



3M™ Acrylic Foam and Acrylic Plus Tapes

Technical Update: Branded Liners

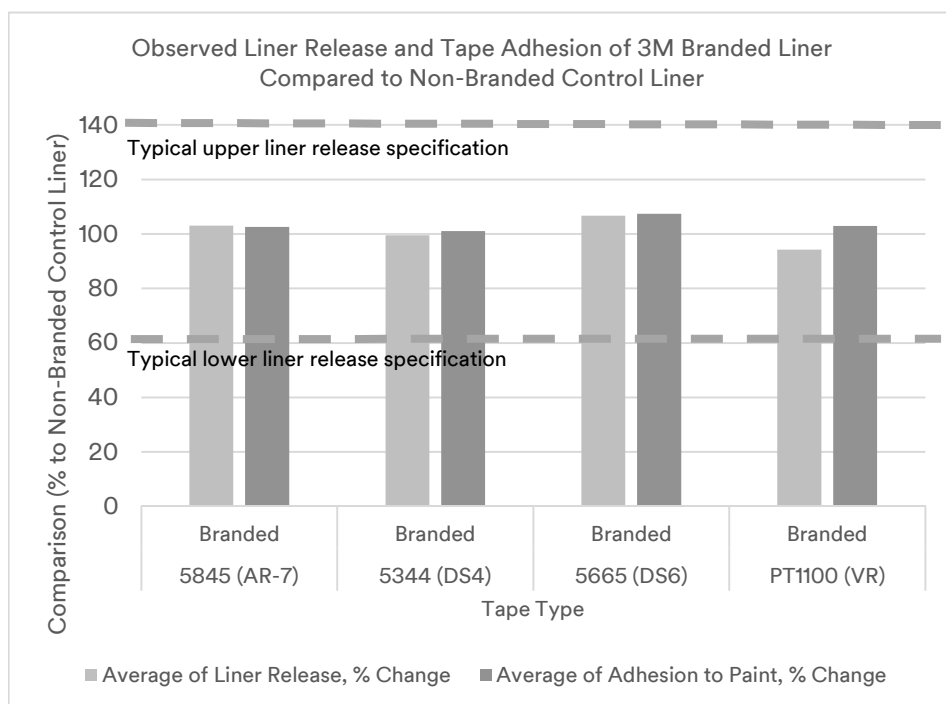


In an effort to help our customers confirm that they are using 3M™ Automotive Attachment Tapes, many of our products now feature 3M branding on the liner. Several competitive products on the market today also take advantage of a red liner, and on occasion, our Technical Service Teams have identified 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 Acrylic *Plus* Attachment Tape

Part Number 06397 (Black)

Technical Data Sheet

September 2004

Supersedes Technical Data Sheet dated December 2003

General Description

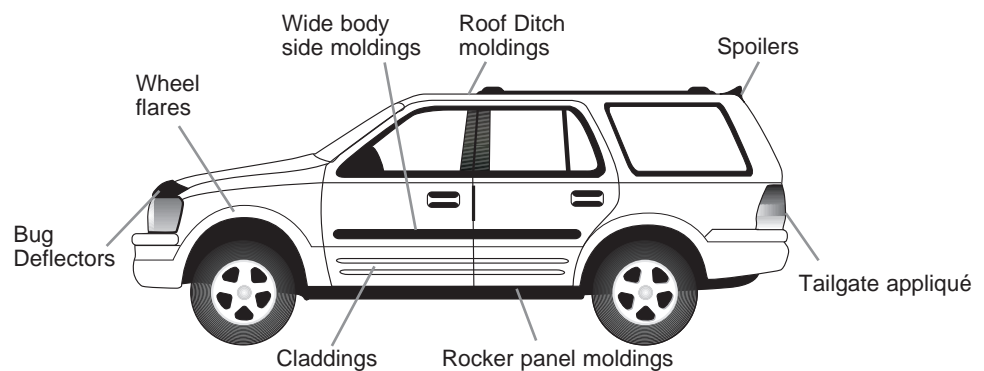
3M™ Automotive Acrylic *Plus* Attachment Tape Part No. 06397 is a 0.060-inch-thick, black, high-performance, double-coated acrylic foam tape. Part No. 06397 is a thicker 3M Acrylic *Plus* Tape for use where higher performance is necessary or there is greater mismatch between the trim part and substrate.

