3M™ Acrylic Foam Tape 5609
Technical Data Sheet

Product Description
3M™ 5609 is an Acrylic Foam Tape made of grey acrylic foam. The tape is in particular suited for the attachment of elastomeric parts such as seals to car bodies or doors. 5609 is characterised by its high adhesion to a variety of automobile surfaces. One side of the tape is attached to the painted surface or respective substrate by self-stick acrylic foam. The other side is bonded to the elastomeric part through heat activation. The heat activated adhesive guarantees a durable bond, especially to seals made of EPDM and TPE. A good inner strength, brilliant long-term stability as well as very good conformability to the bonded surfaces are characteristic attributes for 5609.

Product Features
- Good adhesion to many automotive paints.
- Operating temperature up to 90°C.
- Optimized acrylate foam core for easy application and good adaptation to component surfaces.
- Temperature, weather, UV and solvent resistant.
- Suitable for all manual and automatic application processes.

Advantages
- 3M™ Acrylic Foam Adhesive Tapes can compensate stress due to their unique viscoelasticity. In contrast to foam adhesive tapes (PE, PU adhesive tapes), they can cope with significant elongation differences between substrates in case of temperature changes.
- Easy to use: The tape can be easily processed in multiple ways to cut and to apply.
- Good initial adhesion: The initial adhesion allows immediate further processing often without temporary support or fixtures.
- Freedom of design: enables the easy differentiation of vehicle models through modified trim attachments without change of the body configuration.
- Sealing and damping properties: positive improvement of NVH properties.

Product Construction
### Physical Properties

<table>
<thead>
<tr>
<th>Typical Values</th>
<th>5609</th>
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</thead>
<tbody>
<tr>
<td><strong>Thickness</strong></td>
<td>0.8 mm</td>
</tr>
<tr>
<td><em>90° Peel on 3M Reference Stainless Steel plates (Specification values have to be determined on customer substrate)</em></td>
<td></td>
</tr>
<tr>
<td>20 min RT Liner Side (LS)</td>
<td>25 N/cm</td>
</tr>
<tr>
<td>72 h RT Liner Side (LS)</td>
<td>29 N/cm</td>
</tr>
<tr>
<td><strong>Density</strong></td>
<td>650 kg/m³</td>
</tr>
<tr>
<td><strong>Core</strong></td>
<td>3M™ Acrylic Foam Tape</td>
</tr>
<tr>
<td><strong>Color</strong></td>
<td>Gray</td>
</tr>
<tr>
<td><strong>Liner</strong></td>
<td>Orange polyethylene film.</td>
</tr>
</tbody>
</table>
| **Adhesive** | Non-liner side (NLS) (to rubber): E2 heat activatable adhesive for EPDM and TPE.  
Liner Side (LS) (paint side): Self-stick adhesive with high initial tack and high ultimate bond strength. |
| **Shelf Life** | Film liner: 36 month from date of manufacturing  
Conditions: 4 °C - 38 °C and 0 - 95 % RH in original unopened packaging – optimum: 23 °C ± 2 °C and 50% ± 4 % RH  
Levelwound rolls to be stored horizontally. |
| **Temperature Resistance** | -40°C to +90°C, short term 120°C  
(both values are load-dependent). |
| **Tabbing** | An extended liner tab is recommended.  
3M™ Heat-bonding tabbing 5081 - 5082. |
| **Splices** | Number of splices depends on order quantity and roll length.  
Level-wound rolls have 3-4 splices on average. Smaller order quantities (less than 400 m²) rolls could contain a significantly different number of splices. |
| **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 use www.3M.com/msds.  
The product is published as material entry and is available for access on www.mdsystem.com. For Product IMDS ID Number, email requests to 3M-IMDSrequest@mmm.com.  
(In Germany use ge-produktsicherheit@mmm.com). |
| **IMDS** | http://www.mdsystem.com/imdsnt/startpage/index.jsp |

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