

3M Automotive and Aerospace Solution Division

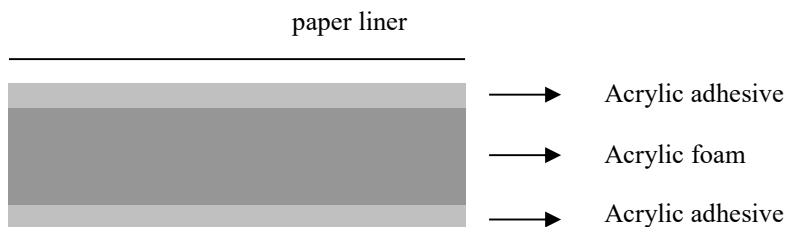
Technical Data Sheet

Acrylic Foam Tape #5069G

General Information

- Developed for adhesion on auto-clear paint.
- Effective stress distribution and relaxation caused from various driving condition.
- Relatively longer durability when exposed to various automotive chemical, such as, plasticizer, fuel and so on.
- Typical application: Exterior molding, ornament, and professional market items.
 - : Side visor, Bumper guard, Hand free kit

Structure



Physical Properties

Foam	Gray acrylic foam
Thickness (without liner)	1.2 mm
Density	0.66g/cm ³
Liner	Red printed PE liner
Liner thickness	0.14 mm

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Adhesion Test Result

Aging Condition			#5069
180 degree peel (kgf/25mmW)	Initial	20 min at R.T.	1.2
	Normal	1 day at R.T.	1.5
	Heat aging	3 days at 80°C	6.7
Dynamic Shear (kgf/sqcm)	Initial	20 min at R.T.	4.0
	Normal	1 day at R.T.	5.8
	Heat aging	3 days at 80°C	8.6

Test method and condition

Substrate: 180 degree peel: Auto clear paint
 Dynamic shear: SUS panel
Test speed: 180 degree peel: 200mm/min
 Dynamic Shear: 50mm/min

Application Guide

- Cleaning surface: wiping out dust and oil
- Positioning carefully for perfect wet-out: whole tape area contact to substrate (pre-heat is recommended at winter season)
- Pressurize enough. The more rounded substrate, the higher force is needed. 5kg_f (full press by adult thumb) on each 1cm wide tape is common.

Notice

- All statements, technical information and recommendations herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed and the following is made in lieu of all warranties, expressed or implied, including the implied warranties of merchantability and fitness for purpose.