



Technical Data Sheet

3M™ VHB™ Tape - Specialty Tape 4646

Product Description

3M™ VHB™ Tape 4646 is a 0.025 inch (0.6 mm) thick dark gray double coated acrylic foam tape with PE film liner. The general purpose acrylic adhesive on both sides bonds to a broad range of high surface energy substrates including metals, glass and easier to bond paints and plastics. The firm foam provides high foam strength and has high temperature resistance. 3M™ VHB™ Tape 4646 is part of the 4611 tape family. Each product in this family has general purpose acrylic adhesive but varies in thickness.

Product Features





- Fast and easy-to-use permanent bonding method provides high strength and long-term durability
- Virtually invisible fastening keeps surfaces smooth
- Can replace mechanical fasteners (rivets, welds, screws) or liquid adhesives
- Dark gray, 0.025 in (0.6 mm), general purpose adhesive with firm foam has added feature of high temperature resistance
- Eliminate drilling, grinding, refinishing, screwing, welding and associated clean-up
- Creates a permanent seal against water, moisture and more
- Pressure sensitive adhesive bonds on contact to provide immediate handling strength
- Allows the use of thinner, lighter weight and dissimilar materials

Technical Information Note




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

Typical Physical Properties

Property	Values	Additional Information
Adhesive Type	General Purpose Acrylic	
Foam Type	Firm Acrylic	
Liner	PE Film	
Liner Thickness	0.13 mm	
Color	Dark Gray	
Liner Color	Red	View
Test Name: Primary		










Total Tape Thickness (mil)	25 mil	View 
Test Method: ASTM D3652		
Total Tape Thickness (mm)	0.6 mm	View 
Test Method: ASTM D3652		
Total Tape Thickness	0.025 in	View 
Test Method: ASTM D3652		
Thickness Tolerance	±15 %	
Density	840 kg/m ³	View 
Test Method: ASTM D3574		
Notes: Foam with adhesive		
Density	52 lb/ft ³	
Liner Thickness	0.005 in	

Typical Performance Characteristics

Property	Values	Additional Information
90° Peel Adhesion	15 lb/in	View 
Test Method: ASTM D3330		
Dwell/Cure Time: 24.0		
Dwell Time Units: hr		
Temp C: 23C		
Temp F: 72F		
Environmental Condition: 50%RH		
Backing: 5 mil Aluminum Foil		
Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	26 N/cm	View 
Test Method: ASTM D3330		
Backing: 2 mil Aluminum Foil		
Notes: 12 in/min (300 mm/min)		
Normal Tensile	690 kPa	View 
Test Method: ASTM D897		

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 73F
Substrate: Aluminum

Notes: 1 in.² (6.45 cm²), Jaw Speed 2 in./min. (50 mm/min.)

Normal Tensile	100 lb/in ²	View 
<p>Test Method: ASTM D897</p> <p>Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 73F Substrate: Aluminum</p> <p>Notes: 1 in.² (6.45 cm²), Jaw Speed 2 in./min. (50 mm/min.)</p>		
Overlap Shear Strength	550 kPa	View 
<p>Test Method: ASTM D1002</p> <p>Notes: 1 in.² (6.45 cm²), Jaw Speed 0.5 in/min (12.7 mm/min)</p>		
Overlap Shear Strength	80 lb/in ²	View 
<p>Test Method: ASTM D1002</p> <p>Notes: 1 in.² (6.45 cm²), Jaw Speed 0.5 in/min (12.7 mm/min)</p>		
Short Term Temperature Resistance	232 °C	View 
<p>Notes: No change in room temperature dynamic shear properties following 4 hour conditioning at indicated temperature with 100 g/static load. (Represents minutes, hour in a process type temperature exposure).</p>		
Short Term Temperature Resistance	450 °F	View 
<p>Notes: No change in room temperature dynamic shear properties following 4 hour conditioning at indicated temperature with 100 g/static load. (Represents minutes, hour in a process type temperature exposure).</p>		
Long Term Temp C	149 °C	View 
<p>Notes: Maximum temperature where tape supports at least 250 g load per 0.5 in² in static shear for 10,000 minutes. (Represents continuous exposure for day or weeks).</p>		
Long Term Temp F	300 °F	View 
<p>Notes: Maximum temperature where tape supports at least 250 g load per 0.5 in² in static shear for 10,000 minutes. (Represents continuous exposure for day or weeks).</p>		
Static Shear	1500 g	View 
<p>Test Method: ASTM D3654</p> <p>Temp C: 23C Temp F: 73F Substrate: Stainless Steel</p> <p>Notes: Tested at various temperatures and gram loadings. 0.5 in.² (3.23 cm²). Will hold listed weight for 10,000 minutes (approximately 7 day).</p>		
Static Shear	750 g	View 


Test Method: ASTM D3654

Temp C: 66C

Temp F: 150F

Substrate: Stainless Steel

Notes: Tested at various temperatures and gram loadings. 0.5 in² (3.23 cm²). Will hold listed weight for 10,000 minutes (approximately 7 day).

