



# VHB™ Tapes

## Design Guide

*Improve process, improve products*



*Permanently bonding and sealing worldwide for 25 years*



# 3M™ VHB™ Tapes...saving time. enhancing appearance, and assembling with

For 25 years, industries worldwide have been using 3M™ VHB™ Tapes to permanently bond and seal many substrates for increased productivity, high strength, long term durability, and improved appearance.



Shaffner Building, 1986 2



Sony Sports Cam, 1989 3



Westinghouse Sign, 1986 4



Singapore Treasury, 1984 5



Computer Security Device, 1983 6



University of Michigan Solar Car, 1990 7

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3M™ VHB™ Tapes Product Information

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	Product Number	Tape Thickness w/o liner Mils (mm)	Description	Adhesive Type	Temperature Resistance		Solvent Resistance	Relative Adhesion		Application Ideas	Liner Type
					Minutes Hours	Days Weeks		HSE	LSE		
3M™ VHB™ Conformable Tape	4926	15 (0.4)	Gray, closed-cell acrylic foam carrier. Conformable. Good adhesion to many painted metals. Plasticizer resistant. UL 746C.	Acrylic	300°F (149°C)	200°F (93°C)	High	High	Med.	Bond muntin bars to windows. Bond and seal polycarbonate lens over LCD. Bond pre-painted metals in truck assembly. Bond and seal plastic windows to pre-painted control panels/switch gear. Mount vinyl wiring ducts and conduit channels.	A
	4936	25 (0.64)									B
	4936F	25 (0.64)									A
	4941	45 (1.1)									D
	4941F	45 (1.1)									A
	4956	62 (1.6)									B
	4956F	62 (1.6)									D
	4919F	25 (0.64)									D
	4947F	45 (1.1)									B
	4979F	62 (1.6)									D
4991	90 (2.3)	D									
3M™ VHB™	5925	25 (0.64)	Dark gray, closed-cell acrylic foam carrier. Conformable. Good adhesion to many painted surfaces, including powder coated paint. UL 746C.	Modified Acrylic	300°F (149°C)	200°F (93°C)	High	High	Med	Bonds to a variety of plastics and paint systems.	D
	5952	45 (1.1)									D
	5962	62 (1.6)									D
3M™ VHB™	4943F	45 (1.1)	Gray conformable foam. Apply as low as 32°F (0°C).	Acrylic	300°F (149°C)	200°F (93°C)	High	High	Low	Bond cellular phone antennas. Bond automatic toll tags to vehicle.	C
	4957F	62 (1.6)									C
3M™ VHB™ Tape	4611	45 (1.1)	Dark gray, closed-cell acrylic foam carrier. High temperature resistance. UL 746C.	Acrylic	450°F (232°C)	300°F (149°C)	High	High	Low	Pre-powder coat paint applications: hat channels and stiffeners.	D
	4646	25 (0.64)									D
	4655	62 (1.6)									D
	4920	15 (0.4)	White, closed-cell acrylic foam carrier. All-purpose adhesive. UL 746C.	Acrylic	300°F (149°C)	200°F (93°C)	High	High	Low	Attach stiffeners in air conditioners, office furniture and telecommunications equipment. Bond aluminum skin to steel support of trucks, vans, ambulances. Bond architectural signs to frames.	A
	4930	25 (0.64)									A
	4950	45 (1.1)									A
	4955	80 (2.0)			400°F (204°C)	300°F (149°C)					C
	4959	120 (3.0)									C
	4945	45 (1.1)	White, closed-cell acrylic foam carrier. Plasticizer resistant. UL 746C. Film liner version of 4945.	Acrylic	300°F (149°C)	200°F (93°C)	High	High	Med.	Attach vinyl trim. Bond vinyl extrusions. Bond pre-painted truck and trailer skins.	A
	4946	45 (1.1)									B
4905	20 (0.5)	Clear, acrylic construction for joining transparent material.	Acrylic	300°F (149°C)	200°F (93°C)	High	High	Low	Seal skylight inner/outer dome. Mount back lit translucent signs. Edge-bond resin filled glass.	D	
4910	40 (1.0)									D	
4951	45 (1.1)	White, closed-cell acrylic foam carrier. Apply as low as 32°F (0°C).	Acrylic	300°F (149°C)	200°F (93°C)	High	High	Low	Mount panels to aluminum frames in buildings, trucks, and trailers. Mount trim to portable buildings.	C	
4932	25 (0.64)	White, closed-cell acrylic foam carrier. Good adhesion to polypropylene and many powder paints.	LSE	200°F (93°C)	160°F (71°C)	High	High	High	Bond powder painted metal stiffeners to office desks and file cabinets. Bond polypropylene and polystyrene.	A	
4952	45 (1.1)									A	
Transfer Tape	F-9460 PC	2.0 (0.05)	Clear adhesive transfer tape. High shear strength adhesive. UL 746C.	100 MP	500°F (260°C)	300°F (149°C)	High	High	Low	Bond decorative metal trim. Bond flexible circuits to aluminum rigidizers or heat sinks.	E
	F-9469 PC	5.0 (0.13)									E
	F-9473 PC	10 (0.25)									E

