



# VHB™ Acrylic Foam Tape 4655F

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## Product Data Sheet

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Updated : May. 2004  
Supersedes : Sept 2002

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### Product Description

4655F is a dark grey double coated acrylic foam tape with a high tack acrylic adhesive. This tape has a plain red filmic liner.

The excellent temperature performance enables bonding of materials prior to processing in a powder coating line

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### Physical Properties

Not for specification purposes

<b>Adhesive Type</b>	Acrylic
<b>Foam Core</b>	Acrylic
<b>Thickness (ASTM D-3652) Tape</b>	1.5 mm ± 0.15mm
<b>Release Liner</b>	Red Filmic
<b>Tape Colour</b>	Dark Grey
<b>Foam Density</b>	840 kg/m <sup>3</sup>
<b>Shelf Life</b>	24 months from date of despatch by 3M when stored in the original carton at 20°C & 50 % Relative Humidity

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### Performance

#### Characteristics

Not for specification purposes

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

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### Additional Product Information

This product is suitable for plasticised PVC but is not suitable for low surface energy plastics.

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### Application Techniques

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.

2. To obtain optimum adhesion, the bonding

surfaces must be clean dry and well unified. A typical surface cleaning solvent is isopropyl alcohol & water. Use proper safety precautions for handling solvents.

3. Ideal tape application temperature range is 21°C to 40° C.

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.

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### Applications

4655F 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.

Typical applications include:

- Bonding roof bows on trucks and buses.
- Bonding lower weight glazing (muntin) bars or muntin bars positioned internally.
- Signage applications.

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### Tapes & Adhesives Group

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