



Acrylic *Plus* Tape Series PT1000

Technical Data Sheet

April 2009

Supersedes Technical Data Sheets for PT1100 and PT1500 Dated August 2003

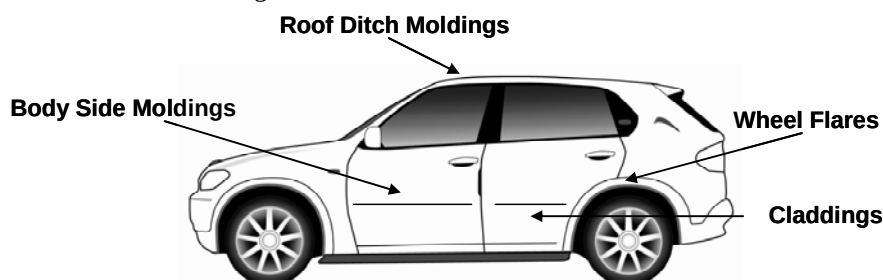
General Description 3M™ Acrylic *Plus* Tape Series PT1000 is a black, double-coated acrylic foam tape designed for the attachment of automotive exterior trim parts such as body side moldings and claddings.

3M Tape Series PT1000 offers the following key features:

- Superior adhesion performance to automotive paint surfaces, including the newest scratch- and mar-resistant formulations
- High conformability
- Black, high-strength core with low elongation properties
- Cold temperature impact resistance
- Easy liner release

The highly conformable core, which improves adhesive wet out, combines with high performance adhesive systems to provide excellent part adhesion to the most challenging surfaces. The black color and low elongation properties improve the bond-line appearance of the attached part.

Applications Some typical applications for 3M Tape Series PT1000 include body side moldings, claddings, roof ditch moldings and wheel flares.

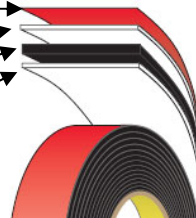


Shelf Life One year from date of receipt by customer when stored at 4° C - 30° C (40° F - 100° F) and 0 – 95% relative humidity. Optimum storage conditions are 22° C (72° F) and 50% relative humidity.

Product Construction

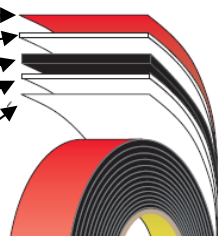
3M Acrylic *Plus* Tapes PT1100 and PT1500

GL-1 easy-release liner
VR-2 acrylic adhesive
Black acrylic foam
VR-1 acrylic adhesive



3M Acrylic *Plus* Tapes PT1100 T and PT1500 T

GL-3 easy-release liner
VR-2 acrylic adhesive
Black acrylic foam
VR-1 acrylic adhesive
Secondary liner



Technical Data Sheet

3M™ Acrylic Plus Tape Series PT1000

Page 2

Physical Properties

	PT1100	PT1500	PT1100 T	PT1500 T
Thickness	1.14 mm (0.045 in.)	1.52 mm (0.060 in.)	1.14 mm (0.045 in.)	1.52 mm (0.060 in.)
Range	+/- 0.13 mm (0.005 in.)	+/- 0.13 mm (0.005 in.)	+/- 0.13 mm (0.005 in.)	+/- 0.13 mm (0.005 in.)
Density	545 kg/m ³ (34 lb/ft ³)	521 kg/m ³ (32.5 lb/ft ³)	545 kg/m ³ (34 lb/ft ³)	521 kg/m ³ (32.5 lb/ft ³)
Range	+/- 80 kg/m ³ (5 lb/ft ³)	+/- 80 kg/m ³ (5 lb/ft ³)	+/- 80 kg/m ³ (5 lb/ft ³)	+/- 80 kg/m ³ (5 lb/ft ³)

Liner Options

GL-3 (T versions)

GL-1

Configuration

Red Polyethylene

1-side silicone-coated with secondary liner

Red Polyethylene

2-side silicone-coated

Heat-Bond Tab Compatibility

Yes

(3M™ Tabbing Tape 5400)

No

Contact 3M technical service for options

Roll Width and Length

3M™ Acrylic Plus Tapes are available in the following standard widths. Millimeter widths are rounded to the nearest whole numbers and 1/8-inch increments starting with 1/4 inch.

