



Acrylic Foam Tape 5605

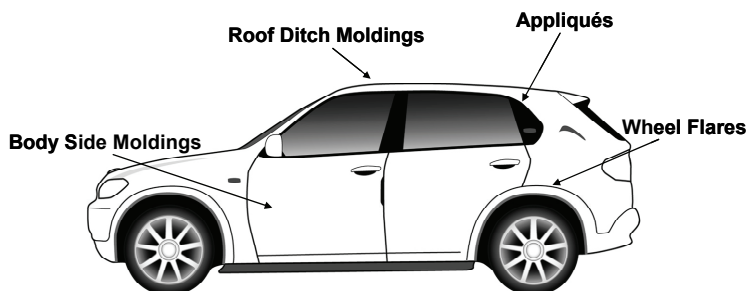
Technical Data Sheet

March 2011

Supersedes Technical Data Sheet dated November 2008

General Description 3M™ Acrylic Foam Tape (AFT) 5605 is designed for the primerless attachment of thermoplastic polyolefin (TPO) and polypropylene (PP) injection molded trim parts to the exteriors of vehicles. The key feature of 3M AFT 5605 is TX-1 adhesive on the non-liner side of the tape. TX-1 is designed to bond to low surface energy plastics such as TPO and PP without the use of an adhesion promoter. 3M AFT 5605 has AR-7 adhesive on the liner side of the tape for bonding to automotive paint surfaces.

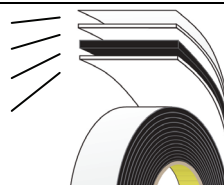
Applications



Shelf Life One year from date of receipt by customer when stored at 22°C (72°F) and 50% relative humidity.

Product Construction

Silicone Coated Liner
AR-7 Acrylic Adhesive
Acrylic Foam
TX-1 Acrylic Adhesive



Physical Properties Values shown are typical values not to be used for specification purposes.

Thickness	1.14 mm (± 0.10 mm) (0.045 in ± 0.004 in)
Density	688 kg/m ³ (± 80 kg/m ³) (43 lb/ft ³ ± 5 lb/ft ³)

Roll Width and Length (Planetary)

3M™ Acrylic Foam Tapes are available in the following standard widths. Millimeter widths rounded to the nearest whole numbers (7, 8, 9 mm . . .) and 1/8 inch increments starting with 1/4 inch (0.25, 0.375, 0.50, 0.625 inch . . .).

Minimum widths:
4 mm Levelwound
5 mm Planetary

Roll Width	Roll Width Tolerance	Roll Length (maximum)
Planetary Rolls		
< 8 mm (< 0.315 in)	+/- 0.38 mm (+/-0.015 in.)	66 meters (72 yards)
8 - 9 mm (0.315 - 0.375 in)	+/- 0.38 mm (+/-0.015 in.)	99 meters (108 yards)
10 - 18 mm (0.394 - 0.709 in)	+/- 0.38 mm (+/-0.015 in.)	132 meters (144 yards)
> 18 mm (> 0.709 in.)	+/- 0.76 mm (+/- 0.030 in.)	132 meters (144 yards)
Levelwound Rolls		
4 - 16 mm (0.157 - 0.630 in.)	+/- 0.38 mm (+/-0.015 in.)	900 meters (984 yards)

Performance Properties

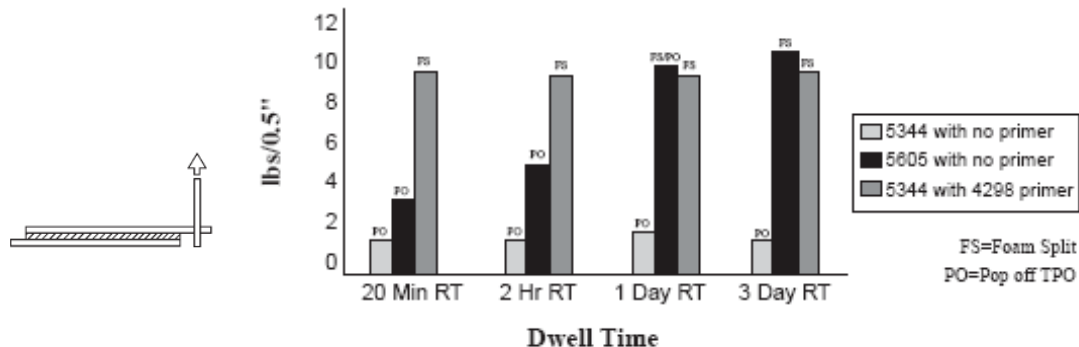
Performance tests are run using standard test procedures. These values presented are typical values not to be used for specification purposes.

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1. 90° Peel Adhesion to Automotive Grade TPO



Breakaway and continuing peel tests are run with 12.7 mm (0.5 in) wide tape on PVC test bars. Tests were run on base coat/clear coat paint at a separation rate of 305 mm/min (12 in/min).



2. Static Shear

Exceeds 100 hours at 70°C (158°F). Static shear tests are run with 12.7 mm (0.5 in) wide by 50.8 mm (2 in) long tape on PVC test bars, 6.8 kg (15 lbs) roll-down against stainless steel. Static weight is 250 gm (0.55 lbs).

Contact Information The information provided in this technical document is intended as a guide for this product. For more information, and help selecting a 3M product for an application, please contact a 3M technical service representative.

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