**NOTE:** The technical information and data provided here should be considered representative or typical only and should not be used for specification purposes. User should evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for user's method of application.

**Liner Types:**

A – 3 mil 54# Densified Kraft Paper  
B – 5 mil Clear Polyethylene Film

C – 2 mil Polyester Film  
D – 5 mil Red Polyethylene Film

**Relative Adhesion:**

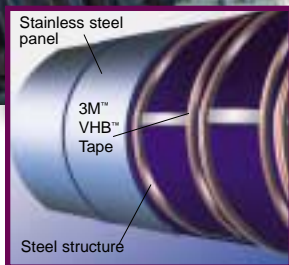
HSE – High Surface Energy  
LSE – Low Surface Energy

# STRENGTH

to replace spot welds, screws, rivets, and liquid adhesives

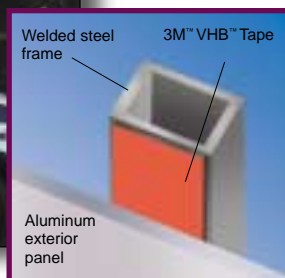
3M™ VHB™ Tapes all-acrylic construction provides strength and durability in highly demanding applications.

- Bond with high holding strength for static or dynamic stress
- Provide a continuous bond to distribute stress over the entire surface
- Viscoelastic properties absorb shock and flexing for reliability against wind, vibration, and other stresses
- Eliminate pull-through, dimpling and weld distortion
- Damp vibration

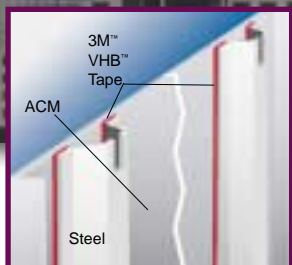


Aeroporto Fortaleza, Fortaleza, Brazil  
Architect: Claudio Silva, 1997  
Stainless steel panels bonded to steel frame.

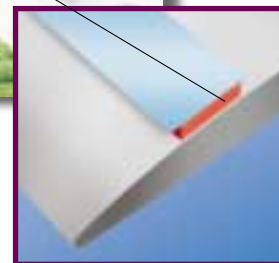
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11  
Damps vibration and noise producing a quieter ride.



Jumeirah Beach Hotel, Dubai, UAE  
Curtain wall design: Schmidlin AG, 1998  
Aluminum panels bonded to steel stiffeners.



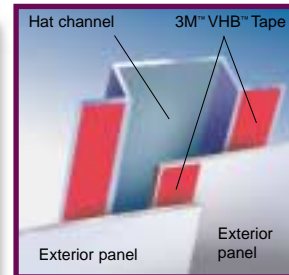
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Securely bonds stainless steel scuff strips to aluminum wing flaps despite extreme ground-to-air temperature swings of 150°F to -40°F (65°C to -40°C).

# DURABILITY

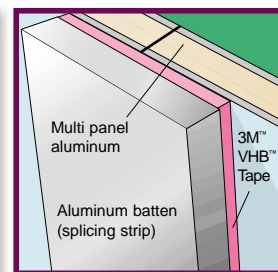
for long term performance indoors and out

- Resists all of the following:
  - High temperature
  - Cold
  - Temperature cycling
  - UV light
  - Moisture and solvents
- Seal against environmental conditions
- Prevent bi-metallic corrosion
- Damp vibration to prevent metal fatigue
- Compensate for differential of thermal expansion



Replace rivets in bonding truck side panels to steel frames for a much smoother, cleaner appearance and a strong bond. VHB tape can also reduce vibration in the box.