Minimum widths:
4 mm Levelwound
5 mm Planetary
(Standard versions)
6 mm Planetary
(T versions)

Planetary

PT1100

Roll Width	Roll Width Tolerance	Roll Length (maximum)
< 8 mm (< 0.276 in)	+/- 0.40 mm (+/-0.015 in.)	66 meters (72 yards)
8 - 9 mm (0.276 - 0.375 in)	+/- 0.40 mm (+/-0.015 in.)	99 meters (108 yards)
10 - 18 mm (0.394 – 0.709 in)	+/- 0.40 mm (+/-0.015 in.)	132 meters (144 yards)
> 18 mm (> 0.709 in.)	+/- 0.80 mm (+/- 0.031 in.)	132 meters (144 yards)

PT1500

Roll Width	Roll Width Tolerance	Roll Length (maximum)
< 10 mm (< 0.315 in)	+/- 0.40 mm (+/-0.015 in.)	66 meters (72 yards)
> 10 mm (0.394)	+/- 0.40 mm (+/-0.015 in.)	99 meters (108 yards)

PT1100 T

Roll Width	Roll Width Tolerance	Roll Length (maximum)
< 8 mm (< 0.276 in)	+/- 0.40 mm (+/-0.015 in.)	66 meters (72 yards)
8 - 9 mm (0.276 - 0.375 in)	+/- 0.40 mm (+/-0.015 in.)	99 meters (108 yards)
10 - 18 mm (0.394 – 0.709 in)	+/- 0.40 mm (+/-0.015 in.)	132 meters (144 yards)
> 18 mm (> 0.709 in.)	+/- 0.80 mm (+/- 0.031 in.)	132 meters (144 yards)

PT1500 T

Roll Width	Roll Width Tolerance	Roll Length (maximum)
< 10 mm (< 0.315 in)	+/- 0.40 mm (+/-0.015 in.)	66 meters (72 yards)
> 10 mm (0.394)	+/- 0.40 mm (+/-0.015 in.)	99 meters (108 yards)

Levelwound

PT1100 – PT1100T

Roll Width	Roll Width Tolerance	Roll Length (maximum)
4 - 14 mm (0.157 – 0.551 in)	+/- 0.40 mm (+/-0.015 in.)	900 meters (984 yards)
15 - 16 mm (0.591 – 0.630 in)	+/- 0.40 mm (+/-0.015 in.)	700 meters (765 yards)

PT1500 – PT1500 T

Roll Width	Roll Width Tolerance	Roll Length (maximum)
4 – 16 mm (0.157 – 0.630 in)	+/- 0.40 mm (+/-0.015 in.)	500 meters (545 yards)

Technical Data Sheet

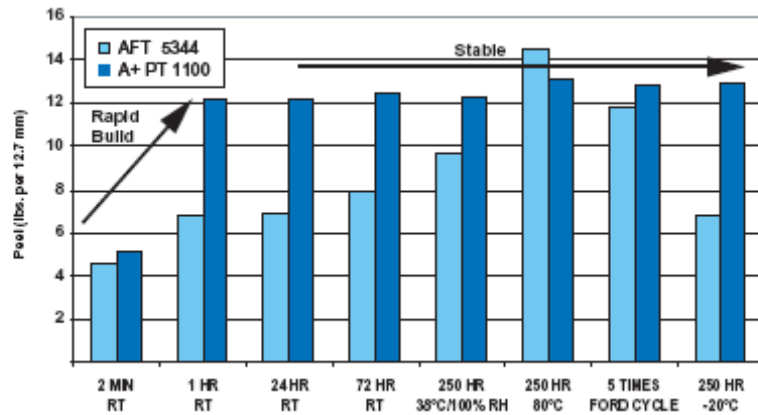
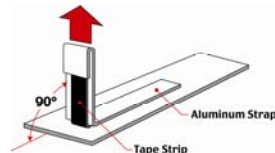
3M™ Acrylic Plus Tape Series PT1000

