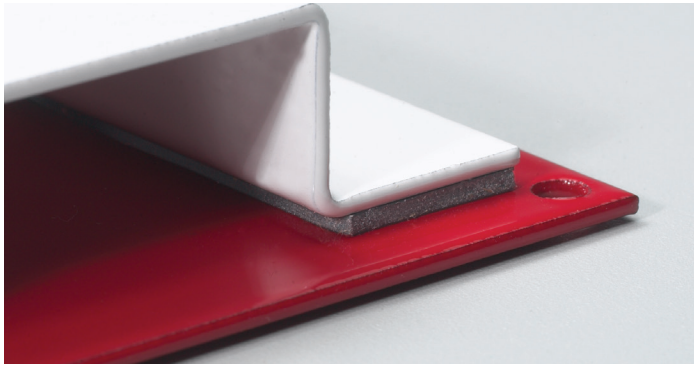


Post-Powder Coat Bonding Solutions

3M™ VHB™ Tape 5952

- ▶ Provides a strong bond on powder coated surfaces and difficult-to-stick surfaces
- ▶ Eliminates drilling, grinding, refinishing, screwing, welding, and clean-up
- ▶ Pressure sensitive adhesive bonds on contact to provide immediate handling strength



3M™ Scotch-Weld™ Structural Acrylic Adhesives DP8805NS and DP8810NS

- ▶ Over three times the impact strength of conventional acrylic adhesives
- ▶ Fast curing with an 18-month shelf life
- ▶ Low odor

3M™ Scotch-Weld™ Urethane Adhesives DP6310NS and DP6330NS

- ▶ High performing two component polyurethane
- ▶ Easy mixing, exceptional non-sag formulation
- ▶ Suitable for bonding to a wide variety of substrates, including painted surfaces



Why choose a tape or adhesive?

Benefits of tape and adhesive bonding solutions

- ✓ Improves aesthetics
- ✓ Weight reduction
- ✓ Quick and easy application

Benefits of a tape solution

- ✓ Very strong bond that can replace spot welds and rivets
- ✓ Provides instant handling
- ✓ Ideal for dynamic loads

Benefits of an adhesive solution

- ✓ Ideal for weld-replacing static loads
- ✓ High strength allows use of smaller bond areas
- ✓ Quick cure time
- ✓ Repositionable



3M Product		Product Description and Features
Powder Coat Masking	3M™ Polyester Tape 8991†	<ul style="list-style-type: none"> ▶ 1.0 mil polyester backing ▶ 1.4 mil silicone adhesive
	3M™ Polyester Tape 8992†	<ul style="list-style-type: none"> ▶ 2.0 mil polyester backing ▶ 1.2 mil silicone adhesive
	3M™ Polyimide Tape 8997†	<ul style="list-style-type: none"> ▶ 1.0 mil polyimide backing ▶ 1.4 mil silicone adhesive
	3M™ Polyimide Tape 8998†	<ul style="list-style-type: none"> ▶ 2.0 mil polyimide backing ▶ 1.2 mil silicone adhesive
†Also available in lined and log roll format		
Pre-Powder Coat Bonding	3M™ VHB™ Tape GPH	<ul style="list-style-type: none"> ▶ High temperature resistance (150°C continuous, 230°C intermittent)
	3M™ Scotch-Weld™ Structural Acrylic Adhesive DP8407NS	<ul style="list-style-type: none"> ▶ High strength, high peel ▶ Bondline control 250µm ▶ Non-sag ▶ 6 minute work life* ▶ Time to handling strength 24 minutes* ▶ Heat and humidity resistant ▶ Maintains >75% of initial strength after 1 hour at 400° F/204°C
Post-Powder Coat Bonding	3M™ VHB™ Tape 5952	<ul style="list-style-type: none"> ▶ Adheres to painted and difficult-to-bond surfaces, usually without the need for special surface preparation, priming or abrading
	3M™ Scotch-Weld™ Structural Acrylic Adhesives DP8805NS/DP8810NS	<ul style="list-style-type: none"> ▶ Fast curing ▶ Bondline control 250µm ▶ High impact strength ▶ Non-sag ▶ 5 minute work life*/10 minute work life* ▶ Time to handling strength 7 minutes*/18 minutes* ▶ 20 minute structural strength* ▶ Low odor
	3M™ Scotch-Weld™ Urethane Adhesives DP6310NS/DP6330NS	<ul style="list-style-type: none"> ▶ High performing ▶ Best gap filling ▶ Low temperature flexibility

*All times quoted are approximate

Product Selection and Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

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Industrial Adhesives & Tapes Division

3M Center
 Building 225-3S-06
 St. Paul, MN 55144-1000
 1-800-362-3550
www.3M.com/structuraladhesives
www.3m.com/vhb
www.3m.com/iatd

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