3M Automotive Acrylic *Plus* Attachment Tape is OEM approved, utilizing breakthrough technology developed by 3M. With its unique, new high-performance adhesives on both sides, it offers improved adhesion over a variety of conditions, leading to reduced rework and warranty issues, and offering the following key performance features:

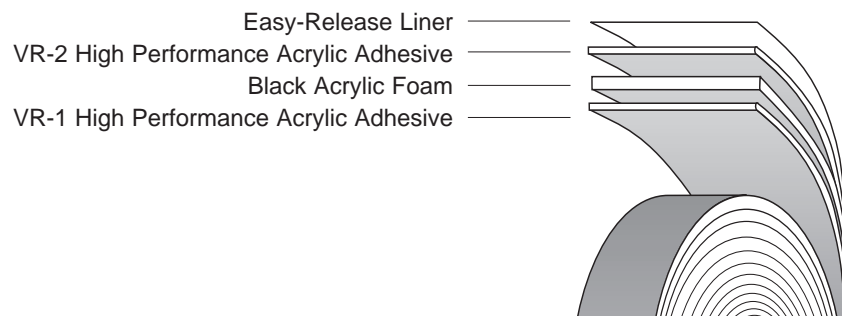
- Superior adhesion build rate to automotive substrates.
- More conformable core for excellent wet-out (tape contact to substrate).
- Black, high-strength core resulting in improved bond-line quality.
- High adhesion performance with excellent stress distribution.
- Easy liner release.

3M™ Automotive Adhesion Promoter 06396 is recommended for use on all plastic parts, such as RIM, TPO, PPO, PP, PC, PC+ABS, etc., for tape-to-part adhesion when used with 3M tape 06397.

Typical Applications



Product Construction



Technical Data Sheet 06397

Page 2

Physical Properties

Foam	Black acrylic
Liner color	Red
Thickness	0.060 in. (1,52 mm)
Package	Clam shell

Ordering Information

Part Number	Color	Size	Rolls Per Box	Boxes Per Case
06397	Black	1/2" x 10 yds (12,7 mm x 9,1 m)	1	12

Details

- Conformable, closed cell 1.52mm acrylic foam core provides excellent wet out on surface contours
- Good choice for demanding trim attachment or where a thick foam is required
- Features two different adhesives – one on each side of the tape for effective bonding
- Liner-side adhesive is designed for adherence to automotive paint systems
- Non-liner-side adhesive delivers excellent adhesion to metal and plastic parts
- Acrylic adhesives are formulated for high adhesive build rates on automotive substrates
- Black color provides good bond-line appearance
- Adhesion promoter recommended for tape-to-part adhesion on plastic parts

3M™ Automotive Acrylic Plus Attachment Tape 06397 features two adhesives, one on each side of a strong, conformable 1.52 mm closed-cell acrylic foam core. Our liner-side adhesive is formulated for bonding to automotive paint systems, and the non-liner-side bonds to metals and plastics used in automotive components. Both adhesives deliver excellent initial tack and adhesive build.

Two Adhesives for Bonding to Automotive Parts and Paint Systems

Developed specifically for attaching exterior trim and other parts to automotive substrates, our [3M™ Automotive Acrylic Plus Attachment Tape 06397](#) features a thick, durable 1.52 mm acrylic foam core with two different adhesives — one for each side of the application. Our liner-side adhesive delivers excellent adhesion to plastic and metal surfaces commonly found in automotive trim and other components. The non-liner-side adhesive provides very high initial and final adhesion for automotive paint surfaces, including scratch- and mar-resistant paint systems. Both adhesives are formulated for very high adhesive build and final adhesion to automotive surfaces.



Conformable core for excellent wet-out (tape contact to substrate)

Thick Foam Core Handles Higher Loads

The thick, 1.52 mm viscoelastic foam core conforms well even to complex geometries. It is engineered for stress relaxation when exposed to high stress loads, and maintains bond-line aesthetics under normal stress loads. The black color of this OEM approved tape helps create sharp bond-lines. Its 1/2" width makes it suitable for a versatile range of applications. A red, 3M branded liner provides easy one-piece release for efficient application.

Confidence in Your Purchase

The [3M branded liner](#) features a subtle 3M logo-marking to provide evidence to the customer that they are receiving the 3M quality they expect from their purchase. The liner makes our tapes easy to identify and difficult to imitate. This proprietary branding technology is designed to help identification of 3M™ Acrylic Foam Tapes.

3M recommends the use of 3M™ Automotive Adhesion Promoter 06396 for tape-to-part adhesion with 3M™ Automotive Acrylic Plus Attachment Tape 06397 on all plastic parts such as RIM, TPO, PPO, PP and PC.

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™ Automotive Acrylic Plus Attachment Tape 06397.

Rely on [premium tapes by 3M](#) if you're looking for quality and efficiency.