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Signs that resist cold winds in Denmark (installed 1985)

15

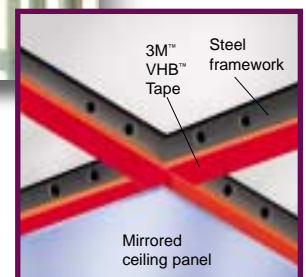


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O'Hare Airport,  
Chicago, IL, USA

Architect: Custom Products of  
Southgate, CA, 1987

Mirror-finish composite ceiling panels bonded  
to a suspension frame.





# PRODUCTIVITY through application ease and versatility

- Save money and time with increased efficiency
- PSA (pressure sensitive adhesive) bonds on contact with no bottlenecks for drying time or fixturing
- Fast, easy assembly
- Eliminate time consuming labor – drilling, grinding, refinishing, screwing, welding and clean-up
- Die cut to precisely fit any shape, size or profile
- Easy to use with minimal training



For assembly efficiency, die-cut pieces of 3M™ VHB™ Tape bond components in a water-resistant video camera case. The foam conforms to help seal the unit.

Easily cut to size, 3M™ VHB™ Tape 5952 bonds polycarbonate sheets to the back of a routed aluminum face. Surface is simply cleaned prior to application. Tape is pressed with a roller for optimum bonding.

# APPEARANCE

with aesthetic improvement you can see and feel

- Virtually invisible fastening helps keep surface smooth and clean to enhance design and appearance
- Expand the range of material options
  - Bond most painted and powder coated surfaces, and plastics such as acrylic, polycarbonate, and ABS
  - Bond metal and most plastics with minimal surface preparation
- Use lighter weight and thinner materials
- Use a wider variety of materials more readily for high impact visual combinations
- Prevent bi-metallic corrosion
- Join dissimilar materials
- Uniform thickness creates repeatable results without expensive equipment



Assembled with rivets.

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Assembled with 3M™ VHB™ Tape.

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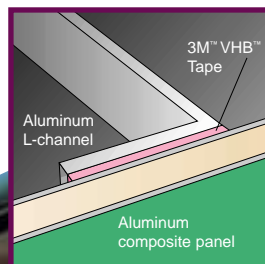
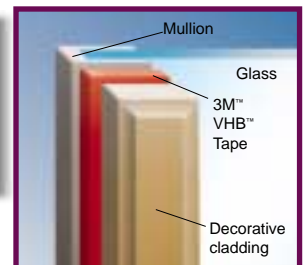


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Decorative copper cladding adheres to window system creating a unique appearance.



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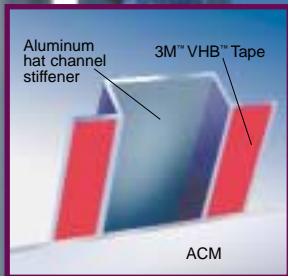


