



3M™ Acrylic Plus Tape ST1200

Technical Data Sheet

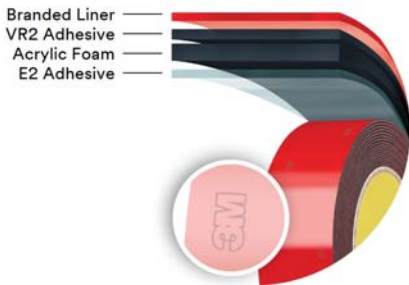


3M™ Acrylic Plus Tape ST1200 is a 1.20 mm (0.047 in) thick, black acrylic foam tape, constructed with two different adhesives, used to attach weatherstrip and/or gasket seals for automotive and industrial applications.

3M ST1200 Tape offers the following key features:

- Provides high adhesion and holding strength to automotive paint surfaces.
- Conformable acrylic core delivers excellent wet-out and stress handling characteristics to maintain seal integrity.
- Features a black, high-strength core resulting in improved bond line appearance and quality.
- Heat-activated adhesive on the non-liner side forms an immediate, consistent and durable bond to most EPDM formulations and TPE materials.

Product Construction



Liner Options

See the technical update [“3M™ Acrylic Foam and Acrylic Plus Tapes: Product Constructions”](#) for liner and tabbing options.

Physical Properties

ST1200	
Thickness Range	1.20 mm \pm 0.13 mm (0.047 in. \pm 0.005 in)
Density Range	689 kg/m ³ \pm 64 kg/m ³ (43 lb/ft ³ \pm 4 lb/ft ³)

Roll Width and Length

3M™ Acrylic Plus Tapes are available in the following standard widths. Millimeter widths -- rounded to the nearest whole number – and 1/8-inch increments starting with 1/4 inch.

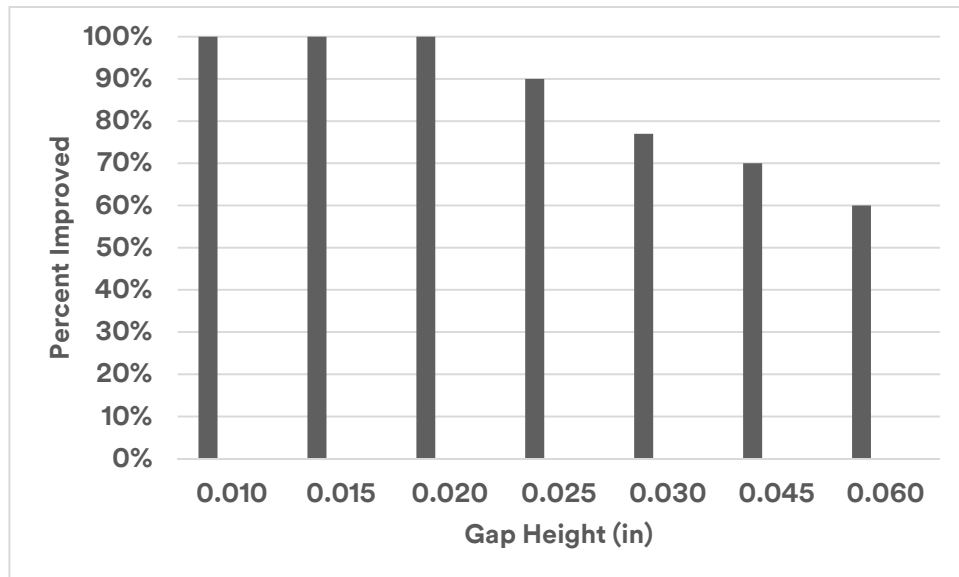
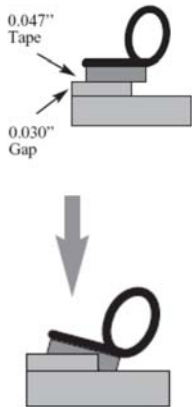
Minimum widths: 4 mm Levelwound, 6 mm Planetary (standard versions)

