



Double Coated Foam Tapes

Technical Data

Temporary

Adhesive Description

3M™ #4614 tapes are consisted of high performance acrylic adhesives, which have excellent long-term holding power. The peel adhesion and tensile holding power of these tapes are significantly higher than corresponding urethane or other similar type of foam tapes.

Product Description

#4614 tapes are ideal for use in many interior and exterior industrial applications. The increased holding power provides better long term bonding than most other urethane or similar foam tapes. #4614 tapes may be used to bond a variety of substrates, including most metals, sealed wood, as well as some plastics and painted surfaces.

Note: All tapes should be thoroughly evaluated by the user under actual conditions with intended substrates to determine whether a specific tape is fit for a particular purpose and suitable for user’s method of application, especially if expected use involves extreme environmental conditions.

Typical Physical Properties

Product		4614-8	4614-10(P)	4614G-8	4614G-10	
Thickness:						
Nominal	(mm)	0.8	1.0	0.8	1.0	
Tolerance		+/- 15%	+/- 15%	+/- 15%	+/- 15%	
Color		White	White	Grey	Grey	
Release	Liner:	0.13	0.13	0.13	0.13	
(mm)		Film Liner	Film Liner	Film Liner	Film Liner	
(Paper Liner)						
Approximate Density:						
		(g/cm ³)	700	700	700	700
Roll Length:						
Standard	(m)	30	30	30	30	
Roll Width:						
Minimum	(mm)	6.4	6.4	6.4	6.4	
Maximum	(mm)	580	580	580	580	
Slitting Tolerance						
		(mm)	+/- 0.8	+/- 0.8	+/- 0.8	+/- 0.8

Typical Performance Characteristics

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Products	4614-8	4614-10(P)	4614G-8	4614G-10
90° Peel Adhesion:				
To Stainless Steel (kg/12.7mm)	2.3	2.3	2.5	2.7
Room Temperature				
Jaw Speed 305mm/min				
ASTM D-3330				
Normal Tensile:				
(T-block) (kg/in. ²)	18.0	18.0	19.0	19.0
To Aluminum				
Room Temperature				
Jaw Speed: 12.7mm/min				
ASTM D-897				
Static Shear:				
To Stainless Steel (min)				
1in. ² (6.45cm ²) overlap				
1,000grams loading at 23°C	>10,000	>10,000	>10,000	>10,000
500grams loading at 70°C	>10,000	>10,000	>10,000	>10,000
ASTM D-3654				
Dynamic Shear:				
To Stainless Steel (kg/in. ²)	40	35	40	35
1in. ² (6.45cm ²) overlap				
Room Temperature				
Jaw Speed: 12.7mm/min				
ASTM D-1002				
Shelf Life:	12months from date of manufacture when stored in original cartons at room temperature & 50% RH			

Application Technique

- Bond strength is dependent upon the amount of adhesive to surface contact developed. Firm application pressure helps develop better adhesive contact and improve bond strength.
- To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Typical surface cleaning solvents are isopropyl alcohol and water (rubbing alcohol) or heptane. **Note:** Be sure to follow manufacturer’s safety precautions and directions for use when using solvents.
- Ideal tape application temperature range is 70°F To 100°F (21°C to 38°C). Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

Application Ideas

- These products have been designed for general purpose mounting and joining applications where high internal strength is required and are ideal for many applications which involve high continuous shear loads.
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For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 82-80-533-4114. Address correspondence to : 3M Engineered Adhesives Division, 3M Korea LTD, Daehan Invest Trust BLDG 22nd Floor, Yoido Dong, Yongdeungpogu, Seoul, Korea. Our fax number is 82-2-786-7429

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This Engineered Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.



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