



# VHB™ Acrylic Tape

## 5604A

### Technical Data Sheet

2010.8

**Product Description** 3M™ VHB™ Acrylic Foam Tapes 5604A is double-coated pressure sensitive adhesive tapes for bonding metals and other high surface energy materials. It has excellent temperature resistance and can be used to bond metal parts prior to paint processing.

<b>Construction</b>	Adhesive:	General Purpose Acrylic
	Adhesive Carrier:	Firm Acrylic Foam
	Thickness:	0.40mm (15.7mil)
	Density:	780 kg/m <sup>3</sup>
	Liner:	Red PE film
	Tape Color:	Gray

**Typical Physical Properties and Performance Characteristics** **Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.**

Peel Adhesion (Stainless steel)	158 oz/in width ( 173N/100mm)
Normal Tensile (alum T-block)	60 psi (0.4 Mpa)
Solvent Resistance:	High
Shelf Life:	24 months from date of manufacture (stored in original cartons, 70°F [21 °C]/50%RH)
Temperature Resistance:	
Short Term: (minutes, hours)	200°F (93°C)
Long Term: (days, weeks)	158°F (70°C)

**Application Guidelines** For maximum bond strength, the surfaces should be thoroughly cleaned with a 50:50 mixture of isopropyl alcohol and water. Ideal tape application is accomplished when temperature is between 70° and 100°F (21° and 38°C) and the bond is allowed to dwell 72 hours. Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended. Consult manufacturer's directions for use and precautions when using cleaning solvents.

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**Important Notice**

The statements and technical information contained herein are based on tests and data which 3M believes to be reliable, but the accuracy or completeness of such statements and technical information is not guaranteed. User is responsible for determining whether a specific 3M™ VHB™ Tape is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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