

Solutions for your assembly challenges.

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5,000+

adhesive and tape SKUs

Do it your way.

- 3M systems are built around *your* manufacturing processes, not the other way around.
- Whether it's structural or non-structural adhesives, bonding tapes or reclosable fasteners, 3M solutions ensure speed, convenience and ease of use.



88,667

employees

Do it together.

- No matter what you need to bond, you can count on 3M's expertise, technologies and 88,667 dedicated employees to help you find solutions.
- From wood, metal, foil, insulation, foam, fabric and panel lamination to specialty high performance and multipurpose materials of every kind, solutions are one call away.

Finding your
**3M Adhesive
& Tape**
Assembly Solutions

100,000

patents

Do it boldly.

- 3M has been a world leader in bonding technology for decades and we have the patents to prove it.
- Quality, consistency and reliability—the attributes you look for in a bonding solution—help drive our quest for new innovations.



1

chance to do it right

Do it responsibly.

- Sustainability is a natural extension of 3M's corporate values.
- We developed the first water-based contact adhesive ever — more than 40 years ago.
- We have a wide selection of Low VOC products that help contribute to LEED® credits and are GREENGUARD™ Certified.



Bonding Tapes

Convenience meets extreme bonding power.

Powerful Bonding Solutions

Help your customers successfully bond a variety of materials with strength and speed for permanent, structural and repositionable applications. Our double-sided bonding tapes provide shear strength, conformability, surface adhesion and temperature resistance.

3M™ VHB™ Tapes

Dream. Design. Deliver.

Since 1980, 3M™ VHB™ Tape has offered unlimited design and application possibilities. By working with 3M's engineering experts, product designers know they can count on this reliable solution. Lab-tested and proven in the real world, 3M™ VHB™ Tape eliminates rivets, bolts, screws and welds.

- Durability for long-term performance indoors and out
- Productivity through application ease and versatility
- Instant bonding
- Smooth, invisible appearance
- Viscoelastic properties absorb shock and distribute stress evenly over the bond line
- Bond dissimilar materials with confidence



194



195

3M™ VHB™ Tape bonds panels to a bus on contact. The tape seals against water, moisture and more. Bonding power eliminates mechanical fasteners for a smooth, clean surface. Viscoelastic properties help absorb shock and vibration for bond reliability.



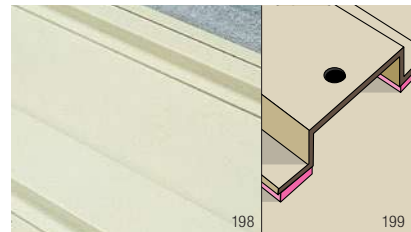
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To join a variety of materials for high impact visual combinations throughout a refrigerator, 3M™ VHB™ Tape bonds painted and unpainted metal, HSE and LSE plastics, ceramics and more.



197

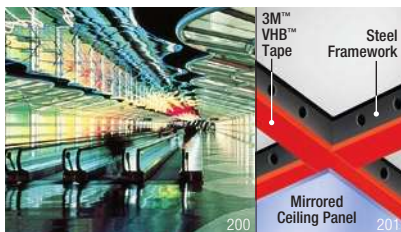
For assembly efficiency, die-cut pieces of 3M™ VHB™ Tape bond components on a laptop.



198

199

3M™ VHB™ Tapes bond panel stiffeners on contact to pre-painted metal cabinetry. Unlike welding, applying the tape does not damage the finish.



200

201

Mirrored ceiling panels are held in place with 3M™ VHB™ Tapes rather than screws. This helps maintain a clean, smooth appearance without distorting the reflective surfaces.



202

For a heat resistant bond, 3M™ VHB™ Tapes bond and seal stainless steel trim to the glass oven door with strength enough to replace mechanical fasteners. Door surface is smooth and attractive.



203

With high holding power and long-term reliability, 3M™ VHB™ Tape bonds dimensional letters to a painted wall for indoor or outdoor signage.

3M™ VHB™ Tapes — Typical Applications

3M™ VHB™ Tape is a proven high-strength alternative to screws, rivets, welds and other forms of traditional fastening methods. While a screw or a rivet can join two substrates at a single point, 3M™ VHB™ Tape permanently adheres one substrate to another and spreads the stress load across the entire length of the joint. The most common applications for 3M™ VHB™ Tape are:

Panel to Frame Applications

- Reduce weight and solve dynamic force challenges
- Create a clean appearance



Stiffener to Panel Applications

- Exceptional vibration and corrosion resistance
- Deliver unique designs



Lens Window to Housing Applications

- Securely seal dissimilar materials
- Enhance productivity
- Create innovative designs



Decorative Material Attachment Applications

- Unlimited opportunities to enhance products
- Flexibility of production and design



3M™ VHB™ Tapes

Product Number	Tape Thickness w/o Liner mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Solvent Resistance	Relative Adhesion		Application Ideas					
					Minutes Hours	Days Weeks		HSE	LSE						
4941 Tape Family															
4926	15 (0.4)	A	Gray, closed-cell acrylic foam carrier. Conformable. Good adhesion to many painted metals. Plasticizer resistant. UL 746C.	Multi-purpose Acrylic	300°F (149°C)	200°F (93°C)	High	High	Med	Bond and seal polycarbonate lens over LCD. Bond and seal plastic windows to pre-painted control panels/switch gear. Mount vinyl wiring ducts and conduit channels. Seam vinyl banners.					
4936	25 (0.64)	A													
4936F	25 (0.64)	F													
4941	45 (1.1)	A													
4941F	45 (1.1)	D													
4956	62 (1.6)	A													
4956F	62 (1.6)	F													
4991	90 (2.3)	F													
4991B	90 (2.3)	F	Black version of 4991.												
4919F	25 (0.64)	F	Black version of 4936F.												
4947F	45 (1.1)	F	Black version of 4941F.												
4979F	62 (1.6)	F	Black version of 4956F.												
5952 Tape Family															
5906	6 (0.15)	G	Black, closed-cell acrylic foam carrier. Good adhesion to many painted surfaces, including powder coated paint.	Modified Acrylic	300°F (149°C)	250°F (121°C)	High	High	Med	Bond and seal polcarbonate lens over LCD. Lens and touch panel bonding. Logo attachment. P.O.P. and display construction.					
5907	8 (0.2)	G													
5908	10 (0.25)	G													
5909	12 (0.3)	G													
5915	16 (0.4)	F	Black or white, closed-cell acrylic foam carrier. Good adhesion to many painted surfaces, including powder coated paint. UL 746C.							300°F (149°C)	250°F (121°C)	High	High	Med	Bonds to a variety of plastics and paint systems. Bond architectural signs to frames. Attach trim and extrusions. Hat channels and stiffeners.
5915P	16 (0.4)	E													
5915WF	16 (0.4)	F													
5925	25 (0.6)	F													
5925P	25 (0.6)	E													
5925WF	25 (0.6)	F													
5930	32 (0.8)	F													
5930P	32 (0.8)	E													
5930WF	32 (0.8)	F													
5952	45 (1.1)	F													
5952P	45 (1.1)	E													
5952WF	45 (1.1)	F													
5962	62 (1.6)	F													
5962P	62 (1.6)	E													
5962WF	62 (1.6)	F													
5958FR	40 (1)	F	Meets FAR 25.853 (a) 12 sec vertical burn Appendix F, Part 1 (a) (ii)		300°F (149°C)	200°F (93°C)				Overhead stow bins, signage, kick plates, galley modules, plastic and metal decorative trim, ceiling tile stiffeners, mirror mounting, air duct spuds, floor and wall panel attachment and clip attachment.					
RP Tape Family															
RP16	16 (0.4)	A	Gray, closed-cell acrylic foam carrier. Conformable. Good adhesion to many painted metals.	Multi-purpose Acrylic	250°F (121°C)	200°F (93°C)	High	High	Med	Panel bonding, stiffener attachment and trim attachment.					
RP16F	16 (0.4)	F													
RP25	25 (0.6)	A													
RP25F	25 (0.6)	F													
RP32	32 (0.8)	A													
RP32F	32 (0.8)	F													
RP45	45 (1.1)	A													
RP45F	45 (1.1)	F													
RP62	62 (1.6)	A													
RP62F	62 (1.6)	F													

