



VHB™ Acrylic Foam Tape 4611F

Product Data Sheet

Updated : May 2004
Supersedes : June 2003

Product Description

4611F is a dark grey double coated acrylic foam tape with a high tack acrylic adhesive. This tape has a plain red filmic liner.

The excellent temperature performance enables bonding of materials prior to processing in a powder coating line

Physical Properties

Not for specification purposes

Adhesive Type	Acrylic
Foam Core	Acrylic
Thickness (ASTM D-3652) Tape	1.1 mm ± 0.1mm
Release Liner	Red Filmic
Tape Colour	Dark Grey
Foam Density	840 kg/m ³
Shelf Life	24 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity

Performance Characteristics

Not for specification purposes

Peel Adhesion to Stainless Steel 90° peel @ room temp, 72 hr dwell, jaw speed 300mm/min AFERA 4001 (modified)	32 N/10mm	
Static Shear Strength weight held for 100 hours to stainless steel with ½ sq in (3.23 sq cm) overlap	1000g @ 20°C 500g @ 70°C	
Temperature Performance Continuous	120 °C	
Intermittent	230 °C	

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Additional Product Information

This product is suitable for plasticised PVC but is not suitable for low surface energy plastics.

Application Techniques

1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact & thus improves bond strength.

2. To obtain optimum adhesion, the bonding

surfaces must be clean dry and well unified. A typical surface cleaning solvent is isopropyl alcohol & water. Use proper safety precautions for handling solvents.

3. Ideal tape application temperature range is 20°C to 40°C.

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

Applications

4611F is a high performance double coated acrylic foam product which possesses a good balance between shear peel and high tack adhesion. It has been designed to be suitable for a range of bonding applications which require a level of adhesion higher than standard double coated foam tapes but perhaps lower than higher performance 3M VHB™ tapes.

Typical applications include:

- Bonding roof bows on trucks and buses.
- Bonding glazing (muntin) bars or muntin bars positioned internally.
- Signage applications.

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