



# Primerless Acrylic Foam Tape 5849

## For Professional Market Applications

Technical Data Sheet

November 2002

Supersedes Preliminary Data Sheet dated April 2002

### General Description

3M™ Primerless Acrylic Foam Tape 5849 is a 20-mil thick, medium-density, dark gray acrylic foam, with TX-1 and DS-4 adhesives on the liner and non-liner sides of the product, respectively. 3M primerless acrylic foam tape 5849 is designed to give a thin bond line for attachment of flexible wood and synthetic decorative dash appliqués to interior plastic dash and trim substrates without the use of adhesion promoters.

TX-1 adhesive is characterized by high peel and shear adhesion to unprimed low surface energy plastics, typically used in the manufacture of interior automotive dash and trim parts (i.e., TPO, PP, PPO, PC, ABS, plastic alloys, etc.). DS-4 adhesive exhibits excellent adhesion to primed plastics and veneers. 3M primerless acrylic foam tape 5849 utilizes a 3M logo-printed, easy-release, maroon liner for liner startability and removal.

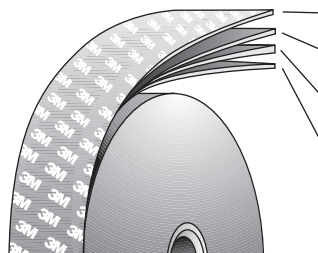
Applications for this acrylic foam tape include attachment of flexible synthetic and thin flexible wood dash appliqués to interior factory dash and trim. It is also suitable for most thin, flexible miscellaneous decorative interior/exterior trim to low surface energy plastics.

### Typical Applications

Interior Dash Overlays  
and Decorative Appliqués



### Product Construction



- Maroon Easy-Release Liner Printed with 3M Logo
- TX-1 Acrylic Adhesive
- Acrylic Foam Core
- DS-4 Acrylic Adhesive

### 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. Optimum storage conditions are 22°C (72°F) and 50% relative humidity.

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## Physical Properties

<b>Foam</b>	Dark Gray Acrylic	
<b>Adhesive</b>	Liner Side Non-liner Side	TX-1 DS-4
<b>Thickness Range</b>	0.51 mm min. 0.43 mm max. 0.58 mm	(0.020 in) (0.017 in) (0.023 in)
<b>Density Range</b>	689 kg/m <sup>3</sup> min. 609 kg/m <sup>3</sup> max. 769 kg/m <sup>3</sup>	(43 lb/ft <sup>3</sup> ) (38 lb/ft <sup>3</sup> ) (48 lb/ft <sup>3</sup> )
<b>Liner</b>	Maroon easy-release liner printed with 3M logo	
<b>Roll Widths</b>	min. 6.4 mm max. 1219 mm	(0.25 in.) (48 in.)
<b>Roll Lengths:</b>	For widths less than 8 mm (0.314 in.): Up to 98.8 m (108 yds.). For widths between 8 - 9.5 mm (0.315 - 0.375 in.): Up to 131.6 m (144 yds.). For widths greater than 9.5 mm (0.376 in.): Up to 160 m (175 yds.).	

## Typical Performance Properties

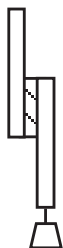
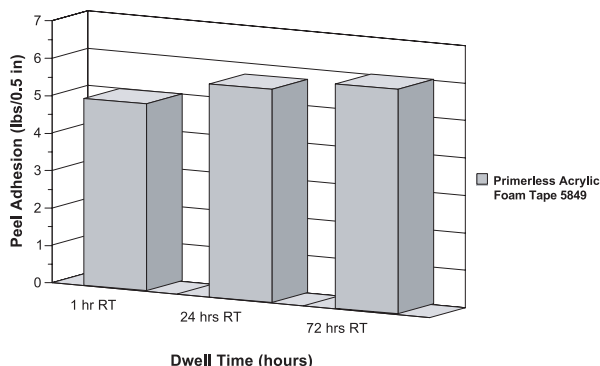
Performance tests are run using standard test procedures. The values presented are typical values not to be used for specification purposes.



### 1. Peel Adhesion

90 Degree Peel  
Adhesion (lbs/0.5 in)

Adhesion to Polypropylene (PP) without Adhesion Promoter



250 g (0.55 lb)

### 2. Static Shear

Exceeds 10,000 min.  
at 79° C (175°F).

Static shear tests are run with 12.7 mm (0.5 in) wide by 50.8 mm (2.0 in) long tape on a polypropylene (PP) test panel with a 6.8 kg (15 lb) roll down against anodized aluminum. Weight is 250 g (0.55 lb).

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