Gas station canopy, Sydney, Australia  
Fabricator: Albert Smith Signs, 1989

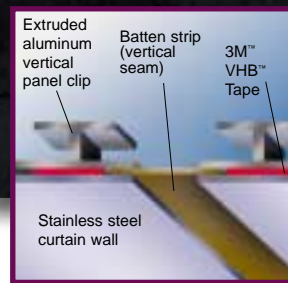
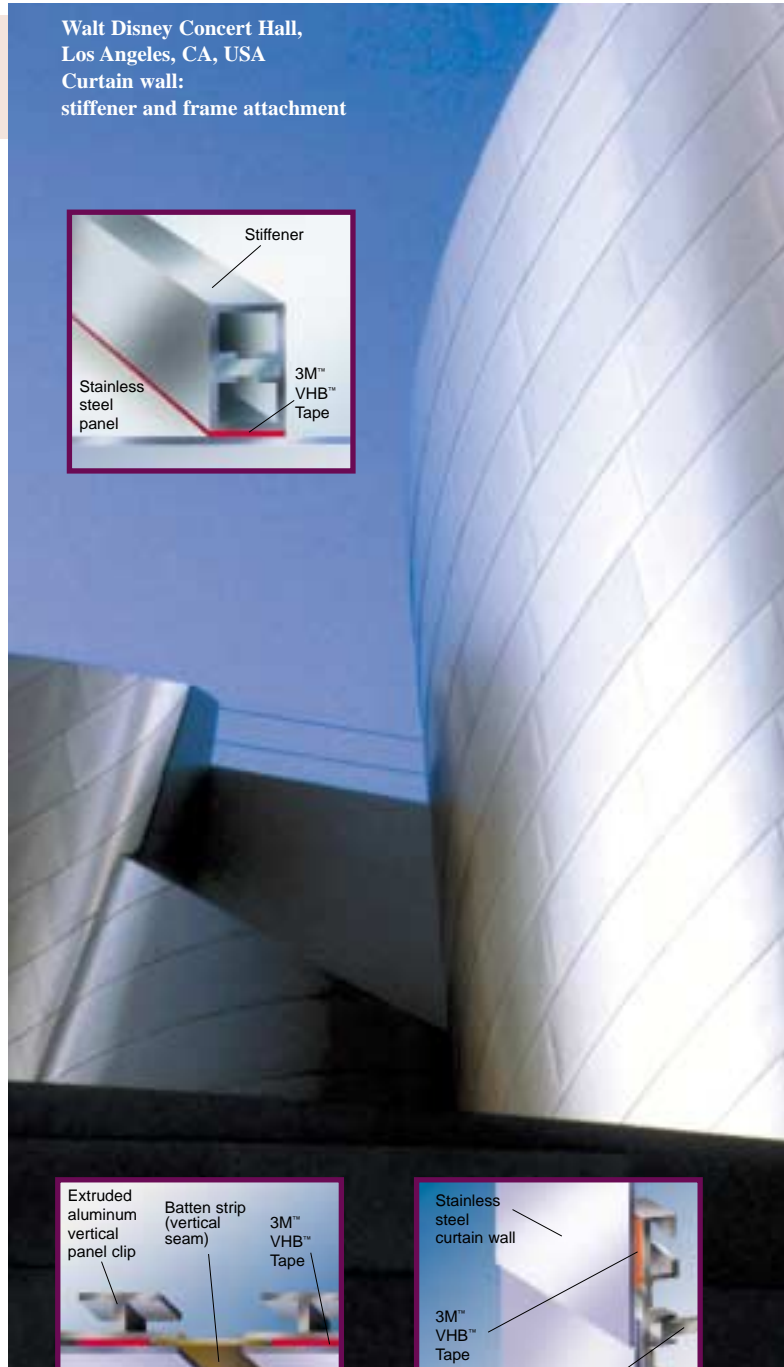
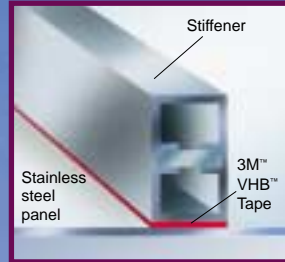


# Construction from panels to windows

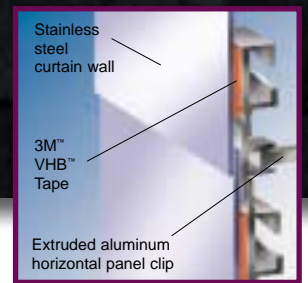
Fast application to permanently bond many materials flat or curved



Walt Disney Concert Hall,  
Los Angeles, CA, USA  
Curtain wall:  
stiffener and frame attachment



Vertical seam



Horizontal seam

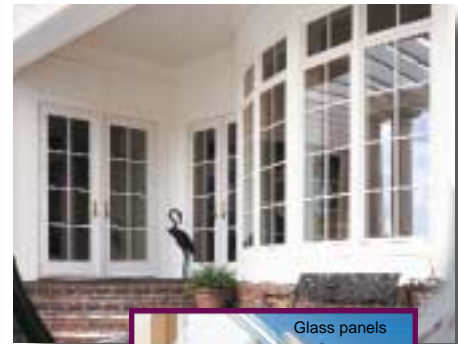
Plaza Centenário,  
Sao Paulo, Brazil  
Architect: Carlos Bratke, 1995  
Aluminum stiffeners bonded to ACM panels.