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3M™ VHB™ Tapes

Product Number	Tape Thickness w/o Liner mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Solvent Resistance	Relative Adhesion		Application Ideas
					Minutes Hours	Days Weeks		HSE	LSE	
4950 Tape Family										
4914	10 (0.25)	A	Closed-cell acrylic foam carrier. UL 746C.	General Purpose Acrylic	300°F (149°C)	200°F (93°C)	High	High	Low	Attach stiffeners in air conditioners, office furniture and telecommunications equipment.
4920	15 (0.4)	A								
4929	25 (0.6)	C								
4930	45 (1.1)	A								
4930F	45 (1.1)	D								
4949	45 (1.1)	C								
4950	45 (1.1)	A								
4955	80 (2)	C								
4959	120 (3)	C								
4959F	120 (3)	D								
4945 Tape Family										
4945	45 (1.1)	A	White, closed-cell acrylic foam carrier. Plasticizer resistant.	Multi- purpose Acrylic	300°F (149°C)	200°F (93°C)	High	High	Low	Attach vinyl trim. Bond vinyl extrusions.
4946	45 (1.1)	F								
4910 Tape Family										
4905	20 (0.5)	F	Clear, acrylic construction for joining transparent material.	General Purpose Acrylic	300°F (149°C)	200°F (93°C)	High	High	Low	Mount backlit translucent signs. Edge-bond resin filled glass.
4910	40 (1)	F								
4951 Tape Family										
4951	45 (1.1)	C	White, closed-cell acrylic foam carrier. Apply as low as 32°F (0°C).	Low Temp Applicable Acrylic	300°F (149°C)	200°F (93°C)	High	High	Low	Low temperature installed products.
4943F	45 (1.1)	C								
4957F	62 (1.6)	C								
4952 Tape Family										
4932	25 (0.6)	A	White, closed-cell acrylic foam carrier. Good adhesion to polypropylene and many powder paints.	Low Surface Energy	200°F (93°C)	160°F (71°C)	High	High	High	Bond powder painted metal stiffeners to office desks and file cabinets. Bond polypropylene and polystyrene.
4952	45 (1.1)	A								
4611 Tape Family										
4646	25 (0.6)	D	Dark gray, closed-cell acrylic foam carrier. High temperature resistance. UL 746C.	General Purpose Acrylic	450°F (232°C)	300°F (149°C)	High	High	Low	Pre-powder coat paint applications. Hat channels and stiffeners.
4611	45 (1.1)	D								
4655	62 (1.6)	D								
4622 Tape Family										
4618	25 (0.6)	H	White, closed-cell acrylic foam carrier.	General Purpose/ Multi- purpose Acrylic	250°F (121°C)	200°F (93°C)	High	High	Low	General purpose bonding.
4622	45 (1.1)	H								
4624	62 (1.6)	H								

Liner Types:

A – 3 mil 54# Densified Kraft Paper
 B – 5 mil Clear Polyethylene Film
 C – 2 mil Polyester Film
 D – 5 mil Red Polyethylene Film
 E – 4 mil 58# Polycoated Kraft Paper
 F – 5 mil Red Printed Polyethylene Film
 H – 5 mil Green PE Film

Relative Adhesion:

HSE – High Surface Energy
 LSE – Low Surface Energy

Multi-purpose Acrylic: Bonds to a wide range of materials including metals, glass, and high and medium surface energy plastics and paints. Resists migration of plasticizers in vinyl substrates.

Modified Acrylic: 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: Bonds to most higher surface energy substrates including metal, glass and high surface energy plastics.

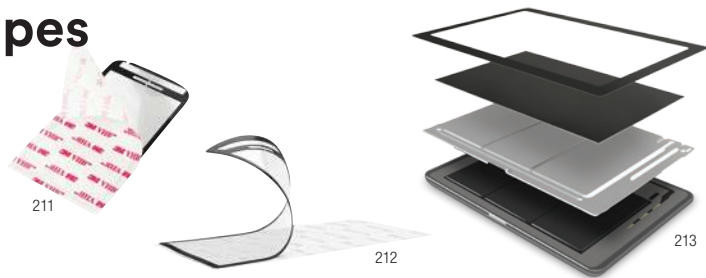
Low Temperature Acrylic: Bonds down to 32°F (0°C) compared to 50°F (10°C) for most acrylic adhesives. Bonds most high surface energy substrates including metal, glass and high surface energy plastics.

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

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3M™ VHB™ Thin Foam Tapes

With a uniquely thin form, 3M™ VHB™ Thin Foam Tapes go where thicker foam tapes simply can't, while still providing the same great benefits of regular 3M™ VHB™ Tapes. Common applications include LCD, lens and touch panel bonding, logo attachment and point of purchase displays.



Product Number	Tape Thickness w/o Liner mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Solvent Resistance	Relative Adhesion		Application Ideas
					Minutes Hours	Days Weeks		HSE	LSE	
5900 Tape Family										
5906	6 (0.15)	G	Black, closed-cell acrylic foam carrier. Good adhesion to many painted surfaces, including powder coated paint.	Modified Acrylic	300°F (149°C)	250°F (121°C)	High	High	Med	LCD, lens and touch panel bonding, logo attachment, P.O.P. and display construction.
5907	8 (0.2)									
5908	10 (0.25)									
5909	12 (0.3)									
86400 Tape Family										
86415	6 (0.15)	G	Black, closed-cell acrylic foam carrier. Good adhesion to many surfaces. Excellent shock/drop characteristics.	Acrylic	250°F (121°C)	180°F (82°C)	Med	High	High	LCD, lens and touch panel bonding, logo attachment, P.O.P. and display construction.
86420	8 (0.2)									
86425	10 (0.25)									
86430	12 (0.3)									
4914 Tape Family										
4914-15	6 (0.15)	A	White, closed-cell acrylic foam carrier.	General Purpose	300°F (149°C)	200°F (93°C)	High	High	Low	LCD, lens and touch panel bonding, logo attachment, P.O.P. and display construction.
4914-20	8 (0.2)	A								
4914	10 (0.25)	A	White, closed-cell acrylic foam carrier. All-purpose adhesive. UL 746C.							

3M™ VHB™ Tape for Commercial Vehicles and Trailers

Built Tough with Smooth Sides to Look Good for the Long Haul

For durability and smooth sides on trailers, trucks, buses, and other commercial vehicles, 3M™ VHB™ Tapes are proven to go the distance.

- 3M™ VHB™ Tape is up to 41% quieter than mechanical fasteners with up to 30% less vibration at highway speeds
- Surfaces of truck panels are aesthetically smooth and graphics apply easily
- Permanently bonds and seals

3M™ VHB™ Tapes for Commercial Vehicles and Trailers are only available through authorized distributors and a warranty may be available on pre-approved applications.



Mechanically fastened at 36,000 miles — leaks at less than 75 psi.



Smooth sides with 3M™ VHB™ Tape at 100,000 miles — no leaks at 3200 psi.

Product Number	Tape Thickness w/o Liner mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Solvent Resistance	Application Ideas
					Minutes Hours	Days Weeks		
CV45F	45 (1.1)	D	Gray, closed-cell acrylic foam carrier. Conformable. Good adhesion to many painted metals.	Multi-purpose Acrylic	300°F (149°C)	200°F (93°C)	High	Bond overlap seams on vehicle side panels.
CV62F	62 (1.6)	F						Bond vehicle side panels to posts.

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

3M™ VHB™ Structural Glazing Tapes

Application Ease and Immediate Handling Strength for Increased Productivity

3M™ VHB™ Structural Glazing Tapes have been proven in thousands of buildings worldwide since 1990 as an alternative to structural silicone and spacer tapes/gaskets.

Immediate handling strength results in faster throughput and delivery. No mixing or curing simplifies manufacturing.

Proven technology with a 30+ year history in construction, an application warranty* is available for qualifying applications in select countries.



Product Number	Tape Thickness w/o Liner mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Relative Adhesion		Solvent Resistance
					Minutes Hours	Days Weeks	HSE	LSE	
G23F	90 (2.3)	F	Gray, closed-cell acrylic foam carrier. Conformable.	Multi-purpose Acrylic	300°F (149°C)	200°F (93°C)	High	Med	High
B23F			Black, closed-cell acrylic foam carrier. Conformable.						

*3M™ VHB™ Structural Glazing Tapes are only available for structural glazing applications approved by 3M Technical Service through select distributors.

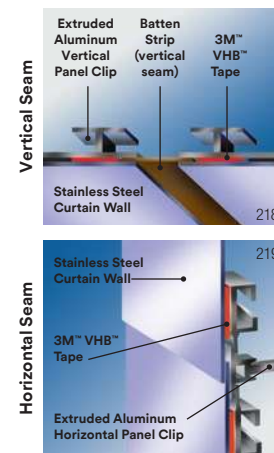
3M™ VHB™ Architectural Panel Tapes

Proven for More Than 30 Years in Applications from Denver to Singapore

For quick permanent assembly of cladding and curtain wall panels, 3M™ VHB™ Tapes provide an ideal combination of durability, performance and application ease.

Bond to a wide range of architectural panel substrates including dissimilar materials. With design flexibility, create visibly stunning facades.

Application warranty available for qualifying applications in select countries.



Product Number	Tape Thickness w/o Liner mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Solvent Resistance	Relative Adhesion	
					Minutes Hours	Days Weeks		HSE	LSE
G11F	45 (1.1)	Red, Printed Film	Gray, closed-cell acrylic foam carrier. Conformable.	Multi-purpose Acrylic	300°F (149°C)	200°F (93°C)	Med	High	Med
B11F	45 (1.1)		Black, closed-cell acrylic foam carrier. Conformable.						
G16F	62 (1.6)		Gray, closed-cell acrylic foam carrier. Conformable.						
B16F	62 (1.6)		Black, closed-cell acrylic foam carrier. Conformable.		250°F (121°C)	200°F (93°C)	Med	High	Med
G90F	90 (2.3)		Gray, closed-cell acrylic foam carrier. Conformable.						
B90F	90 (2.3)		Black, closed-cell acrylic foam carrier. Conformable.						