Roll Width	Roll Width Tolerance	Roll Length (max)
Planetary Rolls		
< 8 mm (< 0.315 in)	+/- 0.40 mm (+/-0.015 in)	66 M (72 yds)
8 - 9 mm (0.315 - 0.375 in)	+/- 0.40 mm (+/-0.015 in)	99 M (108 yds)
> 10 - 18 mm (0.394 – 0.709 in)	+/- 0.40 mm (+/-0.015 in)	132 M (144 yds)
> 18 mm (> 0.709 in)	+/- 0.80 mm (+/- 0.031 in)	132 M (144 yds)
Levelwound Rolls		
4 – 16 mm (0.157 – 0.630 in)	+/- 0.40 mm (+/-0.015 in)	700 M (765 yds)

Performance Properties

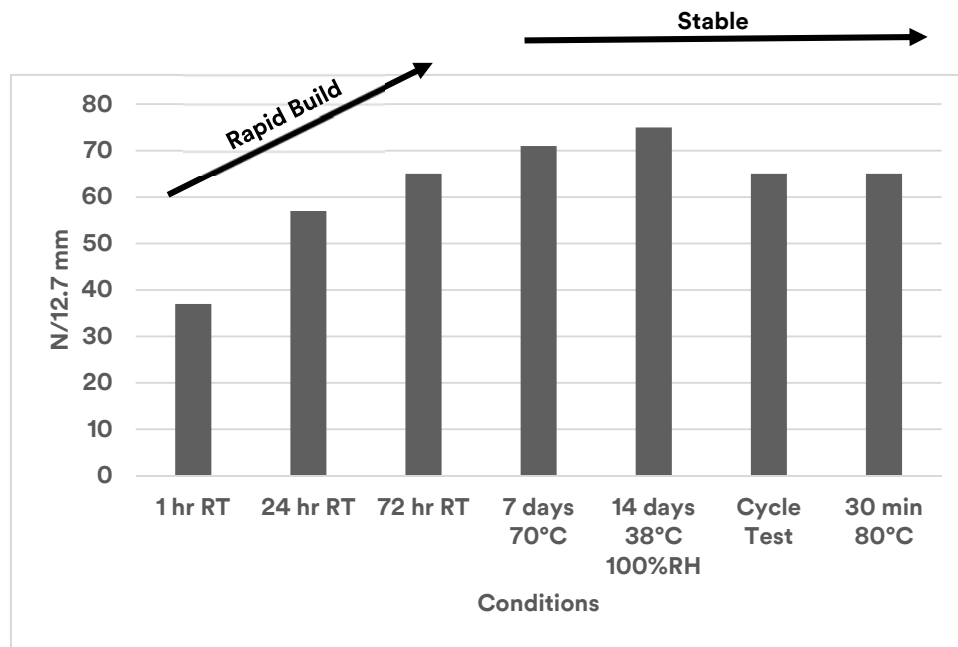
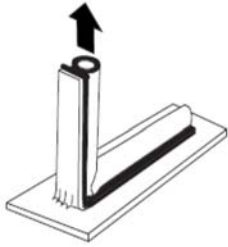
Typical performance of 3M™ Acrylic Plus Tape ST1200 is shown below. Peel values depend on the composition and cross-section of a particular weatherstrip. These values are for reference only.

Conformability/Wet-Out



Performance Properties (continued)

90° Peel Adhesion



3M ST1200 Tape has excellent initial adhesion at assembly and excellent long-term adhesion over all environmental conditions during vehicle life.

Shelf Life

One year from date of manufacture when stored at 4°C - 38°C (40°F - 100°F) and 0-95% relative humidity (RH). The optimum storage conditions are 22°C (72°F) and 50% relative humidity.

Regulatory Information

Please refer to the product label and Safety Data Sheet (SDS) for health and safety information before using. Observe proper handling precautions as outlined in the SDS, which is available on request or at www.3M.com/msds.

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 technical service representative or call 1-800-328-1684.

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