Static Shear	750 g	View 
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Test Method: ASTM D3654

Temp C: 93C

Temp F: 200F

Substrate: Stainless Steel

Notes: Tested at various temperatures and gram loadings. 0.5 in² (3.23 cm²). Will hold listed weight for 10,000 minutes (approximately 7 day).

Static Shear 121C Stainless Steel	750 g	View 
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Test Method: ASTM D3654

Temp C: 121C

Temp F: 250F

Substrate: Stainless Steel

Notes: Tested at various temperatures and gram loadings. 0.5 in² (3.23 cm²). Will hold listed weight for 10,000 minutes (approximately 7 day).

Static Shear 177C Stainless Steel	750 g	View 
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Test Method: ASTM D3654

Temp C: 177C

Temp F: 350F

Substrate: Stainless Steel

Notes: Tested at various temperatures and gram loadings. 0.5 in² (3.23 cm²). Will hold listed weight for 10,000 minutes (approximately 7 day).

Available Sizes

Property	Values	Additional Information
Standard Roll Length	65.8 m	
Standard Roll Length	72 yd	
Minimum Available Width	6.4 mm	
Minimum Available Width	0.25 in	
Maximum Available Width	1219 mm	
Maximum Available Width	48 in	

Normal Slitting Tolerance ±0.79 mm

Normal Slitting Tolerance ±1/32 in

Core Size (ID) 76.2 mm

Core Size (ID) 3 in

Available Sizes




UL 746C Listings

Solvent and Fuel Resistance

Additional Performance Characteristics

Property	Values	Additional Information
Shear Modulus	6 x 10 ⁵ Pa	
Coefficient of Thermal Expansion	See 3M™ VHB™ Tape 4611 m/m/°C	

Electrical and Thermal Properties

Property	Values	Additional Information
Dielectric Constant 1KHz	See 3M™ VHB™ Tape 4611	View 
Test Method: ASTM D150 Temp C: 23C Temp F: 72F		
Dielectric Constant 1MHz	See 3M™ VHB™ Tape 4611	View 
Test Method: ASTM D150 Temp C: 23C Temp F: 72F		
Dissipation Factor 1KHz	See 3M™ VHB™ Tape 4611	View 
Test Method: ASTM D150 Temp C: 23C Temp F: 72F		

Dissipation Factor 1MHz

See 3M™ VHB™ Tape 4611

View 

Test Method: ASTM D150

Temp C: 23C

Temp F: 72F

Dielectric Strength

See 3M™ VHB™ Tape 4611 V/μm

View 

Test Method: ASTM D140

Thermal Conductivity

See 3M™ VHB™ Tape 4611 W/m/K

Volume Resistivity

See 3M™ VHB™ Tape 4611 Ω-cm

View 

Test Method: ASTM D257

Temp C: 23C

Temp F: 73F

Surface Resistivity

See 3M™ VHB™ Tape 4611 Ω

View 

Test Method: ASTM D257

Design Considerations

Adhesion to the substrate is important in achieving bonding success. Adhesives must flow onto the substrate surfaces in order to achieve intimate contact area and allow the molecular force of attraction to develop. The degree of flow of the adhesive on the substrate is largely determined by the surface energy of the substrate. 3M™ VHB™ 4611 family tapes bond well to high (HSE) surface energy materials. The image below shows typical materials in these categories.

Achieving good contact is also important. The necessary thickness of tape depends on the rigidity of substrates and their flatness irregularity. While the 3M™ VHB™ Tapes will conform to a certain amount of irregularity, they will not flow to fill gaps between the materials. For bonding rigid materials with normal flatness, consider use of tapes with thickness of 45 mils (1.1 mm) or greater. As the substrate flexibility increases thinner tapes can be considered.

Using the right amount of tape is important to handle the expected stresses. Because 3M™ VHB™ Tapes are viscoelastic by nature their strength and stiffness is a function of the rate at which they are stressed. They behave stronger with relatively faster rate of stress load (dynamic stresses) and will tend to show creep behavior with stress load acting over a long period of time (static stresses). As a general rule, for static loads, approximately four square inches of tape should be used for each pound (57 cm² of tape per kg) of weight to be supported in order to prevent excessive creep. For dynamic loads a useful design factor is 12 lb/in² (85 kPa) for most dynamic stresses in general applications.

Allow for thermal expansion/contraction. 3M™ VHB™ Tapes can perform well in applications where two bonded surfaces may expand and contract differentially. Assuming good adhesion to the substrates, the tapes can typically tolerate differential movement in the shear plane up to 3 times their thickness.

