



VHB™ Acrylic Foam Tape 4991

Product Data Sheet

Updated : Sept. 2002
Supersedes : February 2001

Product Description

3M™ VHB™ Acrylic Foam Tape 4991 is a double coated 0.090 in. (2.3 mm) pressure sensitive adhesive tape for bonding many painted metals, as well as unpainted metals, and higher surface energy plastics. 3B VHB Acrylic Foam Tape 4991 is appropriate for applications which demand a thicker conformable products.

Physical Properties

Not for specification purposes

Adhesive Type	Plasticiser Resistant
Thickness (ASTM D-3652)	2.3 mm
Foam Density	720 kg/m ³
Adhesive Carrier	Acrylic Foam (Closed Cell)
Liner	Red Polyethylene Film
Tape Colour	Grey
Shelf Life	24 months from date of manufacture when stored in the original carton at 20°C & 50 % Relative Humidity

Performance

Characteristics

Not for specification purposes

Peel Adhesion to Stainless Steel	35 N/10mm
Static Shear Strength (Stainless Steel)	1000 g @ 22°C 500 g @ 66°C 500 g @ 93°C
Temperature Performance Max (minutes/hours) Max Continuous (days/weeks)	120 °C 90 °C
Normal Tensile (Aluminium T-Block)	415 kPa
Solvent Resistance	High

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Additional Product Information

For maximum bond strength the surfaces should be thoroughly cleaned with a 50:50 mixture of isopropyl alcohol and water. Consult manufacturers directions for use and precautions when using cleaning solvents. Ideal tape application is accomplished when temperature is between 20°C and 40°C and the bond is allowed to dwell 72 hours. Initial tape application to surfaces at temperatures below 10°C is not recommended.

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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**

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