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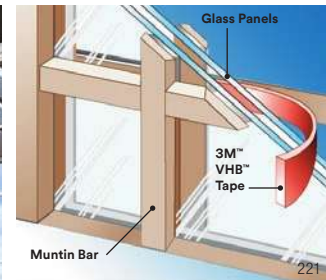
3M™ VHB™ Tape for Windows and Doors



Attach Wood, Vinyl, Composite or Painted Metal Muntin Bars to Windows

These high strength tapes conform to glass with good wet-out and resistance to UV light, thermal expansion and contraction, solvents and cleaners. Tapes below are available only for approved window and door customers. Pre-approved applications may be eligible for a 10-year warranty.

See 3M™ Primers on page 69.



Product Number	Tape Thickness w/o Liner mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Solvent Resistance	Relative Adhesion	
					Minutes Hours	Days Weeks		HSE	LSE
G45P	45 (1.1)	A	Gray, closed-cell acrylic foam carrier. Conformable.	Multi-purpose Adhesive	300°F (149°C)	200°F (93°C)	High	High	Med
G45F		D	Gray, closed-cell acrylic foam carrier. Conformable.						
B45F		F	Black, closed-cell acrylic foam carrier. Conformable.						

3M™ VHB™ Tape for Sign and Display

Reliable and Immediate Bonding

For indoor and outdoor signage, 3M™ VHB™ Tapes hold immediately without the work of screws and the mess and curing time of liquid adhesives.

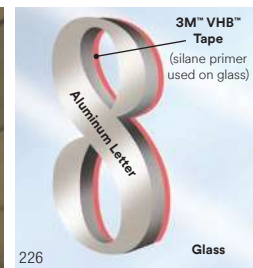
- Bond metals, plastics, glass, foam board and more
- Invisible fastening for smooth, attractive surfaces



3M™ VHB™ Tape provides durable bonding in outdoor applications.



Clear 3M™ VHB™ Tape permanently bonds aluminum letters to glass and appears almost invisible from behind the pane.



Product Number	Tape Thickness w/o Liner mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Solvent Resistance	Relative Adhesion		Application Ideas
					Minutes Hours	Days Weeks		HSE	LSE	
5952	45 (1.1)	F	Black or white, closed-cell acrylic foam carrier. Good adhesion to many painted surfaces, including powder coated paint. UL 746C.	Modified Acrylic	300°F (149°C)	250°F (121°C)	High	High	Med	Bond and seal metal and plastic through a sign.
5952WF	45 (1.1)	F								
5962	62 (1.6)	F								
4910	40 (1)	F	Clear, acrylic construction for joining transparent material.	General Purpose	300°F (149°C)	200°F (93°C)	High	High	Low	Bond unpainted metal.
4941	45 (1.1)	A	Gray, closed-cell acrylic foam carrier. Good adhesion to many painted metals. Plasticizer resistant. UL 746C.	Multi-purpose Acrylic	300°F (149°C)	200°F (93°C)	High	High	Med	Bond flexible vinyl banners.
4956	62 (1.6)	A								

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3M™ VHB™ Tape for Appliances



3M™ VHB™ Tape is the Ultimate Solution for Appliance Design Applications

From the kitchen to the laundry room, trust in 3M™ VHB™ Tape to expand design freedom in everything from how the side panels hold together to the way a brand's logo is displayed. Thanks to the viscoelastic properties of 3M™ VHB™ Tape, OEM consumer and commercial design engineers and manufacturers have access to a new realm of opportunities for beautiful, more efficient household appliance designs.



227

Product Number	Tape Thickness w/o Liner mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Solvent Resistance	Relative Adhesion		Application Ideas
					Minutes	Hours		HSE	LSE	
4941	45 (1.1)	A	Gray, closed-cell acrylic foam carrier.	Multi-purpose Acrylic	300°F (149°C)	200°F (93°C)	High	High	Med	Logo attachment, overlay attachment and control panel assembly.
5952	45 (1.1)	F	Black, closed-cell acrylic foam carrier.	Modified Acrylic	300°F (149°C)	250°F (121°C)				
RP45	45 (1.1)	A	Gray, closed-cell acrylic foam carrier.	Multi-purpose Acrylic	250°F (121°C)	200°F (93°C)				

3M™ VHB™ Tape for Electronics

Electronic designs are becoming lighter, thinner and smaller every day. Bulky mechanical systems can be replaced with the incredible, strong, long-lasting viscoelastic bond of 3M™ VHB™ Tape. Expand design freedom and simplify manufacturing processes while meeting the challenges of a dynamic market and look no further than 3M™ VHB™ Tape.



228

Product Number	Tape Thickness w/o Liner mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Solvent Resistance	Relative Adhesion		Application Ideas
					Minutes Hours	Days Weeks		HSE	LSE	
5908	10 (0.25)	G	Black, closed-cell acrylic foam carrier.	Modified Acrylic	300°F (149°C)	250°F (121°C)	High	High	Med	Bond and seal polycarbonate lens over LCD. Bond and seal plastic windows to pre-painted control panels/switch gear. Mount vinyl wiring ducts and conduit channels. Electronic component and assembly attachment.
5915	16 (0.4)	F								
5925	25 (0.6)	F								
5952	45 (1.1)	F								
RP16	16 (0.4)	A	Gray, closed-cell acrylic foam carrier.	Multi-purpose Acrylic	250°F (121°C)	200°F (93°C)	High	High	Med	
RP45	45 (1.1)	A								

3M™ Primers

Product Number	Solvent	Active Ingredients	VOCs	Color	Flashpoint	Coverage	Application Ideas
AP111	Isopropyl Alcohol (IPA)	Less than 5% by weight	5.91 lbs./gallon (708g/L)	Clear	52°F (11°C)	19m²/L (800 ft²/gal) based on .002" wet coating thickness depending on method of application	Promote better adhesion for bare metals and painted surfaces.
AP115	Isopropyl Alcohol and Water	Less than 1% by weight	6.08 lbs./gallon (728g/L)	Clear	53°F (12°C)	20–25 ft² per 4 fl. oz. bottle (1.8–2.3m² per 118mL bottle)	Promote better adhesion for glass.
Primer 94	See SDS	See SDS	Approx 6.3 lbs./gallon (755g/L) less H2O and exempt solvents	Clear Light Yellow/ Clear Dark Orange	-4°F (-20°C)	600 ft²/gal (211m²/L)	Promote better adhesion for a variety of plastic surfaces such as polyethylene, polypropylene, ABS and PET/PBT blends.

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3M™ Extreme Sealing Tapes



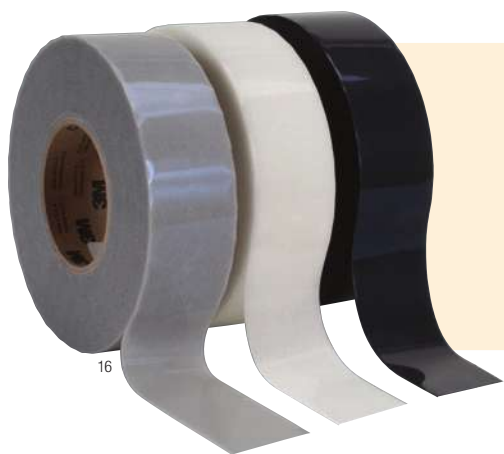
From Trailer, Bus and Rail Car Roof Seams to Metal Enclosures, a Sure Winner Over Traditional Sealants

- Sticks on contact to many metals and plastics without dripping, oozing or clean-up
- Increases productivity throughput with no drying time; immediately paintable*
- Conforms over contours, edges, rivets and screw heads for a water tight seal
- Looks neat and precise for improved aesthetics
- Outstanding resistance to many common industrial solvents
- Excellent resistance to abrasion and high pressure washing

*Accepts many paints. Test paint on tape to check for compatibility.



44



16

Suggested Uses

- RV trailer and roofs
- Metal enclosures
- Awnings
- Trailer home roofs
- Metal storage buildings
- Vent stacks/windows
- Gutters and downspouts
- Skylights
- Outdoor signs/displays
- Leak patching and repairs



Scan the code to download the 3M™ Extreme Sealing Tape Exterior Durability Report.

Product	Color	Backing/Adhesive	Tape Thickness mils (mm)	Tensile Strength lb/in (N/cm)	90° Peel Adhesion Strength [†] lb/in (N/cm)						Widths in (mm)	Length yd (m)
					Alumi- num	Stainless Steel	Glass	Truck Paint	PVC	ABS		
4411G	Grey	Ionomer Film/ Pressure Sensitive Acrylic	40 (1)	13 (23)	15 (26)	16 (28)	15 (26)	15 (26)	15 (26)	16 (28)	0.75, 1, 2, 2.5, 3, 4 (19, 25, 50, 65, 75, 100)	36 (32.9)
4411N	Neutral/Translucent		40 (1)		15 (26)	15 (26)	15 (26)	14 (25)	16 (28)	16 (28)		36 (32.9)
4411B	Black		40 (1)		19 (33)	17 (30)	19 (33)	17 (30)	19 (33)	18 (32)		36 (32.9)
4412N	Neutral/Translucent		80 (2)		18 (32)	18 (32)	19 (33)	19 (33)	19 (33)	19 (33)		18 (16.5)

[†]Adhesion promoters were used on peel Adhesion test substrates.