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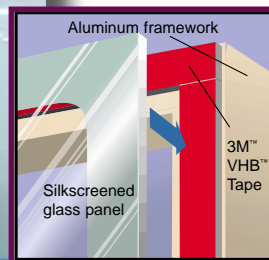
Bond muntin bars made of vinyl, primed wood, or painted aluminum to glass windows or doors. Resists UV exposure.



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Glass bonded to aluminum framework. Subway station platform door, Korea.

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# Signs limited only by the imagination

Versatility and reliable performance throughout any sign

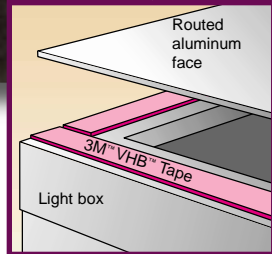
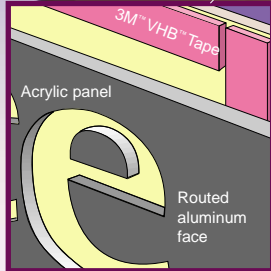


Twin pole monument sign,  
Medina, Ohio  
Fabricator: Lawrence Sign, 2003

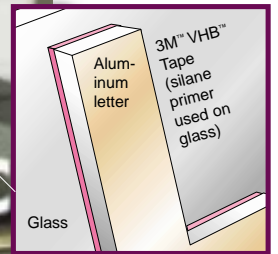


Channel letter sign with decorative backdrop, Seattle, Washington



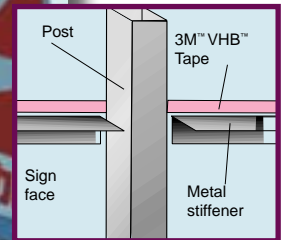


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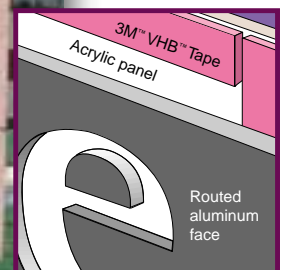
Characters on glass,  
Fort Lee, New Jersey  
Fabricator: Spanjer  
Brothers, Inc., 1989

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Grocery store signage,  
Sagamihara, Japan  
Fabricator:  
Sanwa Neon,  
1993

