

# 3M™ Conformable Bonding Tape 5073 and 5074

## Technical Data Sheet

### General Description

3M™ Conformable Bonding Tapes 5073 and 5074 offer very good adhesion performance and high flexibility. These tapes are specially designed for rough or highly irregular surfaces, providing strong adhesion for applications such as automotive wire harness assembly, and offering excellent conformability for sealing applications.

3M Conformable Bonding Tapes 5073 and 5074 offer the following key features:

- Excellent initial adhesion and static performance on uneven substrates
- Highly conformable tape for sealing and bonding to rough or irregular surfaces
- It is a flexible black tape with independent foam, allowing it to absorb irregularities and provide sealing, offering more flexibility than 3M™ Acrylic Foam Tapes
- Excellent adhesion performance with superior weather resistance, heat resistance, and chemical resistance
- Can be applied to various substrates used for automotive parts without special surface treatment\*



\*Note: Depending on the material (e.g., EPDM rubber), 3M™ Adhesion Promoter may be required. Please check before use.

Typical applications for 3M Conformable Bonding Tapes 5073 and 5074 include sealing or bonding support for weather-strips, various interior or exterior part attachment, foam bonding, and fixing wire harnesses to the headliner.

### Product Construction



### Physical Properties

Property	5073	5074
Core	Acrylic Foam Core	
Core Color	Black	
Thickness*	1.0 mm	2.0 mm
Liner	Translucent, light blue, polyethylene liner	

\*Liner thickness is not included

### Performance Properties

3M understands that development of automotive applications is typically driven by specification requirements and performance. Each OEM has their own unique criteria, and 3M continues to develop suitable products to meet those demands. Test reports are available upon request. Please contact your 3M application engineer for support and to obtain specific test data.

Typical performance of 3M Conformable Bonding Tapes (CBT) 5073 and 5074 is shown below. Peel and shear values depend on substrate characteristics and/or paint composition. These values are for reference only, and not to be used for specification purposes. For specification values please see the certificate of analysis.

Conditions/Test Parameter Definitions:

- Initial State = 23°C, 20 mins
- Normal State = 23°C, 24 hours
- High Temperature = 23°C, 24 hours -> 80°C
- Heat-aging = 23°C, 24 hours -> 80°C, 336 hours -> 23°C, 24 hours
- Warm Water Immersion = 23°C, 24 hours -> 40°C water, 336 hours -> 23°C, 24 hours
- Wax-remover immersion = 23°C, 24 hours -> wax-remover, 1 hour -> 23°C, 24 hours
- Immediate state = 5, 23, 40°C, 30 seconds

**180° Peel Adhesion to Painted Panel and Polypropylene (PP) Substrate**  
 Tape Size: 10 mm width; Tape backing: 25 µm PET film; Rolling Pressure: 2 kg roller one-way; Peel Speed: 50 mm/min.

Substrate	Conditions/Test Parameters	Typical Performance Value (N/cm)	
		5073	5074
Painted Panel <sup>1</sup> without Adhesion Promoter	Initial State	14.0	18.0
	Normal State	14.0	18.0
	High Temperature	6.0	8.0
	Heat-aging	18.5	23.5
	Warm Water Immersion	18.5	23.0
	Wax Remover Immersion	13.5	18.0
PP with 3M™ Adhesion Promoter K520	Initial State	14.0	18.0
	Normal State	14.0	18.0
	High Temperature	6.0	8.0
PP without Adhesion Promoter	Initial State	8.8	9.8
	Normal State	9.8	10.8
	High Temperature	2.9	2.9

**90° Peel Strength to Painted Panel**  
 Tape Size: 10 mm width; Tape backing: 25 µm PET film; Rolling Pressure: 2 kg roller one-way; Peel Speed: 300 mm/min.

Substrate	Conditions/Test Parameters	Typical Performance Value (N/cm)		
		5073	5074	
Painted Panel <sup>1</sup> without Adhesion Promoter	Immediate State	5°C	11.8	14.0
		23°C	16.8	23.1
		40°C	16.8	23.1

**Static Shear Holding Power on Paint and Ethylene Propylene Diene Monomer Rubber (EPDM)**  
 Tape Size: 10mm x 25mm; Rolling pressure: 5kg roller one-way.

Substrate	Conditions/Test Parameters	Holding Power (g)		
		5073	5074	
Painted Panel <sup>1</sup> and EPDM with 3M™ Adhesion Promoter K520	Normal State	23°C	400	500
		40°C	300	400
		60°C	200	300
		80°C	100	100

<sup>1</sup> Painted panel: White colored painted panel used on a vehicle

**Shelf Life**

Three years (36 months) from date of manufacture when stored at recommended storage condition 23°C and 50% relative humidity.

**Regulatory Information**

The product is published as a material entry and is available for access on [www.mdssystem.com](http://www.mdssystem.com). For product IMDS I.D. number, email requests to [3M-IMDSrequest@mmm.com](mailto: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 application engineering representative or [connect with a 3M expert](#).

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