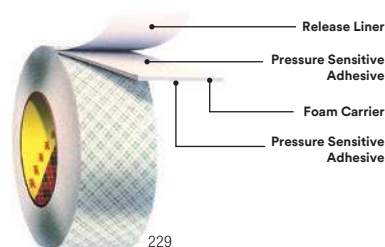
Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Double Coated Foam Tapes

Flexible Foam Carriers Fill Gaps and Help Bond Irregular Surfaces

In bonding rough or irregular surfaces, 3M™ Double Coated Foam Tapes fill gaps and distribute stress uniformly over the bonded area.

- Bond line that seals, cushions and damps vibration
- Resists impact
- Withstands a wide temperature range to meet your application requirements
- Provides good insulating qualities
- Select from rubber or acrylic adhesive and a choice of different foam carriers: urethane, polyethylene or acrylic



To replace screws and liquid adhesives, 3M™ Multipurpose Mounting Tape 4016 bonds immediately to many indoor surfaces, even permanently mounting a plastic soap dispenser to a mirror.



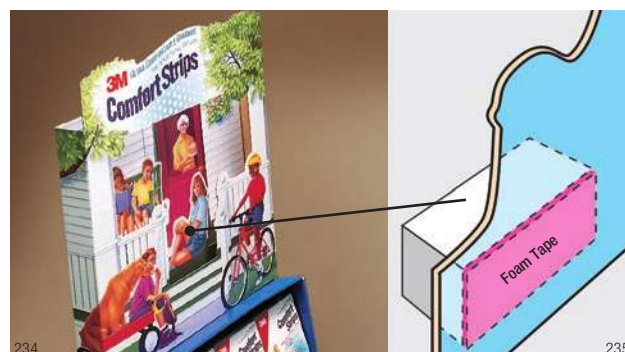
3M™ Double Coated Foam Tapes can be precisely die-cut and pre-applied to the back of any shape. Ready to mount to a variety of surfaces.



To permanently mount to a textured wall, 3M™ Extra Thick Multipurpose Mounting Tape 4008 bonds on contact and fills gaps between the surfaces.



3M™ Double Coated Urethane Foam Tapes bond plastic signs to painted cinder block. The foam fills gaps between irregular surfaces. Various foam thicknesses are available for surface conformance based on the degree of roughness.



3M™ Double Coated Polyethylene Foam Tapes with high tack adhesive bond foam spacers between the planes of a 3-dimensional P.O.P. display.

3M™ Double Coated Foam Tapes

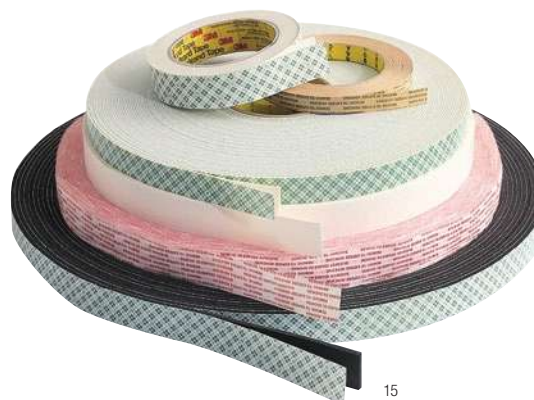
Product Number	Tape Thickness mils (mm)	Liner Type	Description	Adhesive Type	Temp. Resistance		Adhesive Type	Relative Adhesion		Application Ideas
					Minutes Hours	Days Weeks		HSE	LSE	
Urethane										
4004	250 (6.4)	A	Off-white, open-cell urethane foam carrier. High shear adhesive with high temperature resistance.	100	380°F (193°C)	220°F (104°C)	Med	High	Low	Bond acoustic panels to walls. Mount air fresheners. Mount soap dispensers. Mount interior signs and nameplates. Attach wire clips to various surfaces. Mount electrical channel to wall.
4008	125 (3.2)									
4016	62 (1.6)									
4026	62 (1.6)									
4032	31 (0.8)									
4052	31 (0.8)									
4056	62 (1.6)		Black versions of 4016 and 4026.	100	380°F (193°C)	220°F (104°C)				
4085	45 (1.1)	E	Off-white, open-cell urethane foam carrier. High tack adhesive.	740	200°F (93°C)	125°F (52°C)				
Polyethylene										
4451	32 (0.8)	C	Black, closed-cell, high density polyethylene foam carrier. High tack synthetic rubber.	A135	150°F (66°C)	120°F (49°C)	Med	High	Low	Removable applications where good static is needed. Exhibits and trade shows. Nameplates.
4462	31 (0.8)	B	White or black, closed-cell polyethylene foam carrier. High tack adhesive.	745	158°F (70°C)	120°F (49°C)				Attach hooks, wire clips and racks. Mount retail shelf price channels. Mount pen holders.
4466	62 (1.6)									
4492	31 (0.8)	C	White or black, closed-cell polyethylene foam carrier. High shear adhesive with high temperature resistance.	430	180°F (82°C)	158°F (70°C)				Mount nameplates on awards and novelties. P.O.P. displays and signs.
4496	62 (1.6)									
Acrylic										
4658F	31 (0.8)	D	Clear, closed-cell, acrylic foam tape. Clean removability from many substrates.	100	212°F (100°C)	175°F (80°C)	High	High	Low	Removable P.O.P. displays. Signs. Exhibits and trade shows. Nameplates.

Liner Types:

A – 3 mil 62# Densified Kraft paper – Green plaid
B – 3 mil Densified Kraft paper – White
C – 4 mil 58# Polycoated Kraft paper – Tan
D – 2 mil Polyester film – Clear
E – 3 mil Densified Kraft paper – Tan

Relative Adhesion:

HSE – High Surface Energy
LSE – Low Surface Energy



15

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

3M™ Double Coated Tapes

A Variety of Carriers for Easy Handling and Dispensing

3M™ Double Coated Tapes are engineered with adhesive on both sides of paper, film or tissue. This increases the dimensional stability of the adhesive for easy handling and application.

Depending on your production volume, you can apply tape by hand or with automatic high-volume dispensers. Select paper, polyester film or other synthetic carriers to help meet your special needs. Different adhesives (rubber, silicone or acrylic) can be on opposite sides of the carrier to join different materials. Your choice of properties include high temperature resistance, conformability to irregular surfaces, high initial adhesion, high shear strength and more.



236 Simply roll on a strip or band of 3M™ Double Coated Tape 9832 for quick edge banding with no special equipment. Pressure sensitive adhesive tape grabs with immediate handling strength for improved productivity.



237 With differential adhesive, the silicone adhesive side of 3M™ Double Coated Tape adheres to a silicone rubber keypad. Acrylic adhesive side adheres to a plastic base.



238 3M™ Double Coated Tape 410M is the quick, convenient way to bond golf club grips to shafts. Adhesive sets up fast and bonds firmly for long-lasting performance.



239 For precise fit, 3M™ Double Coated Tape is pre-applied to foam gasketing materials and then die-cut to size. This helps increase dimensional stability of the part to facilitate assembly.

Product	Description/ Application Ideas	Tape Cal. (mils)	Carrier Type	Liner		Master Size	Specs	Adhesion				Chem. Resist.	Temp. Range	
				Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
200MP/300LSE (Differential Adhesive)														
9496LE	Differential double coated tape featuring High Performance Acrylic Adhesive 200MP and Low Surface Energy Acrylic Adhesive 300LSE.	6.7	PET	58# PCK	4.2	24" x 36" sheets	—	10	9	1	2	9	-40	400
								9	9	10	1	8	-40	300
300LSE (Low Surface Energy Acrylic)														
93005LE	Very thin double-coated tape polyester tape with good anti-lifting properties.	2.0	PET	58# PCK/ 83# PCK	4.2/ 6.2	48" x 60 yd	—	9	9	10	1	8	-40	300
93010LE	High adhesion to polypropylene and LSE plastics for excellent graphic appearances. Good chemical/humidity resistance.	3.9	PET	58# PCK	4.2	54" x 180 yd	—							
93015LE		5.9	PET	58# PCK	4.2	54" x 180 yd	—							
93020LE		7.9	PET	58# PCK	4.2	54" x 180 yd	—							

Values: 1 = Lowest Performance; 10 = Highest Performance

Rankings are a general guide. Adhesives should be tested with actual components to ensure acceptable performance.

