



VHB™ Acrylic Foam Tape 4613F

Product Data Sheet

Updated : May. 2004
Supersedes : Sept 2002

Product Description 4613F is a white double coated acrylic foam tape with a high tack acrylic adhesive. This tape has a plain red filmic liner.

Physical Properties
Not for specification purposes

Adhesive Type	Acrylic
Foam Core	Acrylic
Thickness (ASTM D-3652) Tape	1.1 mm ± 0.1mm
Release Liner	Red Filmic
Tape Colour	White
Foam Density	840 kg/m ³
Shelf Life	24 months from date of despatch by 3M when stored in the original carton at 20°C & 50 % Relative Humidity

Performance Characteristics
Not for specification purposes

Peel Adhesion to Stainless Steel 90° peel @ room temp, 72 hr dwell, jaw speed 300mm/min AFERA 4001 (modified)	32 N/10mm	
Static Shear Strength weight held for 100 hours to stainless steel with ½ sq in (3.23 sq cm) overlap	1000g @ 20°C 500g @ 70°C	
Temperature Performance Continuous	120 °C	
Intermittent	150 °C	

Date : May 2004
 VHB Acrylic Foam Tape
 4613F

Additional Product Information`	This product is suitable for plastic materials except low surface energy plastics.	On some plastics like plasticised PVC, practical tests are recommended.	
Application Techniques	<p>1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact & thus improves bond strength.</p> <p>2. To obtain optimum adhesion, the bonding</p>	<p>surfaces must be clean dry and well unified. A typical surface cleaning solvent is isopropyl alcohol & water. Use proper safety precautions for handling solvents.</p> <p>3. Ideal tape application temperature range is 21°C to 40° C.</p>	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.
Applications	<p>4613F 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"> - Bonding roof bows on trucks and buses. - Bonding PVC (muntin) bars or muntin bars positioned internally. - Signage applications. 	

3M and VHB are trademarks of the 3M Company

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. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



Tapes & Adhesives Group

3M United Kingdom PLC
 3M House, PO Box 1,
 Market Place,
 Bracknell, Berkshire,
 RG12 1JU

Product Information :
 Tel 0870 60 800 50
 Fax 0870 60 700 99

3M Ireland
 3M House, Adelphi Centre,
 Upper Georges Street,
 Dun Laoghaire, Co. Dublin,
 Ireland

© 3M United Kingdom PLC 2000

Customer Service :
 Tel (01) 280 3555
 Fax (01) 280 3509