Page 3

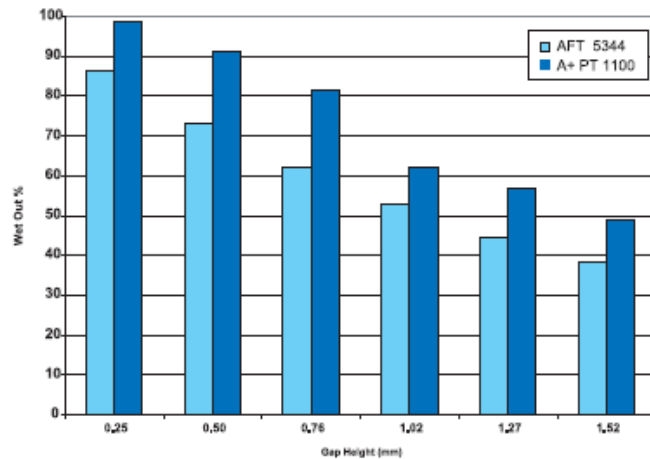
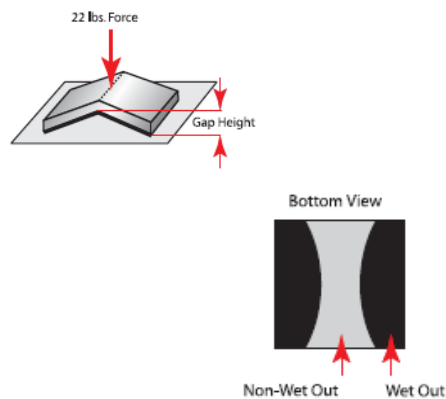
Performance Properties

Typical performance of 3M™ Acrylic Plus Tape Series PT1000 is shown below. Peel values depend on paint composition. These values are for reference only.

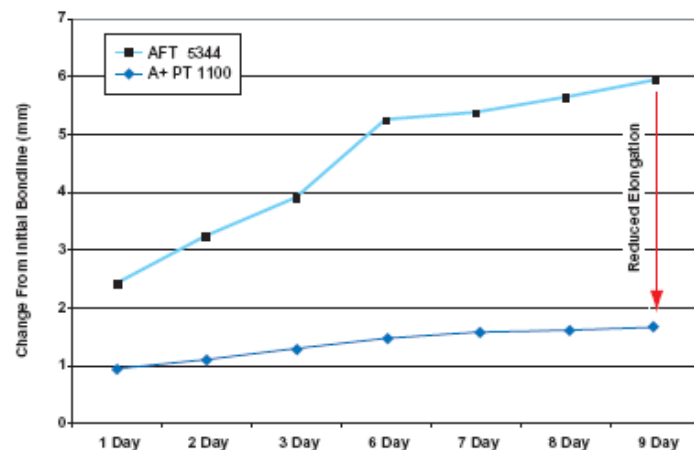
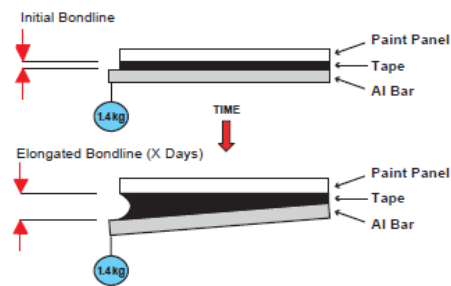
90° Peel Adhesion Testing



High Conformability (Angled Gap)



Low Elongation Core (Static Break Away)



Technical Data Sheet

3M™ Acrylic Plus Tape Series PT1000

Page 4

Contact Information	The information provided in this technical document is intended as a guide for this product. For more information or help in selecting a 3M product for an application, please contact 3M HELPS at 1-888-3M HELPS (1-888-364-3577).
----------------------------	---

Regulatory	IMDS# 2271874. This is a published material entry on www.mdssystem.com .
-------------------	---

3M is a Trademark of 3M Company.

Technical Information: The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

Warranty, Limited Remedy, and Disclaimer: Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.



Automotive Division

3M Center, Building 223-1S-02
St. Paul, MN 55144-1000
www.3M.com/autosolutions

© 3M 2009
75-3470-8713-4
Printed in U.S.A.



ISO/TS 16949:2002
File No. A2109