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

3M™ Double Coated Tapes



292

Product	Description/ Application Ideas	Tape Cal. (mils)	Carrier Type	Liner		Master Size	Specs	Adhesion				Chem. Resist.	Temp. Range		
				Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)	
300 (High Strength Acrylic)															
444	Foam lamination. Gasket attachment.	3.9	PET	55# DK	3.2	48" x 108 yd	—	7	9	9	9	6	-40	250	
444PC	Foam lamination. Gasket attachment.	3.9	PET	58# PCK	4.2	48" x 108 yd	—								
300MP (High Tack Acrylic)															
99786	Thin nonwoven carrier for dimensional stability and improved handling. Temperature resistance up to 300°F.	5.5	Non-woven	58# PCK Printed	4.2	48" x 180 yd	—	7	7	8	9	7	-40	250	
99786NP	Same as 9786 except an unprinted liner.	5.5	Non-woven	58# PCK Unprinted	4.2	54" x 180 yd	—								
9832	General purpose tape with improved temperature resistance.	4.8	PET	58# PCK	4.2	54" x 250 yd	—								
9832HL	Same as 9832 except with a heavier liner.	4.8	PET	58# PCK	6.2	54" x 250 yd	—								
340 (High Tack Acrylic)															
9456	High tack acrylic adhesive with good adhesion to many plastics.	5.0	Tissue	55# DK	3.2	54" x 180 yd	—	6	6	5	4	8	-40	180	
9824	Foam lamination. Gasket attachment.	3.1	PET	55# DK	3.2	54" x 250 yd	—								
9828		4.0	PET	55# DK	3.2	54" x 250 yd	—								
9828PC	High tack acrylic adhesive with good adhesion to many foams.	4.0	PET	74# PCK	5.6	54" x 250 yd	—								
350 (High Performance Acrylic)															
9500PC	High performance with good chemical resistance.	5.6	PET	61.5 PCK	4.5	48" x 108 yd	—	9	10	10	9	8	-40	450	
3028EK	Same as 9500PC with an extensible kraft liner which facilitates narrow slitting.	5.6	PET	Extensible Kraft	5.5	48" x 108 yd	—								
375 (High Performance Double Coated)															
9086	Easy tearing, easy handling.	7.5	Tissue	Glassine Black Logo	3.0	54" x 750 yd	—	High	High	Med	Low	Good	-10	250	
9087	Thick adhesive to bond rough surfaces.	10.2	PVC	Glassine Green Logo	3.0	54" x 750 yd	—							185	
9088	High temperature resistance with paper liner.	8.3	PET	Glassine Red Logo	3.0	54" x 750 yd	—							300	
9088FL	High temperature resistance with film liner.	8.3	PET	Red PP, No Print	3.1	54" x 750 yd	—							300	
400 (Acrylic Adhesive)															
415	Splice papers, films and foils.	4.0	PET	60# DK	4.0	48" x 108 yd	—	5	5	5	5	5	-60	250	
9576		4.0	Clear PP	60# DK	4.0	27" x 360 yd	—								

Values: 1 = Lowest Performance; 10 = Highest Performance

Rankings are a general guide. Adhesives should be tested with actual components to ensure acceptable performance.

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3M™ Double Coated Tapes

Product	Description/ Application Ideas	Tape Cal. (mils)	Carrier Type	Liner		Master Size	Specs	Adhesion				Chem. Resist.	Temp. Range	
				Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
Silicone/Acrylic Differential														
9731	Differential adhesive. Silicone/Acrylic double coated tape. Ideal for attaching silicone materials to HSE or LSE materials.	5.5	PET	Clear PET/54# Tan PCK	3.0/5.4	48" x 180 yd	—	10	10	9	8	8	-40	300
Silicone														
96042	Silicone attachment. Silicone lined for easier processing.	5	PET	White PET	2	48" x 180 yd	—	9	8	7	6	10	-40	350
700/745/760 (Synthetic Rubber)														
9443NP	High tack rubber adhesive with good adhesion to most plastics.	6	HDPE	60# DK	3.7	27" x 120 yd	—	8	9	9	2	2	-40	200
9579	Core starting on metal cores.	9	HDPE	62# DK	3.7	27" x 144 yd	—							
9589	Carpet attachment.	9	HDPE	60# DK	3.7	26" x 144 yd	—							
830/850/860 (Natural Rubber)														
401M	Used for mounting rubber or photopolymer printing plates.	9.0	Paper	54# DK	3.0	22" x 108 yd	—	8	8	8	5	1	-40	180
410M	Core starting/end tabbing of papers, films and foils.	6.0	Paper	54# DK	3.0	23.5" x 108 yd	—	8	8	8	5	1	-40	200
900 (Miscellaneous)														
9737	Clear, thin PET carrier. Aggressive and versatile splicing tape.	3.5	PET	55# DK White	3.5	54" x 180 yd	—	5	5	2	5	7	-10	300
9738	Clear, non-woven tissue carrier. Aggressive and versatile splicing tape.	4.3	Non-woven tissue	55# DK White	4.3	54" x 180 yd	—							
9740	Clear, high peel, tack and shear strength. Performance grade splicing tape for corrugators.	3.5	PET	55# DK	3.5	54" x 180 yd	—	6	6	2	3	6	10	425
9741	Clear, thick, super aggressive tape. Adheres to a wide variety of substrates for splicing applications.	6.5	PET	55# Glassine	6.5	54" x 180 yd	—	7	7	3	7	5	-40	200
9816L	General purpose, high tack, rubber-based adhesive.	3.5	PET	60# Kraft	3.5	54" x 200 yd	—	8	8	7	7	3	-40	150
9816M				74# Kraft	3.5	54" x 200 yd	—							
9816H				14 pt. Board	3.5	54" x 200 yd	—							
9817L	Exposed side is acrylic, liner side is rubber-based. Excellent quick stick and adhesion to high and low energy surfaces.	3.3	PET	60# Kraft	3.5	54" x 200 yd	—	8	7	6	7	3	-40	175
9817M				74# Kraft	3.5	54" x 200 yd	—							
9817H				14 pt. Board	3.5	54" x 200 yd	—							
Specialty Differential Rubber/Acrylic														
9377	Flame retardant double-coated tape for carpet installation to bond carpet to interior floorboards.	11.0	PP	58# PCK	4.2	24" x 25 yd	—	4, 10	—	—	—	8	40	250

Values: 1 = Lowest Performance; 10 = Highest Performance

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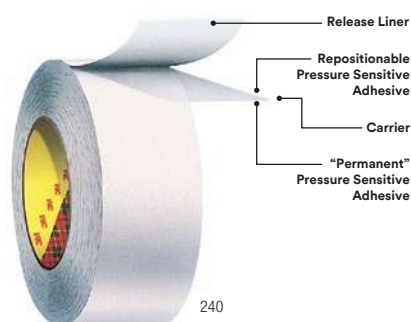
3M™ Removable/Repositionable Tapes

Versatility for Many Substrates on On-Off and Open-Close Applications

Some 3M™ Removable/Repositionable Tapes feature a “permanent” adhesive on one side of a film or tissue carrier and a removable/repositionable adhesive on the other side.

Other tapes in the line offer different levels of adhesion on each side. And others feature equal adhesive strength on each side for reliable attachment but with easy separation for repositioning or multiple openings and closings. You can join substrates that include glass, metals, wood, paper, painted surfaces and many plastics.

With lined versions, you can initially join one side to a surface while the other side is covered with the liner, ready to be joined later to the second surface. Linerless versions are used for bonding both surfaces at the same time.



3M™ Removable/Repositionable Tape seals hosiery bags for shipment and display but also lets the customer open and re-close the bag as necessary.



High tack side of 3M™ Removable/Repositionable Tape 9415 “permanently” adheres to cores for winding up paper or film. Low tack side releases the paper or film when unwinding.

Product	Description/ Application Ideas	Tape Cal. (mils)	Carrier Type	Liner		Master Size	Specs	Adhesion				Chem. Resist.	Temp. Range	
				Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
400/1000* (Differential Adhesive)														
9415PC	Differential adhesive; polyester film carrier.	2	PET	78# PCK	6.0	48" x 216 yd	—	5	5	5	4	5	-20	150
9416	Differential adhesive; tissue carrier.	1	Tissue	70# PCK	5.6	48" x 216 yd	—	3	1	1	—	2		
928 ATG	Reverse wound ATG version of 9416 on 1" core. Used with ATG700 Applicator.	1	Tissue	70# PCK	5.6	Width to 3/4" L to 36yds	—	3	1	1	—	2		
420/1050* (Differential Adhesive)														
9425	High tack/medium tack for repositionable parts.	5.5	UPVC	58# PCK	4.2	48" x 144 yd	—	8	7	1	4	2	-20	125
								3	1	1	1	2		
9425HT	High tack/medium tack acrylic adhesive offers permanent adhesion to one substrate with removability to the other.	5	PET	58# PCK	4.2	48" x 144 yd	—	8	7	1	4	2	-20	250
								3	1	1	1	2		
400/1070 (Repositionable Acrylic)														
665	Differential adhesive; linerless.	3.5	UPVC	None	—	46" x 108 yd	—	5	5	5	4	5	-60	125
666	Differential adhesive; lined.		UPVC	LDPE	4.0		—							
Differential Acrylic														
97027	High tack/low tack acrylic adhesive with polyester carrier (formerly Venture 4447).	2.9	PET	74# PCK	3.5	54" x 250 yd	—	8	7	6	5	3	-40	250
								1	1	1	1			
97042	High tack/medium tack acrylic adhesive with polyester film carrier (formerly Venture 523).	3.8		55# DK	3	54" x 250 yd	—	7	6	4	3	6	-40	275
								3	2	1	1			
1000 (Repositionable Acrylic)														
9449S	Laminates to various substrates to make them repositionable.	0.4	None	55# DK	3.2	48" x 360 yd	—	3	1	1	—	2	-20	250
100 (High Temp. Acrylic)														
9658F	Clear, closed foam acrylic foam tape.	31	None	PET	2.0	47" x 175 yd	—	9	8	1	—	9	-40	450
800 (Natural Rubber)														
401M	Temporary positioning or fixturing of parts during machining operations and plate mounting.	9	Paper	54# DK	3	22" x 108 yd	—	8	8	8	5	1	-40	180
410M		6				23.5" x 108 yd							-40	200

*Second number reflects removable adhesive side.

