



Weatherstrip Attachment Tape 5404

Technical Data Sheet

April 2009

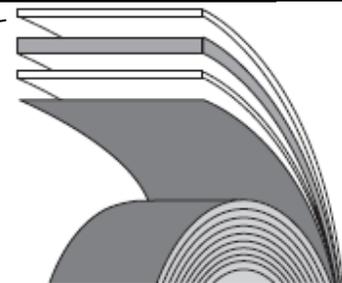
Supersedes Technical Data Sheet dated August 2004

General Description 3M™ Weatherstrip Attachment Tape 5404 is a 1.2 mm thick, medium-density, gray acrylic foam tape constructed with two different adhesives. The heat-activated adhesive forms an immediate, consistent and durable bond to most EPDM formulations and Santoprene® materials. The pressure-sensitive adhesive is characterized by high adhesion and holding strength to many surfaces, including automotive paints and metals. This tape has good conformability and is used to attach weatherstrip and/or gasket seals for automotive and industrial applications.

Shelf Life One year from date of receipt by customer 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.

Product Construction

Heat-activated E2 adhesive
 Gray acrylic foam core
 Pressure-sensitive AR-7 acrylic adhesive
 Liner



Physical Properties

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

| | |
|----------------------------------|---|
| Tape thickness (excluding liner) | 1.20 mm ± 0.10 mm (0.047 inch ± 0.004 inch) |
| Tape density (excluding liner) | 690 kg/m ³ ± 65 kg/m ³ (43 lb/ft ³ ± 4 lb/ft ³) |
| Tabbing option | 3M™ Tabbing Tape 5400 |

Roll Width and Length

3M™ Weatherstrip Attachment Tapes are available in the following standard widths. Millimeter widths are 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 | | |
| 5 – 6 mm (0.197 – 0.236 in.) | +/- 0.40 mm (+/-0.015 in.) | 66 meters (72 yards) |
| 6.35 – 9.5 mm (0.25 – 0.375 in.) | +/- 0.40 mm (+/-0.015 in.) | 99 meters (108 yards) |
| 10 – 18 mm (0.394 – 0.709 in.) | +/- 0.40 mm (+/-0.015 in.) | 132 meters (144 yards) |
| > 18 mm (> 0.709 in.) | +/- 0.80 mm (+/- 0.031 in.) | 132 meters (144 yards) |
| Levelwound Rolls | | |
| 4 – 16 mm (0.157 – 0.630 in.) | +/- 0.40 mm (+/-0.015 in.) | 900 meters (984 yards) |

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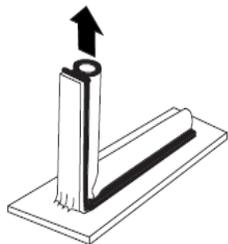
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Page 2

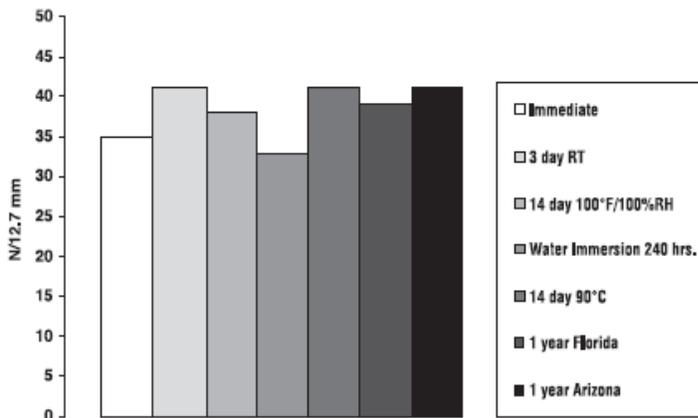
Performance Properties

90° Peel Adhesion

Typical performance of 3M™ Weatherstrip Attachment Tape 5404 is shown below. Peel values depend on the composition and cross-section of a particular weatherstrip. These values should be for reference only.



90° Peel Adhesion



3M Acrylic Foam Tape 5404 has excellent initial adhesion at assembly and long-term adhesion over all environmental conditions during vehicle life.

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 3M HELPS at 1-888-3M HELPS (1-888-364-3577).

Regulatory

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