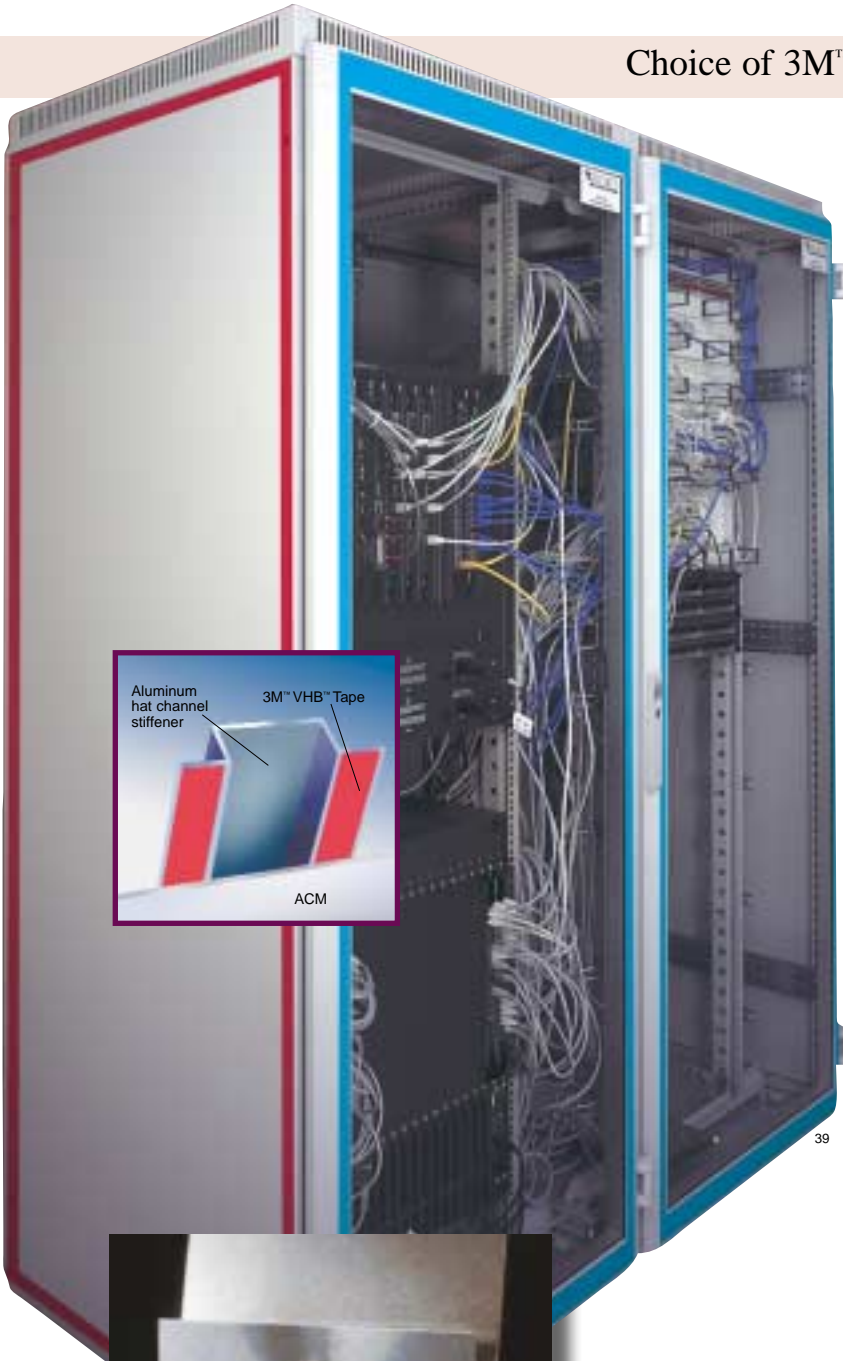
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# Metal fabrication – strength and durability with ease

## Choice of 3M™ VHB™ Tapes for bare or painted metal



Permanently bond metal skin to enclosure frame.

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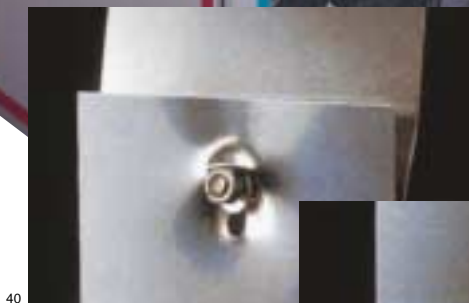
Permanently attach brackets and stiffeners.

43



Permanently attach plastic pocket to enclosure panel without priming in most applications.

44



40

Under equal stress conditions, metal panels bonded with VHB tape show no visible signs of stress compared to those with mechanical fasteners.