Values: 1 = Lowest Performance; 10 = Highest Performance

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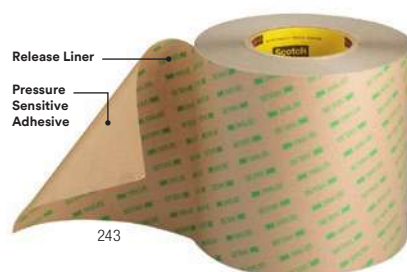
3M™ Adhesive Transfer Tapes

Neat, Precise Application and High Performance in a Variety of Applications

3M™ Adhesive Transfer Tapes are rolls of pressure sensitive adhesive pre-applied to a special release liner.

For application, the tape is simply pressed, adhesive side down, to a surface and the liner is peeled off.

A variety of adhesive properties and liners are available to meet requirements for applications such as nameplate attachment to high and low surface energy plastics, appliance graphic overlays that perform in high temperatures, foam gasketing, web splicing and more.



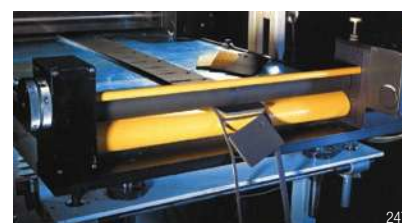
With high cohesive strength, 3M™ Adhesive 200MP bonds aggressively with excellent temperature resistance. Meets the non-fogging specifications of the automotive industry.



For bonding flexible vinyl in such applications as door gaskets, 3M™ Adhesive Transfer Tape F9465PC resists the effect of plasticizers that tend to migrate from the vinyl.



3M™ Laminating Adhesive 300LSE is the solution for low energy surfaces such as polyolefins and powder coat paint. Graphics hold securely and stand up to tough environmental conditions.



3M™ Adhesive Transfer Tapes provide conformability in a variety of foam laminating applications. The acrylic adhesive also provides high shear strength and good environmental aging properties.



3M™ Adhesive Transfer Tape 465 has the grab strength for many printing splices, including flying splices, zero speed and manual overlap. Can be used with a variety of paper grades.



3M™ Adhesive Transfer Tape 467MP is used to laminate metal foil to a circuit board to reduce interference on electronic circuitry.



For graphic beauty, 3M™ Acrylic Adhesive 100 attaches graphics in closed environments. With low odor, reduced outgassing and low fogging, it is used extensively in the automotive, aerospace and appliance industries.

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3M™ Adhesive Transfer Tapes



Product	Description/Application Ideas	Adhesive Caliper (mils)	Liner		Master Size	Specs	Adhesion				Chem. Resist.	Temp. Range	
			Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
100MP* (High Performance Acrylic)													
F9460PC	High performance industrial joining and metal fabrication.	2	58# PCK	4.2	60" x 180 yd	UL	10	7	1	2	10	-40	500
F9469PC	High performance industrial joining and metal fabrication.	5	58# PCK	4.2	60" x 180 yd	UL							
F9473PC	High performance industrial joining and metal fabrication.	10	58# PCK	4.2	60" x 180 yd	UL							
200MP (High Performance Acrylic)													
467MC	Same as 467MP with a paper MicroChannel liner to aid in bubble and wrinkle free graphic attachment.	2	58# PCK	4.2	54" x 180 yd	—	10	9	1	3	9	-40	400
467MCF	Same as 467MP with a polyester MicroChannel liner to aid in bubble and wrinkle free graphic attachment.	2	PET	4.2	54" x 180 yd	—							
467MP	Graphic attachment and general industrial joining. Industry standard. 60 in. width master also available.	2	58# PCK	4.2	48" x 180 yd	UL M ^H							
467MPF	Polyester liner for rotary processing of graphic and die cut parts.	2	PET	2.0	54" x 180 yd	UL							
468MC	Same as 468MP with a paper MicroChannel liner to aid in bubble and wrinkle free graphic attachment.	5	58# PCK	4.0	54" x 180 yd	—							
468MCF	Same as 468MP with a polyester MicroChannel liner to aid in bubble and wrinkle free graphic attachment.	5	PET	4.0	54" x 180 yd	—							
468MP	Industry standard for graphic attachment and die cut parts. 60 in. width master also available.	5	58# PCK	4.2	48" x 180 yd	UL M ^H							
468MPF	Thicker version of 467MPF.	5	PET	2.0	54" x 180 yd	UL							
9667MP	Same as 467MP on heavy, lay-flat liner for kiss-cutting. 48 in. width master also available.	2	83# PCK	6.2	54" x 180 yd	UL							
9668MP	Same as 468MP on heavy, lay-flat liner. 48 in. width master also available.	5	83# PCK	6.2	54" x 180 yd	UL M ^H							
9668MPL	Better lay-flat properties.	5	94# PCK	7.0	60" x 180 yd	—							
220 (Industrial Acrylic)													
9502	Economical attachment of graphics and industrial joining. 60 in. width master also available.	2	58# PCK	4.2	48" x 180 yd	UL	8	7	1	2	8	-40	350
9505	Thicker version of 9502 for textured surfaces. 60 in. width master also available.	5	58# PCK	4.2	48" x 180 yd	UL							
9552	Double-lined laminating adhesive version of 9502.	2.3	58/58# PCK	4.2	48" x 360 yd	UL							
9555	Double-lined laminating adhesive version of 9505.	4.9	58/58# PCK	4.2	48" x 360 yd	UL							

*Products in this platform are 3M™ VHB™ Tapes offering our highest strength.
M^H meets Mil-P-19834B Type I.

Values: 1 = Lowest Performance; 10 = Highest Performance

Rankings are a general guide. Adhesives should be tested with actual components to ensure acceptable performance.

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3M™ Adhesive Transfer Tapes



Product	Description/Application Ideas	Adhesive Caliper (mils)	Liner		Master Size	Specs	Adhesion				Chem. Resist.	Temp. Range	
			Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
290 (Low Outgassing Acrylic)													
501FL	Ultra-clean adhesive for low outgassing applications.	1	PET	2.0	54" x 180 yd	—	9	7	1	2	9	-40	450
502FL	Ultra-clean adhesive for low outgassing applications.	2	PET	2.0	54" x 180 yd	—							
300 (High Strength Acrylic)													
927	Attach gaskets and a variety of industrial foam materials.	2	60# DK	3.5	48" x 180 yd	—	7	9	9	9	6	-40	250
950	Thicker version of 927.	5	60# DK	3.5	48" x 180 yd	UL							
950EK	Thicker version of 927 with extensible Kraft liner.	5	78# EK	6.0	48" x 180 yd	—							
992U	For performance-engineered labels. UV indicator in adhesive.	2	55# DK	3.2	48" x 180 yd	UL							
9458	Thin, high tack adhesive for rotary processing HSE and LSE parts.	1	55# DK	3.2	54" x 360 yd	UL							
9459W	White version of laminating adhesive 9459S.	1.5	55# DK	3.2	48" x 360 yd	UL							
9471	For smooth LSE plastics.	2	60# DK	3.5	48" x 180 yd	UL M ^H							
9471PC	Same as 9471 on moisture-stable liner.	2	61# DK	4.2	48" x 180 yd	—							
9472	5.0 mil version of 9471; for textured surfaces.	5	60# DK	3.5	48" x 180 yd	UL M ^H							
9653	A 3.5 mil version of 9471 on a heavy, lay-flat liner for kiss-cutting.	3.5	83# PCK	6.2	48" x 180 yd	UL							
9671	Heavier lined version of 9471 for easy handling, lay-flat properties.	2	83# PCK	6.2	48" x 180 yd	UL M ^H							
9672	Heavier lined version of 9472 for easy handling, lay-flat properties.	5	83# PCK	6.2	48" x 180 yd	UL							
9673	Same as 9671 with unprinted liner.	2	83# PCK	6.2	48" x 180 yd	UL M ^H							
300FR (Flame Retardant)													
9372W	Flame retardant. Moisture stable liner.	2	83# PCK	6.2	60" x 180 yd	UL	8	9	9	9	6	-40	250
9372DKW	Flame retardant. Rotary diecuttable liner.	2	55# DK	3.2	60" x 180 yd	UL							
9375W	Flame retardant. Moisture stable liner.	5	83# PCK	6.2	60" x 180 yd	UL							

*Products in this platform are 3M™ VHB™ Tapes offering our highest strength.
M^H meets Mil-P-19834B Type I.

