



Automotive Technical Data Sheet

3M™ Acrylic Foam Tape

5608

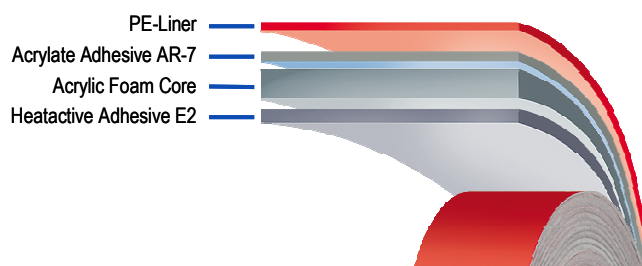
General Description

3M's 5608 Acrylic Foam Tape is a high performance tape made of grey acrylic foam. The tape is especially qualified for attaching elastomeric parts such as seals to car bodies and doors.

5608 is characterised by its high adhesion to a variety of automobile surfaces. One side of the tape is attached to the painted surface or the respective substrate by a pressure sensitive adhesive. The other side is bonded to the elastomeric part through heat-activation.

The heat-activated adhesive guarantees a durable bond, especially to seals made of EPDM and TPE Rubber. A good inner strength, brilliant long-term stability as well as very good conformability to the bonded surfaces are characteristic attributes of 5608.

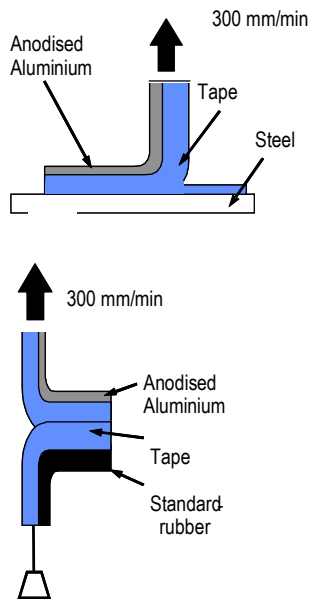
Construction



General Properties		
Core	Visco-elastic Acrylic Foam, density (650 kg/m ³)	
Colour	Grey	
Product Thickness	0.8 mm + / - 0.1 mm	
Width tolerance	+ / - 0.4mm	
Liner	H – orange polyethylene foil	
Adhesive to rubber (non-liner side)	E2 heat-activatable adhesive for EPDM and TPE	
Adhesive to paint (liner side)	AR-7 acrylate adhesive with high initial tack and high ultimate bond strength	
Mass per unit area (approx.)	Type	5608 F
	Tape	0.55 kg/m ²
	Liner	0.10 kg/m ²
Shelf life	Following shelf life when stored in unopened original cartons at +4°C to +38°C and 0 - 95 % relative humidity is considered from date of delivery: - Products with non -siliconized polyethylene liner 24 months - Products with siliconized polyethylene liner 12 months Level wound rolls must be stored under lay flat conditions.	
Heat resistance	- 40°C to + 90°C, short term 120°C (both values are load-dependent)	
Splices	Number of splices depends on order quantity and roll-length. Level wound rolls have 3 to 4 splices in average. Smaller order quantities (smaller than one jumbo) rolls could contain up to 14 splices.	
IMDS No.	http://www.mdssystem.de	

Performance Properties (Typical Values)

Performance tests are run using standard test procedures. The values presented are typical values not to be used for specification purposes.



Test	Result
90 ° peel adhesion with AR-7 adhesive on polished steel 3M TMG 1637 - on polished steel - after 20 minutes at RT - after 72 hours at RT - on 2c clearcoat - after 20 minutes at RT - after 72 hours at RT - after gasoline resistance test - after 10 cycles and 4 hours conditioning at RT (10 cycles of 4 hours. -40°C, 4 hours. +90°C, 16 hours. 38°C, 98% relative humidity)	27 N/cm 31 N/cm 25 N/cm 30 N/cm 17 N/cm 29 N/cm
T-Peel with E2 heat active side on standard rubber 3M TMG 1636 - on standard rubber - after 24 hours at RT - after 21 days at 70°C	18 N/cm 19 N/cm

Characteristics of Acrylic Foam Tape

Based on the unique visco-elastic consistence of the acrylic foam tape, a high cohesiveness combined with a brilliant shock- and weathering resistance is achieved.

Generally the adhesion increases with time, resulting in a durable, high performance bond between the part and the substrate. To optimize bond strength, the surfaces must be clean, dry and smooth with good fit between part and substrate. Decisive for good adhesion performance is full surface contact between tape and substrate.

Contact is achieved by pressurization. In practice a pressure between 10 - 50 N/cm² is usually needed and an application temperature between 18 - 40 °C is also necessary.

Additional Information

This data sheet contains specific information about the product. General characteristics and application rules of acrylic foam tapes are available separately.

Important 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. Please ensure before using our product that it is suitable for your intended use. All questions of liability relating to this product are governed by the Terms of Sale subject, where applicable, to the prevailing law.

