

3M
VHB™ Acrylic Foam Tape 4655F

Product Data Sheet

Date: May 2004

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Product Description

4655F 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

Construction

	VHB 4655F
Adhesive Type	Acrylic
Foam Core	Acrylic
Thickness (ASTM D-3652) Tape	1.5 mm ± 0.15mm
Release Liner	Red Filmic
Tape Colour	Dark Grey
Foam Density	840 kg/m ³

Performance Characteristics

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 Intermittent	120 °C 150 °C

Additional Product Information

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

Shelf Life

3M VHB 4655F has a shelf life of 24 months from date of despatch by 3M when stored in the original carton at 20°C & 50 % Relative Humidity

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 21°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

4655F 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 lower weight glazing (muntin) bars or muntin bars positioned internally.
- Signage applications.

For Additional Information

To request additional product information or to arrange for sales assistance, call.....

Address correspondence to: 3M

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