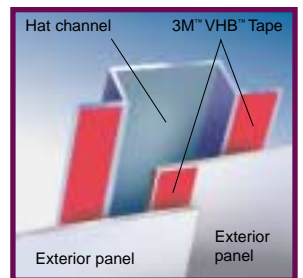
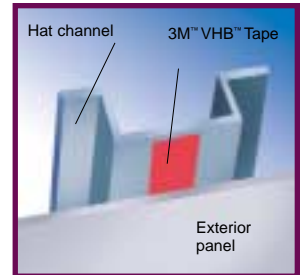
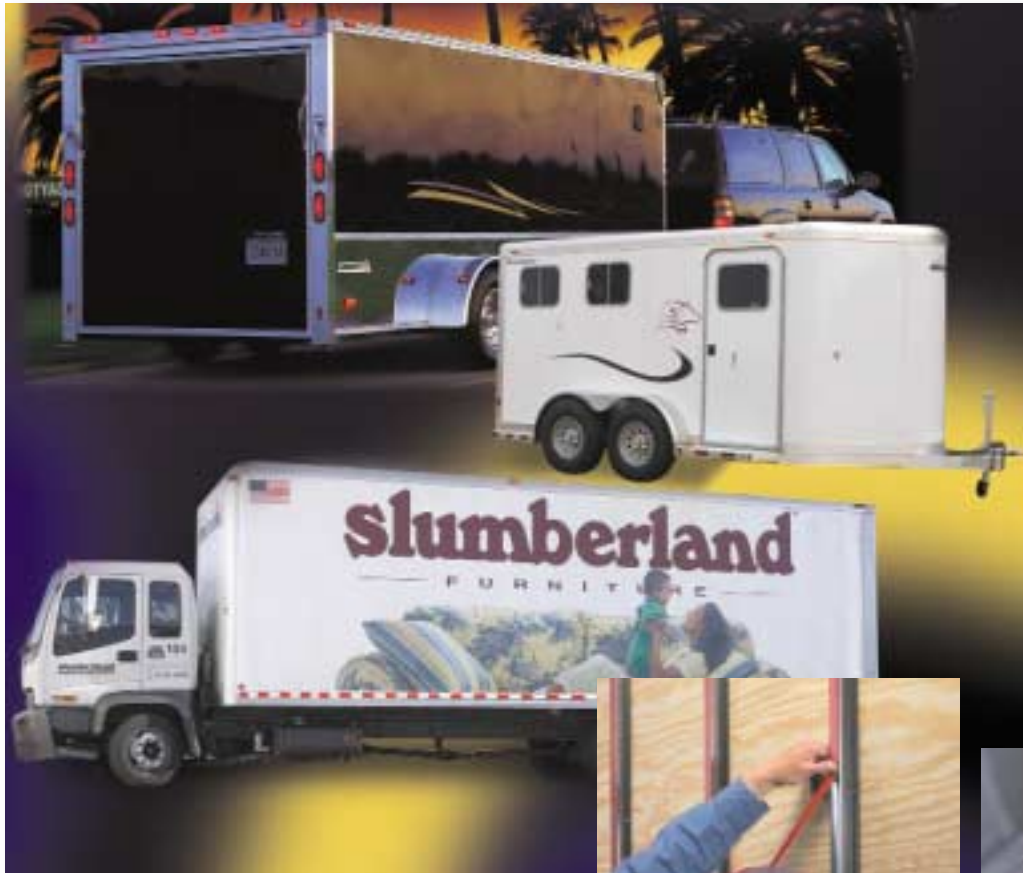


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# Transportation – built fast to last

Built tough with smooth sides to look good for the long haul



45

- Eliminate rivets and screws that can loosen, rattle, and leak
- Damp vibration and noise for a quieter ride
- Keep sides smooth for graphics
- Separate metals to reduce potential for galvanic corrosion



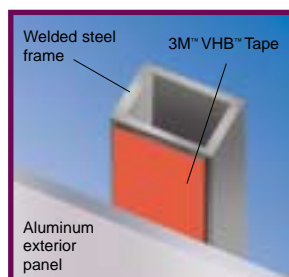
Apply 3M™ VHB™ Tape...

46



Remove liners.

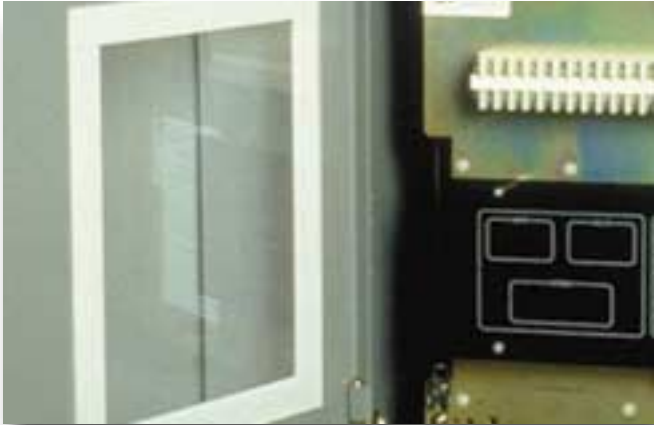
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# Electronics from board to “box”

Flexibility to meet rigid standards of the electronics industry



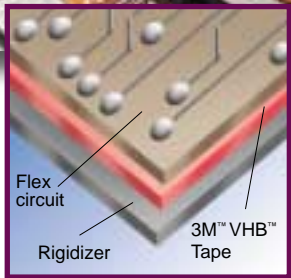
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Bond and seal polycarbonate viewing window into the door of a process control system.



