



PT1500

3M™ Acrylic Plus Tape

Technical Data Sheet

November 2008

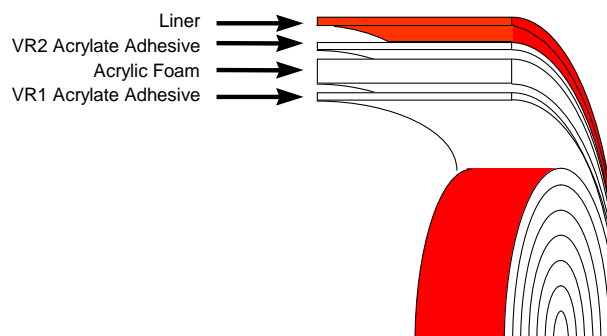
Description

PT1500 is a 3M™ Acrylic Plus Tape of low density, black foamed acrylic adhesive with additional acrylate adhesive on both sides.

Typical applications are attachments of rigid add-on-parts such as spoiler, rocker panel, antenna housings, roof ditch moldings and wheel arch extensions etc., where an aesthetic bond line is required.

PT1500 possesses a very good adhesion to many automotive surfaces, good inner strength, excellent long term stability as well as a very good adaptability to the areas adhered to. Thru the unique visco-elastic property of the PT1500, stress is decreased in the adhesive bond line so that durable bondings are formed.

Construction

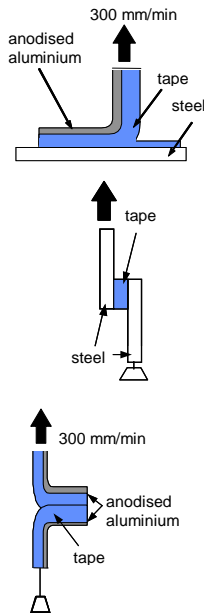


General Properties

Core	Visco-elastic Acrylic Plus Foam, low density (550 kg/m ³)
Colour	black
Thickness (without liner)	1.5 mm ± 0.1 mm
Adhesive to paint (liner side)	VR2 acrylate adhesive with very high initial and final tack to paints
Adhesive to add-on-part (non-liner side)	VR1 acrylate adhesive with very high initial and final tack
Liner	F - Red polyethylene foil T - Version with one side siliconized red polyethylene foil, good for tabbing tape bonding and an additional, one side siliconized transparent polyethylene liner, which has to be removed before application. This liner is available for diecuts, level wound rolls and planetary rolls from 100 mm width upwards.
Shelf Life	Up to 12 months from date of delivery when stored in unopened original cartons at +4°C to +38°C and 0 - 95 % relative humidity

PT1500 3M™ Acrylic Foam Tape

Performance Properties (Typical Values)



Test	Result	
90° peel adhesion on polished steel 3M TM 1637 20 minutes at RT 72 hours at RT	VR1 side: 44 N/cm 44 N/cm	VR2 side: 44 N/cm 44 N/cm
90° peel adhesion on 1K clearcoat 3M TM 1637 20 minutes at RT 72 hours at RT	VR1 side: 44 N/cm 44 N/cm	VR2 side: 44 N/cm 44 N/cm
Static Shear Adhesion 3M TM 1266-B The static shear test is carried out with an bonded area of 25.4 mm by 12.7 mm wide tape. 6.8 kg roll-down against polished steel	Exceeds more than 10,000 minutes at 90°C Weight: 500 gr	
Alu T-Peel 3M TM 1636	28 N/cm	

Characteristics of the Acrylic Foam Tape

The Acrylic Foam Tape is manufactured using a special process of producing a homogeneous system of high performance acrylic adhesive. The product can be used for numerous applications both on the exterior and interior of vehicles. The unique visco-elastic nature of acrylic foam gives it a high cohesive strength combined with excellent shock and weathering resistance. To get an optimised bond, the surfaces must be clean, dry and possibly flat, and show a good fit. Decisive for the raise of adhesion force is the overall contact about the whole area to be bonded. The contact is being forced by the pressure. For practically bonding there is a pressure between 10 to 50 N/cm² required, while h having a temperature of 18°C or higher.

If you bond to substrates which contain plasticizer, like EPDM, PVC, please check plasticizer-resistance of each individual application to ensure that the tape is suitable for this application.

Additional Information

This data sheet contains specific information about the product. General characteristics and application rules of acrylic plus 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.



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