Values: 1 = Lowest Performance; 10 = Highest Performance

Rankings are a general guide. Adhesives should be tested with actual components to ensure acceptable performance.

3M™ Adhesive Transfer Tapes



Product	Description/Application Ideas	Adhesive Caliper (mils)	Liner		Master Size	Specs	Adhesion				Chem. Resist.	Temp. Range	
			Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
300LSE (Low Surface Energy Acrylic)													
9453FL	Film lined version of 9453LE for rotary processing.	3.5	PET	2.0	54" x 180 yd	UL	9	10	10	1	7	-40	300
9453LE	A 3.5 mil version of 9471LE for application to rough surfaces. 48 in. master width available.	3.5	58# PCK	4.2	54" x 180 yd	UL							
9471FL	Film lined version of 9471LE for rotary processing.	2.3	PET	2.0	54" x 180 yd	UL							
9471LE	Bonds graphics to powder coatings, LSE plastics and oily materials.	2.3	58# PCK	4.2	54" x 180 yd	UL							
9472FL	A 5 mil version of 9471LE with film liner for textured surfaces.	5.2	PET	2.0	54" x 180 yd	UL							
9472LE	Thicker adhesive for textured LSE plastics and powder coatings.	5.2	58# PCK	4.2	54" x 180 yd	UL							
9653LE	Heavy lined 9453LE for easy handling and lay-flat properties.	3.5	83# PCK	6.2	54" x 180 yd	UL							
9671LE	Heavy lined 9471LE for easy handling and lay-flat properties.	2.3	83# PCK	6.2	54" x 180 yd	UL							
9672LE	Heavy lined 9472LE for easy handling and lay-flat properties.	5.2	83# PCK	6.2	54" x 180 yd	UL							
300SF (Solvent-Free)*													
XT2112	High tack acrylic adhesive.	5	55# DK	3	48" x 60 yd	—	6	9	9	5	5	-40	200
XT2105	Thinner version of XT2112.	2	55# DK	3	48" x 60 yd	—							
300MP (High Tack Acrylic)													
6035PC	Resists fogging for automotive interior fabric joining applications.	5	58# PCK	4.2	60" x 180 yd	—	7	7	8	8	7	-40	250
6035PL	Heavy lined version of 6035PC for easy handling, lay-flat properties.	5	83# PCK	6.2	60" x 180 yd	—							
6038PC	Low fogging. Automotive fabric and carpet attachment.	8	58# PCK	4.2	60" x 180 yd	—							
6038PL	Low fogging. For rough embossed surfaces with heavy liner for steel rule die-cutting.	8	83# PCK	6.2	60" x 180 yd	—							
9772WL	Provides excellent bond to various fabricated foams, fabrics and substrates.	2	96# PCK	7.0	60" x 180 yd	—							
9773WL		3											
9774WL		4											
9775WL		5											
320 (High Tenacity Acrylic)													
9447	Designed for use with 3M™ Label Component Systems.	1	55# DK	3.2	54" x 360 yd	—	5	5	1	1	5	-60	250
350 (High Performance Acrylic)													
9442	Excellent temperature and solvent resistance; high bond to low surface energy substrates.	2	55# DK	3.2	48" x 180 yd	UL	9	10	10	9	8	-40	450
9445	Thicker version of 9442.	5	55# DK	3.2	48" x 180 yd	UL							
9482PC	High tack and shear strength; excellent adhesion to plastics and foams.	2	58# PCK	4.2	48" x 180 yd	UL							
9485EK	Thicker version of 9482PC with an extensible Kraft liner.	5	78# EK	6.0	48" x 180 yd	—							
9485PC	A 5 mil version of 9482PC.	5	58# PCK	4.2	48" x 180 yd	UL							
9675	Heavy lined version of 9485PC for easy handling, lay-flat properties.	5	83# PCK	6.2	48" x 180 yd	—							

*Manufactured using a solventless adhesive coating process.

Values: 1 = Lowest Performance; 10 = Highest Performance

Rankings are a general guide. Adhesives should be tested with actual components to ensure acceptable performance.

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

3M™ Adhesive Transfer Tapes



292

Product	Description/Application Ideas	Adhesive Caliper (mils)	Liner		Master Size	Specs	Adhesion				Chem. Resist.	Temp. Range	
			Type	Caliper (mils)			Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
400 (Acrylic Adhesive)													
463	High tack and excellent adhesion to most paper stocks. For automatic dispensing.	2	60# DK	3.5	48" x 180 yd	—	5	5	5	4	5	-60	250
465	Same as 463, but with easy liner release for manual or hand application.	2	60# DK	3.5	48" x 180 yd	—							
9457	Adhesive with long term stability, excellent outdoor performance and UV resistance. Adhesive 400 is best if necessary to apply at cooler temperatures.	1	55# DK	3.2	54" x 360 yd	UL							
9665	Thicker version of 9457.	2	58# PCK	4.2	48" x 180 yd	—							
420 (Acrylic Adhesive)													
F9752PC	High tack; can be applied in temperatures as low as 32°F (0°C).	2	58# PCK	4.2	54" x 360 yd	—	7	7	8	4	6	-40	300
F9755PC	Thicker version of F9752PC for textured surfaces.	5	58# PCK	4.2	54" x 360 yd	—							
430 (Acrylic Adhesive)													
9497	Pink tinted high temperature splicing tape.	2	60# DK	3.5	48" x 360 yd	—	6	6	5	4	5	-40	350
9499	Transparent version of 9497.	2	60# DK	3.5	48" x 360 yd	—							
Specialty Acrylic													
9379	Jet fuel and hydraulic fluid resistant adhesive transfer tape.	2	PET	2	48" x 200 yd	M ^H	9	8	1	2	9	-40	350
9380	Thicker version of 9379.	5	PET	2	48" x 200 yd	M ^H							
F9465PC	Vinyl plasticizer resistant adhesive.	5	58# PCK	4.2	54" x 360 yd	—	10	10	7	5	5	-40	200
F9467U	Vinyl plasticizer resistant adhesive.	3.5	58# PCK	4.2	54" x 180 yd	—							
Silicone													
91022	Silicone attachment. Silicone lined for easier processing.	2	White PET	2	48" x 180 yd	—	9	8	7	6	10	-40	500

M^H meets Mil-P-19834B Type I.

Values: 1 = Lowest Performance; 10 = Highest Performance

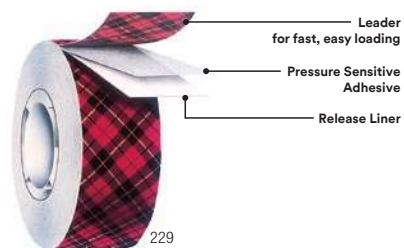
Rankings are a general guide. Adhesives should be tested with actual components to ensure acceptable performance.

Scotch® ATG Transfer Tapes

Finger Touch Application of Pressure Sensitive Adhesive

Versatility, convenience and speed. That's what you get with Scotch® ATG Transfer Tapes for assembly operations in businesses ranging from appliance and printing to P.O.P. and electronics. Readily bond, join, mount, or laminate materials such as paper, plastics, metal, foam and more.

With Scotch® ATG Applicators, a touch of the finger triggers a quick, controlled application of Scotch® ATG Transfer Tape at the same time as the liner rewinds into the applicator. There is no mess and no cleanup. 3M advanced acrylic adhesive bonds on contact and is formulated with a choice of properties such as high temperature resistance, differential tack, adhesion to low surface energy plastic and more.



Save time and effort with Scotch® ATG Transfer Tapes and Applicators. You apply a precise strip of adhesive at the same time as the liner rewinds into the applicator.



Scotch® ATG Applicator 700 with Scotch® ATG Transfer Tape 924 makes fast work of folder assembly. Pressure sensitive adhesive bonds immediately and the folder pocket is ready to hold contents.



Scotch® ATG Applicator 700 for 3/4" and 1/2" wide tape



Scotch® ATG Applicator 714 for 1/4" wide tape



Scotch® ATG Applicator 752C for 3/4", 1/2" and 1/4" wide tape (1/4" adapter purchased separately)



Scotch® ATG Applicator 3662 for 2" wide tape

Additional ATG products are available as part of the X-Series portfolio on page 84.

