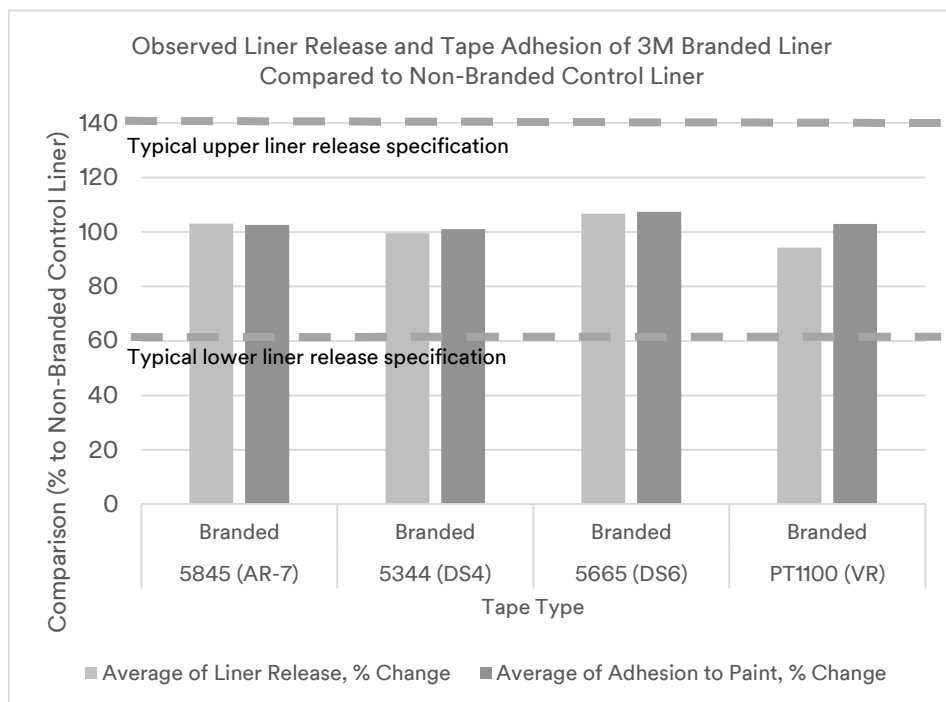


In an effort to help our customers confirm that they are using 3M™ Automotive Attachment Tapes, many of our products now feature 3M branding on the liner. Several competitive products on the market today also take advantage of a red liner, and on occasion, our Technical Service Teams have identified applications where the customer thought they were using 3M products, but were actually being supplied with a non-3M product.

### Product Performance

The liner enhancement does not affect the adhesive performance or liner removal from the tape, and does not impact the finished product or PPAP characteristics; current PPAP's remain valid.

Performance tests are run using standard test procedures in 3M laboratories. The values presented are typical and are not to be used for specification purposes. Values depend on test conditions and substrates.



## Impacted Products

Please consult the chart below for a complete list of 3M Automotive Tapes and Reclosable Fasteners impacted by this liner change.

3M™ Acrylic Foam Tapes			
4220	5345	5665	EC3516
4220FS	5356	5666	GT6008 (GT6008F, GT6008FS, GT6008L, GT6008TL)
4225	5363F	5745L	GT6012 (GT6012F, GT6012FS, GT6012L)
4257	5366F	5845	GTE6112
5314	5367F	5933	Series PX5000 (PX5005, PX5008, PX5011, PX5015)
5314F	5392FLR	EC3504	
5314FS	5390	EC3508	
5344	5567	EC3512	

3M™ Acrylic Plus Tapes
Series EX4000 (EX4008, EX4008T, EX4011, EX4011T, EX4015, EX4015T)
Series PT1000 (PT1100, PT1100T, PT1500, PT1500T)
Series EX4500 (EX4508, EX4508T, EX4511, EX4511T, EX4515, EX4515T)
ST1200
WT4112

3M™ Dual Lock™ Reclosable Fasteners, Roll Goods with Pressure Sensitive Adhesive			
Part Numbers by Stem Density			Dual Lock / 3M Tape
170	250	400	
	SJ3787	SJ3785	DL XXX / 4225
	SJ3758	SJ3271	DL XXX / 5356
		SJ3788	DL XXX / 5745
			DL XXX / GT6008
			DL XXX / GT6012



# Automotive High-Bond Attachment Tape

Technical Data Sheet

January 2010

## General Description

3M™ Automotive High-Bond Attachment Tape is a black, double-coated acrylic foam tape designed for the attachment of automotive exterior trim parts such as body side moldings and claddings. 3M High-Bond Attachment Tape offers an advanced adhesive system that adheres well to traditional, low surface energy, and scratch- and mar-resistant automotive paint systems.

3M tape offers the following key features:

- Excellent adhesion to traditional, low surface energy, and scratch- and mar-resistant automotive paint systems.
- Unique foam core that provides stress relaxation when high application loads are encountered, while maintaining tight bond-line aesthetics under normal conditions.
- Excellent resistance to impact in cold weather.
- Black color provides good bond-line appearance.

