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3M™ Acrylic Foam Tape 5935

Technical Data Sheet

General Description



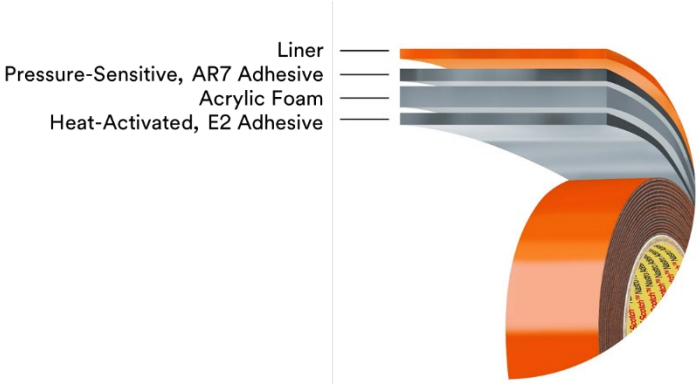
3M™ Acrylic Foam Tape 5935 is a 0.4 mm thick, medium-density, gray acrylic foam tape constructed with two different adhesives. It is recommended for applications where the vehicle taping surface is smooth and a thin tape is necessary. This tape has good conformability and is used to attach weatherstrip and/or gasket seals for automotive and industrial applications.

Product features of 3M AFT 5935 include:

- Heat-activated adhesive forms an immediate, consistent and durable bond to most EPDM formulations and Santoprene® materials
- Pressure-sensitive adhesive is characterized by high adhesion and holding strength to many surfaces, including automotive paints and metals
- Conformable acrylic core delivers excellent wet-out and stress handling characteristics to maintain seal integrity

Since product performance will depend on actual conditions within a specific application, it is essential that the user evaluate the 3M product for fit and feasibility in their application.

Product Construction



Physical Properties

Property	5935
Thickness Range	0.40 mm ±0.05 mm (0.016 inch ±0.002 inch)
Density Range	785 kg/m^3 ± 80 kg/m^3 (49 lb/ft^3 ± 5 lb/ft^3)
Core	Acrylic Foam Core
Color	Gray
Liner	Orange non-siliconized, polyethylene (PE), 0.13 mm ± 0.01 mm (5.0 mils ± 0.5 mils) thick
Adhesive	Liner-side: AR7 acrylic adhesive for adhesion to paint Non liner-side: E2 heat-activated adhesive for adhesion to seal

Tabbing

- Heat-bond tabbing: 3M™ Tabbing Tape 5400 and 3M™ Tabbing Tape 5081 and 5082
- PSA tab: 3M™ Tabbing Tape 5300

Consult application guidelines for detailed product use instructions.

Performance Properties

3M understands that development of automotive applications is typically driven by specification requirements and performance. Each OEM has their own unique criteria, and 3M continues to develop products to meet those demands. Please contact your 3M application engineer for support and to obtain specific test data.

Typical performance of 3M™ Acrylic Foam Tape 5935 is shown below. Peel and shear values depend on substrate characteristics and/or paint composition. These values are for reference only, and not to be used for specification purposes. For specification values please see the certificate of analysis.

90° Peel Adhesion			
Substrate	**Conditions/Test Parameters**	**Product Number**	**Typical Performance Value (N/cm)**
Liner Side to Automotive Paint Panel -1K	20 min RT, 300 mm/min	5935	12.0
	72 hrs RT, 300 mm/min		15.0
Static Shear Adhesion			
Substrate	**Conditions/Test Parameters**	**Product Number**	**Typical Performance Value (minutes)**
Liner Side to Automotive Paint Panel -1K	500 g, 70°C	5935	>6,000
Dynamic Shear Adhesion			
Substrate	**Conditions/Test Parameters**	**Product Number**	**Typical Performance Value (kPa)**
Liner Side to Automotive Paint Panel -1K	72hrs RT, 50mm/min	5935	350
	Test @ 80C, 50mm/min		150

Shelf Life

3M Acrylic Foam Tape 5935 shelf life is three years from date of manufacturing when stored in general indoor warehouse conditions, defined as approximately 4°C-38°C (40°F-100°F) and 30-70% relative humidity. The optimum storage conditions are 22°C (72°F) and 50% relative humidity.

3M Acrylic Foam Tape 5935 should be stored in typical storage conditions for heat-activated adhesives used within the automotive industry.

Levelwound rolls should be stored horizontally. During transportation, storage conditions are uncontrolled for a short period of time (a few days or weeks). This should not impact product performance. However, materials should not be stored in excess of the recommended conditions for extended periods.

Regulatory Information

The product is published as a material entry and is available for access on www.mdsystem.com. For product IMDS I.D. number, email requests to 3M-IMDSrequest@mmm.com.

Contact Information

The information provided in this technical document is intended as a guide for this product. For more information or help in selecting a 3M product for an application, please contact your 3M application engineering representative or connect with a 3M expert.

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Automotive and Aerospace Solutions Division
3M Center, 223-3S-33
St. Paul, MN 55144-1000
Phone 1-800-328-1684
Web www.3M.com/autosolutions

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