



# Double Coated Foam Tapes

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Technical Data

July 2002

## Adhesive Description

3M™ #4614 tapes are consisted of high performance acrylic adhesives, which have excellent long-term holding power. The peel adhesion and tensile holding power of these tapes are significantly higher than corresponding urethane or other similar type of foam tapes.

## Product Description

#4614 tapes are ideal for use in many interior and exterior industrial applications. The increased holding power provides better long term bonding than most other urethane or similar foam tapes. #4614 tapes may be used to bond a variety of substrates, including most metals, sealed wood, as well as some plastics and painted surfaces.

Note: All tapes should be thoroughly evaluated by the user under actual conditions with intended substrates to determine whether a specific tape is fit for a particular purpose and suitable for user's method of application, especially if expected use involves extreme environmental conditions.

## Typical Physical Properties

Product		4614-8	4614-10(P)	4614G-8	4614G-10
<b>Thickness:</b>					
Nominal	(mm)	0.8	1.0	0.8	1.0
Tolerance		+/- 15%	+/- 15%	+/- 15%	+/- 15%
<b>Color</b>		White	White	Grey	Grey
<b>Release Liner:</b>	(mm)	0.13	0.13	0.13	0.13
		Film Liner	Film Liner (Paper Liner)	Film Liner	Film Liner
<b>Approximate Density:</b>					
	(g/cm <sup>3</sup> )	700	700	700	700
<b>Roll Length:</b>					
Standard	(m)	30	30	30	30
<b>Roll Width:</b>					
Minimum	(mm)	6.4	6.4	6.4	6.4
Maximum	(mm)	580	580	580	580
<b>Slitting Tolerance</b>					
	(mm)	+/- 0.8	+/- 0.8	+/- 0.8	+/- 0.8

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## Typical Performance Characteristics

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

Products	4614-8	4614-10(P)	4614G-8	4614G-10
<b>90° Peel Adhesion:</b>				
To Stainless Steel (kg/12.7mm)	2.3	2.3	2.5	2.7
Room Temperature				
Jaw Speed 305mm/min				
ASTM D-3330				
<b>Normal Tensile:</b>				
(T-block) (kg/in. <sup>2</sup> )	18.0	18.0	19.0	19.0
To Aluminum				
Room Temperature				
Jaw Speed: 12.7mm/min				
ASTM D-897				
<b>Static Shear:</b>				
To Stainless Steel (min)				
1in. <sup>2</sup> (6.45cm <sup>2</sup> ) overlap				
1,000grams loading at 23°C	>10,000	>10,000	>10,000	>10,000
500grams loading at 70°C	>10,000	>10,000	>10,000	>10,000
ASTM D-3654				
<b>Dynamic Shear:</b>				
To Stainless Steel (kg/in. <sup>2</sup> )	40	35	40	35
1in. <sup>2</sup> (6.45cm <sup>2</sup> ) overlap				
Room Temperature				
Jaw Speed: 12.7mm/min				
ASTM D-1002				
<b>Shelf Life:</b>	12months from date of manufacture when stored in original cartons at room temperature & 50% RH			

## Application Technique

- Bond strength is dependent upon the amount of adhesive to surface contact developed. Firm application pressure helps develop better adhesive contact and improve bond strength.
- To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Typical surface cleaning solvents are isopropyl alcohol and water (rubbing alcohol) or heptane. **Note:** Be sure to follow manufacturer's safety precautions and directions for use when using solvents.
- Ideal tape application temperature range is 70°F To 100°F (21°C to 38°C). Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

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## Application Ideas

- These products have been designed for general purpose mounting and joining applications where high internal strength is required and are ideal for many applications which involve high continuous shear loads.

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## For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 82-80-533-4114. Address correspondence to : 3M Engineered Adhesives Division, 3M Korea LTD, Daehan Invest Trust BLDG 22<sup>nd</sup> Floor, Yoido Dong, Yongdeungpogu, Seoul, Korea. Our fax number is 82-2-786-7429

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ISO 9002

This Engineered Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.



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