Bond Flexibility: While an advantage for many applications where allowing differential movement is a benefit, the tape bonds are typically more flexible than alternative bonding methods. Suitable design modifications or periodic use of rigid fasteners or adhesives may be needed if additional stiffness is required.

Performance in Severe Cold Temperature can be challenging. Applications which require performance at severe cold temperatures must be thoroughly evaluated by the user if the intended use will subject the tape product to high impact stresses. A technical bulletin “3M™ VHB™ Tape Cold Temperature Performance” (70-0707-3991-0) is available for additional information.

Converting

In addition to standard and custom roll sizes available from 3M through the distribution network, 3M™ VHB™ Tapes are also available in limitless shapes and sizes through the 3M Converter network. For additional information, contact 3M Converter Markets at 1-800-223-7427 or on the web at www.3M.com/converter.

Storage and Shelf Life

All 3M™ VHB™ Tapes have a shelf life of 24 months from date of manufacture when stored at 40°F to 100°F (4°C to 38°C) and 0-95% relative humidity. The optimum storage conditions are 72°F (22°C) and 50% relative humidity. Performance of tapes is not projected to change even after shelf life expires

Industry Specifications

UL 746C (File MH 17478)

Bottom Matter

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Handling/Application Information

Application Techniques

Clean: Most substrates are best prepared by cleaning with a 50:50 mixture of isopropyl alcohol (IPA*) and water prior to applying 3M™ VHB™ Tapes.

Exceptions to the general procedure that may require additional surface preparation include:

- Heavy Oils: A degreaser or solvent-based cleaner may be required to remove heavy oil or grease from a surface and should be followed by cleaning with IPA/water.
- Abrasion: Abrading a surface, followed by cleaning with IPA/water, can remove heavy dirt or oxidation and can increase surface area to improve adhesion.
- Adhesion Promoters: Priming a surface can significantly improve initial and ultimate adhesion to many materials such as plastics and paints.
- Porous surfaces: Most porous and fibered materials such as wood, particleboard, concrete, etc. need to be sealed to provide a unified surface.
- Unique Materials: Special surface preparation may be needed for glass and glass-like materials, copper and copper containing metals, and plastics or rubber that contain components that migrate (e.g. plasticizers).

Refer to 3M Technical Bulletin "Surface Preparation for 3M™ VHB™ Tape Applications" for additional details and suggestions. (70-0704-8701-5)

*Note: These cleaner solutions contain greater than 250 g/l of volatile organic compounds (VOC). Please consult your local Air Quality Regulations to be sure the cleaner is compliant. When using solvents, be sure to follow the manufacturer's precautions and directions for use when handling such materials.

Pressure: Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact and helps improve bond strength. Typically, good surface contact can be attained by applying enough pressure to insure that the tape experiences approximately 15 psi (100 kPa) pressure. Either roller or platen pressure can be used. Note that rigid surfaces may require 2 or 3 times that much pressure to make the tape experience 15 psi.

Temperature: Ideal application temperature range is 70°F to 100°F (21°C to 38°C). Pressure sensitive adhesives use viscous flow to achieve substrate contact area. Minimum suggested application temperature for the 3M™ VHB™ Tape 4611 family is 50°F (10°C). Minimum application temperature does vary by 3M™ VHB™ tape family and ranges from 32°F to 60°F (0°C to 15°C)

Note: Initial tape application to surfaces at temperatures below these suggested minimums is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory. To obtain good performance with all 3M™ VHB™ Tapes, it is important to ensure that the surfaces are dry and free of condensed moisture.

Time: After application, the bond strength will increase as the adhesive flows onto the surface (also referred to as “wet out”). At room temperature approximately 50% of ultimate bond strength will be achieved after 20 minutes, 90% after 24 hours and 100% after 72 hours. This flow is faster at higher temperatures and slower at lower temperatures. Ultimate bond strength can be achieved more quickly (and in some cases bond strength can be increased) by exposure of the bond to elevated temperatures (e.g. 150°F [66°C] for 1 hour). This can provide better adhesive wetout onto the substrates. Abrasion of the surfaces or the use of primers/ adhesion promoters can also have the effect of increasing bond strength and achieving ultimate bond strength more quickly.

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/p/d/b40065659/
Safety Data Sheet SDS	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=4646

Family Group

Link Tags:

- 4611
- 4646
- 4655

Products	Adhesive Type	Foam Type	Liner	Liner Thickness	Color	Liner Color	Total Tape Thickness (mm)
4646	General Purpose Acrylic	Firm Acrylic	PE Film	0.13 mm	Dark Gray	Red	0.6 mm
4655	General Purpose Acrylic	Firm Acrylic	PE Film	0.13 mm	Dark Gray	Red	1.6 mm
4611	General Purpose Acrylic	Firm Acrylic	PE Film	0.13 mm	Dark Gray	Red	1.1 mm

ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

Information

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