



Double Coated Elastomeric Tape

4921

Technical Data

August, 1994

Supersedes August, 1989

Product Description **4921** 1/64 in. (0.4 mm) double coated elastomeric foam tape.

Construction

Product	4921 Tape
Adhesive Type:	A-20*
Adhesive Carrier:	Elastomeric Foam
Thickness: Nominal	1/64 in., 0.016 in. (0.4 mm)
Tolerance	0.010-0.022 in. (0.25-0.56 mm)
Color:	Natural
Release Liner:	0.003 in. (0.08 mm) Green Plaid Paper
Approximate Density: (Foam Only)	32 lb./ft. ³ (510 kg/m ³)

*A-20 is a firm acrylic pressure sensitive adhesive system. It features high ultimate bond strength, very good high temperature and solvent resistance, and very high shear holding power. Bond strength increases substantially with natural aging.

Typical Physical Properties and Performance Characteristics

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

Normal Tensile: ("T" Block) 1 in. ² (6.45 cm ²) Jaw Speed 2 in/min (50 mm/min)		95 psi (655 kPa)
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Static Shear:  (Measured at various temperature & gram loadings. (1/2 sq. in. overlap). Will hold listed weight for 100 hrs.)	72°F (22°C) 120°F (49°C) 150°F (66°C)	1000 1000 500
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Tensile Strength:	600 psi (4135 kPa)
Elongation:	800+%
Temperature Resistance:	
Short Term (Minutes, Hours)	200°F (93°C)
Long Term (Days, Weeks)	150°F (66°C)
Solvent Resistance:	No apparent degradation when exposed to splash testing of most hydrocarbon solvents
UV Resistance:	Not recommended for direct exposure to sunlight or other sources of U.V. light.
Cold Flex at -20°F (-30°C):	No cracking when flexed around a 1/4 in. (6.4 mm) mandrel
Thermal Conductivity:	0.062 BTU Ft./Ft. ² Hr. °F (0.107 W/m•K)
Dielectric Strength:	400-500 volts/mil (400-500 volts/0.025 mm)
Shelf Life:	18 months from date of manufacture when stored in original cartons at 70°F (21°C) and 50% relative humidity.

Double Coated Elastomeric Tapes

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Available Sizes	Product	4921 Tape
	Roll Length (Subject to Minimum Order Requirements):	
	Standard	72 yds. (65.8 m)
	Maximum	175 yds. (160 m)
	Roll Width (Subject to Minimum Order Requirements):	
	Minimum	1/4 in., 0.250 in. (6.4 mm)
	Maximum	38 in. (965 mm)
	Slitting Tolerance:	$\pm 1/32$ in., ± 0.031 in. (± 0.8 mm)

- Application Techniques**
- 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 4921 tape is designed with a thin glue line which make it ideal in many applications for holding wood, plastic or metal trim or attachment of nameplates, particularly if vibration resistance may be required.

For Additional Information To request additional product information or to arrange for sales assistance, call toll free 1-800-227-5085. Address correspondence to: 3M Industrial Tape and Specialties Division, 3M Center, Building 220-8E-04, St. Paul, MN 55144-1000. Our fax number is 612-733-9175. In Canada, phone: 1-519-451-2500. In Puerto Rico, phone: 1-809-750-3000. In Mexico, phone: 5-728-0400.

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ISO 9002

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