	Tape Thickness w/o Liner mils (mm)	Description	Temperature Resistance		Solvent Resistance	Relative Adhesion		Application Ideas	Adhesive Transfer Tape Equivalent
Product			Minutes Hours	Days Weeks		HSE	LSE		
300 (High Tack Acrylic)									
976	2 (0.05)	High tack. Excellent adhesion to most plastics.	250°F (121°C)	150°F (65°C)	Med	High	High	Attach fabric swatches in sample books.	927
969	5 (0.13)							Assemble point-of-purchase displays. Bond trim strips to furniture or luggage. Bond labels to plastic toys. Attach gaskets or foams.	950
350 (High Performance Acrylic)									
926	5 (0.13)	High performance. Excellent temperature and solvent resistance.	450°F (232°C)	300°F (149°C)	High	High	High	Bond fabric or trim to window blinds. Splice aluminum coils. Bond foam insulation. Mount nameplates on award plaques.	F9485PC
400 (General Purpose Adhesive)									
970XL	1 (0.025)	General purpose. Excellent adhesion to most paper stocks.	250°F (121°C)	180°F (82°C)	Med	Med	Low	Attach photos to layouts. Attach labels.	920XL
924	2 (0.05)							Seal pocket in folders. Bond mat board in picture frames. Splice paper, films, foils. General purpose bindery attaching.	465
987*	1.7 (0.040)								9498
400/1000 (Repositionable Adhesive)									
928	2 (0.05)	Differential tack. Repositionable.	180°F (82°C)	150°F (65°C)	Med	High/ Low	Low/ Low	Attach credit card in mailer. Core start/end tab paper, films and foils. Attach temporary labels.	9416

*3M Brand

Relative Adhesion: HSE – High Surface Energy; LSE – Low Surface Energy

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

3M™ Extended Liner Tapes

Versatile Pressure Sensitive Adhesive on Easy-to-Remove Liners

3M™ Extended Liner Tapes offer the adhesive versatility of 3M tapes but with liners wider than the adhesive. This leaves an easy-to-lift edge for convenient and easy liner removal. With the variety of adhesives, you have a selection of performance characteristics such as high tack for coated papers and plastics, low tack for temporary attachment, high temperature resistance and more. Apply manually or with equipment matched to your production volume requirements.



3M™ Extended Liner Tapes are available with a release liner wider than the adhesive. This provides an easy-to-grab edge for convenient liner removal.



Automatic and semi-automatic equipment is available for higher volume applications. For example, apply tape to business forms, literature, bounce back and business reply cards.



Depending on adhesive type, 3M™ Extended Liner Tapes are applied to envelopes, polybags, boxes or tubes. User simply peels off liner to expose the adhesive for an immediate, secure closure.



3M™ Extended Liner Tapes 450XL, 450EK and 465XL immediately bond product information “outserts” to polyethylene bottles. Holds tightly but can be cleanly removed.

Product	Tape Thickness w/o liner mils (mm)	Liner Type	Description	Temperature Resistance		Solvent Resistance	Relative Adhesion		Application Ideas
				Minutes Hours	Days Weeks		HSE	LSE	
340									
466XL	2 (0.05)	62# DK White with Black Print	High tack; Permanent	180°F (82°C)	150°F (65°C)	Med	High	High	Coated papers and low surface energy (LSE) plastics. Overnight envelopes. Features an end-of-roll indicator tab for automated dispensing.
400									
465XL	2 (0.05)	60# DK Tan with Green Print	General purpose	250°F (121°C)	180°F (82°C)	Med	Med	Low	Seal flaps on overnight envelopes. Pressure sensitive edging on business forms. General commercial joining applications. For attaching materials that require more adhesive thickness. Larger outsert attachments.
450EK	1 (0.025)	78# Extensible Kraft White w/o Print							Pharmaceutical outsert attachment. For applications requiring a more tear resistant liner.
450XL	1 (0.025)	60# DK Tan with Green Print							Pharmaceutical outsert attachment. General paper attachment.
920XL	1 (0.025)	40# DK White with Red Print							Seal flaps on polybags and envelopes. Pressure sensitive edging on business forms, literature, photos, posters and labels.
9926XL	1 (0.025)	40# DK White with Red Print	General purpose	180°F (82°C)	150°F (65°C)	Med	Med	Low	Economical alternative for general paper-to-paper applications.
600									
9934XL	4 (0.10)	60# DK tan without Print	High tack to LSE materials	150°F (65°C)	120°F 49°C)	Med	High	High	P.O.P. displays. Difficult splicing applications, shelf talkers, price tags, polyethylene foam bonding, indirect food-contact applications. ¹ High tack to LSE materials.
760									
476XL	6 (0.16)	62# DK White with Red Print	High tack, double coated film	150°F (65°C)	120°F 49°C)	Med	High	High	Heavy-duty sealing. Mounting of promotional items. Core starting. Closure of overnight boxes, tubes and envelopes. Indirect food-contact applications. ¹
770									
9925XL ²	2.5 (0.065)	43# DK White with Black Print	Tissue reinforced; High initial adhesion to a wide variety of materials	150°F (65°C)	100°F 41°C)	Low	Med	Med	General mounting, P.O.P. items. Attaching tags and labels. Core starting. Permanent bonding paper-to-paper, business forms, traffic tickets, novelty items and literature. Indirect food-contact applications. ¹

1 – FDA acceptable dry ingredients listed as indirect food-contact additives when used in food packing with minimal opportunity for exposure.

2 – Non-liner side is adhesive coated full width.

Relative Adhesion:

HSE – High Surface Energy
LSE – Low Surface Energy

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

3M™ Industrial Attachment Tapes — X-Series



Value, Performance and Quality

Selecting the right high-quality tape is now easier than ever. 3M™ X-Series Tapes set the standard for affordable adhesion with four simple categories: XP Series, XT Series, XG Series and XR Series.



262

		Tape Cal. (mils)	Carrier Type	Liner		Master Size	Adhesion				Chem. Resist.	Temp. Range	
Product	Description/Application Ideas			Type	Caliper (mils)		Metal	HSE Plastic	LSE Plastic	Foam		Low (°F)	High (°F)
XG Series (General Purpose Acrylic)													
XG2105	Ideal for assembling, bonding and attaching paper stocks in commercial printing, graphics, specialty packaging and fulfillment applications.	2	n/a	62# DK	2	48" x 60 yd	5	5	5	4	5	-60	250
XG5110	Attach papers and plastic films in print, graphics and specialty packaging applications	4	Clear PP	55# DK	4	27" x 60 yd	5	5	5	5	5	-60	250
XG6110	Used to attach papers and plastic film in print, graphic and specialty packaging applications.	4	Clear PET	55# DK	3.2	48" x 36 yd	5	5	5	5	5	-60	250
XP Series (High Performance Acrylic)													
XP2112	Ideal for hanging posters and signs, trophy and recognition placards, and nameplates and emblems; securely attach smooth surface moldings and trim.	5.0	n/a	55# DK	3.2	48" x 36 yd	9	10	10	9	8	-40	450
XP6114	High shear strength tape for mounting plastic and metal trim.	5.6	PET	58# PCK	4.2	48" x 36 yd	9	10	10	9	8	-40	450
XR Series (Rubber Adhesive)													
XR4123	Aggressive rubber adhesive with tough carrier for clean removal from solid surfaces.	9	HDPE	58# DK	4	27" x 36 yd	8	9	9	2	2	-40	200
XR4115	Aggressive rubber adhesive for superior quick stick adhesion. Clean removal from solid surfaces	6	HDPE	58# DK	4	27" x 60 yd	8	9	9	2	2	-40	200
XR8115	Hand tearable double coated paper tape for temporary holding and clean removal.	6	Paper	54# DK	3	23.5" x 36 yd	8	8	8	5	1	-40	200
XR8123	Hand tearable double coated paper tape with thick carrier for temporary holding and clean removal.	9	Paper	54# DK	3	22" x 36 yd	8	8	8	5	1	-40	180
XT Series (High Tack Acrylic)													
XT2105	Ideal for use on coated papers and other smooth surface materials.	2	n/a	55# DK	3.2	48" x 60 yd	6	9	9	4	5	-40	200
XT2112	Ideal for attaching smooth plastic trim, moldings and emblems. Holds securely to coated papers, film and many other textured surfaces.	5	n/a	55# DK	3.2	48" x 60 yd	6	9	9	4	5	-40	200
XT6110	Attaching porous fabrics, flock, foams and heavy cardstocks.	3.9	PET	55# DK	3.2	48" x 36 yd	7	9	9	9	6	-40	250

Values: 1 = Lowest Performance; 10 = Highest Performance

Rankings are a general guide. Adhesives should be tested with actual components to ensure acceptable performance.

Product	Tape Thickness w/o liner mils (mm)	Description	Temperature Resistance		Solvent Resistance	Relative Adhesion		Application Ideas	Adhesive Transfer Tape Equivalent
			Minutes Hours	Days Weeks		HSE	LSE		
XT Series — ATG Format (High Tack Acrylic)									
XT2105-ATG	2 (0.05)	General purpose. Excellent adhesion to coated papers, paperboard and plastics.	200°F (93°C)	150°F (65°C)	Med	High	High	Attach coated papers and plastics in printing and graphic applications.	XT2105
XT2112-ATG	5 (0.13)							Perfect for plastics assembly and for attaching heavy paperboards and corrugated in P.O.P. and packaging applications.	XT2112

Relative Adhesion: HSE – High Surface Energy; LSE – Low Surface Energy

Note: The technical information and data provided here should be considered representative or typical only and should not be used for specification purposes. User should evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for user's method of application.