

3M
VHB™ Acrylic Foam Tape 4991

Product Data Sheet

Date: September 2002
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Product Description

3M™ VHB™ Acrylic Foam Tape 4991 is a double coated 0.090 in. (2.3 mm) pressure sensitive adhesive tape for bonding many painted metals, as well as unpainted metals, and higher surface energy plastics. 3B VHB Acrylic Foam Tape 4991 is appropriate for applications which demand a thicker conformable products.

Construction

Adhesive Type	Plasticiser Resistant
Thickness (ASTM D-3652)	2.3 mm
Foam Density	720 kg/m ³
Adhesive Carrier	Acrylic Foam (Closed Cell)
Liner	Red Polyethylene Film
Tape Colour	Grey

Performance Characteristics

Peel Adhesion to Stainless Steel	35 N/10mm
Static Shear Strength Weight held for 10,000 mins to stainless steel with ½ sq in (3.23 sq cm) overlap	1000 g @ 22°C 500 g @ 66°C 500 g @ 93°C
Temperature Performance Max (minutes/hours) Max Continuous (days/weeks)	120 °C 90°C
Normal Tensile (Aluminium T-Block)	415 kPa
Solvent Resistance	High

Shelf Life	3M VHB Acrylic Foam Tape 4991 has a shelf life of 24 months from date of manufacture when stored in the original carton at 20°C & 50 % Relative Humidity
Additional Product Information	For maximum bond strength the surfaces should be thoroughly cleaned with a 50:50 mixture of isopropyl alcohol and water. Consult manufacturers' directions for use and precautions when using cleaning solvents. Ideal tape application is accomplished when temperature is between 20°C and 40°C and the bond is allowed to dwell 72 hours. Initial tape application to surfaces at temperatures below 10°C is not recommended.
For Additional Information	To request additional product information or to arrange for sales assistance, call..... Address correspondence to: 3M
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Values presented have been determined by standard test methods and are average values not to be used for specification purposes.

Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications.

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3M Nederland BV

Industriële Tapes & lijmen

Postbus 193

2300 AD Leiden

e-mail: 3mbonding.nl@mmm.com

internet: www.3m.nl/tapes

www.3m.nl/lijmen

Customer Service:

Tel.: (071)5 450 187

Fax: (071)5 450 376