51

Bond rigidizer to flex circuit and withstand process heat.



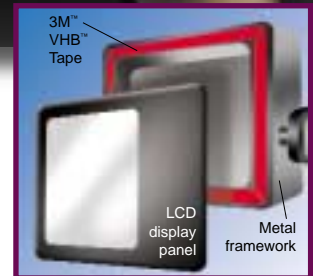
Bond screen to high definition television.

52



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Bond and weather-seal a fish finder lens.



A precise fit with die-cut VHB tape.



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# Optimizing 3M™ VHB™ Tape performance on a wider variety of surfaces

3M™ VHB™ Tapes bond permanently to most surfaces when application requirements are met.

**Clean** In most cases, simply clean substrate with an IPA/water mixture.

**Pressure** Apply 15 psi at the bond line.

**Temperature** Typically apply at 50-60°F (10-26°C). Some VHB tapes can be applied as low as 32°F (0°C).

**Time** Instant tack at room temperature.

Time	Bond strength
20 min.	50%
60 min.	75%
24 hrs.	90%
3 days	100%

**NOTE:** The technical information and data provided here should be considered representative or typical only and should not be used for specification purposes. User should evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for user's method of application.

## 3M™ VHB™ Tape Removal Systems

Easy-to-use for separating bonded parts and removing residue

3M™ VHB™ Tapes bond most surfaces permanently, but if you have to separate the surfaces and remove residue, 3M also has the tools for a fast, effective job.

### 3M™ SMART Tool

Use by hand or in an air chisel to quickly separate such bonded assemblies as overlapped panels and stiffeners.



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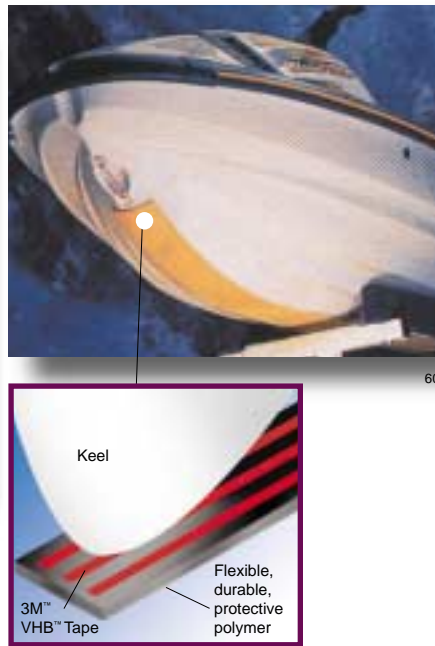
### 3M™ Stripe Off Wheel

Takes residue off faster and easier than solvents or adhesive cleaners. Resilient rounded edge follows contours and irregular surfaces and cleans without scratches or damage to acrylic enamel or urethane paint.

# Wide experience to support you with applications engineering



Highway LED sign, Interstate 70, Colorado



Salt-water resistant Keel Shield™ Hull Protectors



Glass steps bonded to varnished steel frame, Tamedia Building, Zurich, Switzerland

- Technical experts at your service backed with more than 25 years experience in putting 3M™ VHB™ tape to work improving products and processes in many applications
- 3M will be there to make sure you are satisfied
- 3M is constantly developing new solutions for constantly changing customer needs

**For Additional Information:** To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550. Address correspondence to 3M Industrial Adhesives and Tapes Division, 3M Center, Building 21-1W-10, 900 Bush Avenue, St. Paul, MN 55144. Our fax number is 651-778-4244.

**Limited Product Warranty:** 3M warrants for 24 months from the date of manufacture, that 3M™ VHB™ Tape will be free of defects in material and manufacture. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. This warranty does not cover damage resulting from the use or inability to use 3M VHB Tape due to misuse, workmanship in application, or application or storage not in accordance with 3M recommended procedures. **Important Notice:** User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be bonded with the product, the surface preparation of these materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

**Limitation of Remedies and Liability:** If the 3M™ VHB™ Tape is proved to be defective within the warranty period stated above, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M™ VHB™ TAPE. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or strict liability.

**3M**

**Industrial Business  
Industrial Adhesives and Tapes Division**

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70-0709-3830-6