Some typical applications for 3M Automotive High-Bond Attachment Tape include body side moldings, claddings, roof ditch moldings and wheel flares.

## Product Construction

Protective Liner  
JL-2 Acrylic Adhesive  
Black Acrylic Polymer Foam  
VR-1 Acrylic Adhesive



## Shelf Life

One year from date of receipt by customer when stored at 4° C - 30° C (40° F - 100° F) and 0 – 95% relative humidity. Optimum storage conditions are 22° C (72° F) and 50% relative humidity.

## Physical Properties

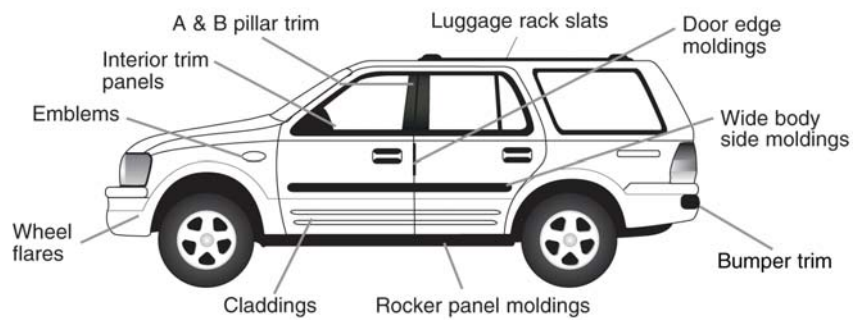
	Part Numbers: 06387, 06388, 06389, 06390	Part Numbers: 06391, 06392
<b>Thickness</b>	1.14 mm (0.045 in.)	1.52 mm (0.060 in.)
<b>Range</b>	+/- 0.13 mm (0.005 in.)	+/- 0.13 mm (0.005 in.)
<b>Density</b>	545 kg/m <sup>3</sup> (34 lb/ft <sup>3</sup> )	529 kg/m <sup>3</sup> (33 lb/ft <sup>3</sup> )
<b>Range</b>	+/- 56 kg/m <sup>3</sup> (3.5 lb/ft <sup>3</sup> )	+/- 56 kg/m <sup>3</sup> (3.5 lb/ft <sup>3</sup> )

## Technical Data Sheet

### 3M™ Automotive High-Bond Attachment Tape

Page 2

#### Typical Applications



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#### Contact Information

The information provided in this technical document is intended as a guide for this product. For more information, and help selecting a 3M product for an application, please contact a 3M technical service representative.

## Details

- Features two adhesives – one on each side of the tape for effective bonding
- Acrylic adhesive is formulated for high adhesive build rate on automotive substrates
- Non-liner-side adhesive delivers excellent adhesion to metal and plastic parts
- Liner-side adhesive is designed for traditional, LSE and mar-resistant automotive paint systems
- Conformable closed cell acrylic foam core delivers excellent stress relaxation under load
- Adhesion promoter recommended for tape-to-part adhesion on plastic parts
- Black color provides good bond-line appearance

3M™ Acrylic Plus High-Bond Tape features two adhesives, one on each side of an acrylic foam core, designed for robust performance to a range of automotive surfaces. Foam core provides stress relaxation when exposed to high application loads, while maintaining tight bond-line aesthetics under normal conditions. A removable liner is silicone-coated on both sides for easy release and application.

### Designed for Adherence to Trim Parts and Scratch-Optimized Paint Systems

Developed specifically for attaching exterior trim and other parts to automotive surfaces, our [3M™ Acrylic Plus High-Bond Tape](#) features two different adhesives applied to an acrylic foam core. The liner-side adhesive delivers very high initial and final adhesion ideal for scratch- and mar-resistant paint systems. The non-liner-side adhesive is excellent for bonding to automotive trim and other components. Both adhesives are formulated for high initial tack, adhesive build and final adhesion to automotive plastics and paints. The 1.14 mm viscoelastic foam core is engineered for stress relaxation when exposed to high application loads, and maintains good bond lines under normal loads. This tape is also available with a core thickness of 1.52 mm, which is suitable for complex contours and geometries. [The red, 3M branded liner](#) is silicone-coated on both sides to provide easy one-piece release and efficient tape application.

### Recommended Applications

- Wide body side moldings
- Bug deflectors
- Door edge moldings
- Large claddings
- Rocker panel moldings
- Spoilers
- Roof ditch moldings
- Tailgate appliques

### Better Science for Better Adhesion from 3M

Since 1925 when one of our lab assistants invented masking tape, 3M has been applying science to life — developing adhesive products and technologies that help entire industries and individual businesses worldwide. The work that began with a single 3M engineer now spans decades and generations. And all of it goes into each of our products developed for automotive OEM, like 3M™ Acrylic Plus High-Bond Tape.