



# Acrylic Foam Tape 4611

## Product Data Sheet

Date: May 2004

Supersedes: Date: 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

### Construction

<b>Adhesive Type</b>	Acrylic
<b>Foam Core</b>	Acrylic
<b>Thickness (ASTM D-3652) Tape</b>	1.1 mm $\pm$ 0.1mm
<b>Release Liner</b>	Red Filmic
<b>Tape Colour</b>	Dark Grey
<b>Foam Density</b>	840 kg/m <sup>3</sup>

### Performance Characteristics

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

<b>Additional Product Information</b>	<b>This product is suitable for plasticised PVC but is not suitable for low surface energy plastics.</b>
<b>Shelf Life</b>	3M VHB 4611F has a shelf life of 24 months from date of despatch by 3M when stored in the original carton at 21°C (70°F ) & 50 % Relative Humidity
<b>Application Techniques</b>	<p>1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact &amp; thus improves bond strength.</p> <p>2. To obtain optimum adhesion, the bonding surfaces must be clean dry and well unified. A typical surface cleaning solvent is isopropyl alcohol &amp; water. Use proper safety precautions for handling solvents.</p> <p>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.</p>
<b>Applications</b>	<p>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.</p> <p>Typical applications include:</p> <ul style="list-style-type: none"> <li>- Bonding roof bows on trucks and buses.</li> <li>- Bonding glazing (muntin) bars or muntin bars positioned internally.</li> <li>- Signage applications.</li> </ul>
<b>For Additional Information</b>	<p>To request additional product information or to arrange for sales assistance, call: 08-92 22 50</p> <p>Address correspondence to: 3M Svenska AB, Industri, 191 89 Sollentuna</p>
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