

# Adhesive & Tape Solutions for Your Assembly Challenges

## What are Gasket Attachment Assemblies?

Gaskets are used in multiple markets, such as electronics, transportation, fluid handling equipment and appliance.



**Gasketing:** Attachment of a substrate typically, foam, rubber or paper that acts as an interface or seal between two surfaces. 3M offers solutions for attaching preformed gaskets, and also solutions which can replace gaskets or bond and seal simultaneously. **Examples include air and liquid filters, fluid handling equipment, heat exchangers and ball joints.**

### Possible Adhesive or Tape Requirements:

- Easy and fast to apply gaskets
- Resist fluids
- High adhesion to foams and rubber

### Best 3M Solutions for Gasket Attachment



#### ■ 3M™ VHB™ Tapes

High-strength bonding tapes that can be die-cut into a variety of shapes to replace rubber or foam gaskets, providing an instant, simple solution. Their closed-cell construction provides a watertight barrier between flat parts.



#### ■ 3M™ Scotch-Weld™ Instant Adhesives

One part solvent-free cyanoacrylate (CA) adhesive that reaches handling strength in 5–30 seconds. Best for small very tight bondlines (<10 cm<sup>2</sup>). Commonly used on rubbers and plastics.



#### ■ 3M™ Scotch-Weld™ Gasket Makers

One-part anaerobic adhesives can be applied as a curing liquid gasket between complex metal shapes, replacing pre-formed gaskets.



#### ■ 3M™ Contact and Spray Adhesives

Solvent and water based adhesives can be sprayed, brushed or roll applied. Very fast, easy and economical coverage of multiple substrates, irregular shapes and mild textures.



#### ■ 3M™ Adhesive Transfer Tapes

Can be pre-applied to gasketing material which is then die-cut to provide parts. These products provide instant adhesion to flat, untextured substrates.



#### ■ 3M™ Double Coated Tapes

Can be pre-applied to gasketing material which is then die-cut to provide parts. These products provide instant adhesion.

### Performance Factors for Gasket Attachment

All 3M technologies in the table below are commonly used in gasket attachment applications. Use the table below as a relative comparison of product performance.

Good = + Better = ++ Best = +++

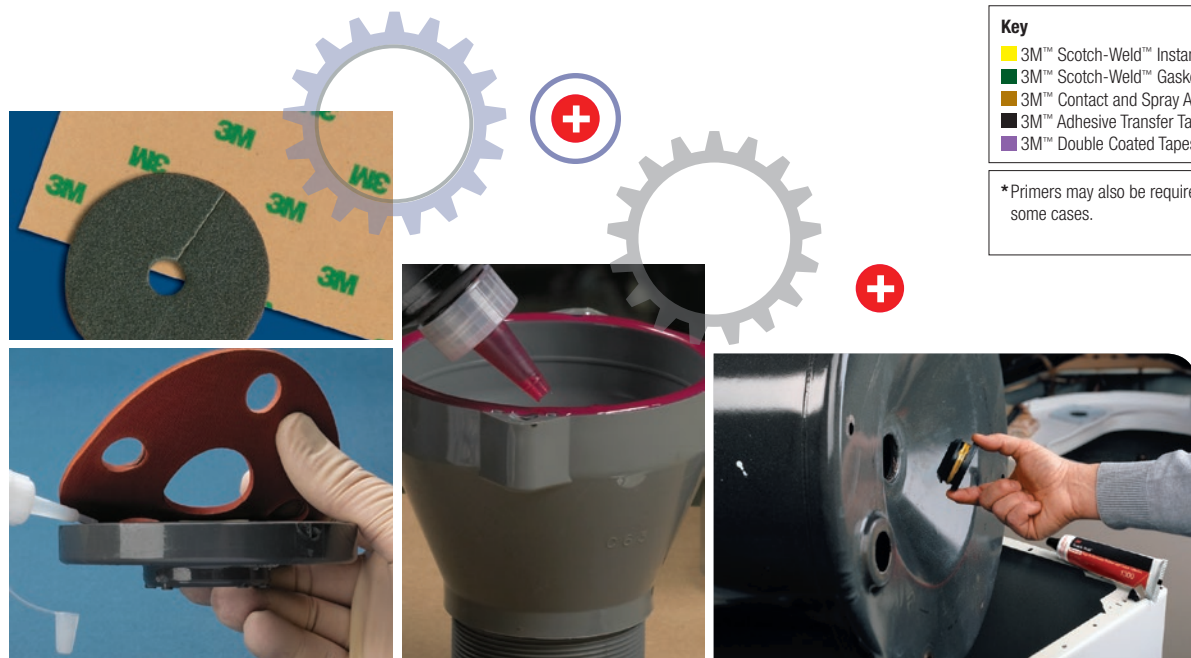
Attribute	VHB Tapes	Instant Adhesives	Gasket Makers	Contact and Spray Adhesives	Adhesive Transfer Tapes	Double Coated Tapes
High Strength Rubber Bonding	N/A	+++	N/A	++	+	+
Temperature and Solvent Resistance	+++	+	+++	+++	+++	+++
Ease of Application	+++	++	++	+	+++	+++
Rate of Strength Build	+++	+++	+	+++	+++	+++

## Gasket Attachment Assembly Solutions

	Metal	Glass	Paint	Plastics: HSE	Plastics: LSE
Rubber (EPDM, Santoprene®)	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 4799</li> <li>■ *468MP, 950</li> <li>■ 9832, XT6110</li> </ul>	<ul style="list-style-type: none"> <li>■ 4799</li> <li>■ *468MP, 950</li> <li>■ 9832, XT6110</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 4799</li> <li>■ *468MP, 950</li> <li>■ 9832, XT6110</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 4799</li> <li>■ *468MP, 950</li> <li>■ 9832, XT6110</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 4799</li> <li>■ *9472LE, 950</li> <li>■ 9832, XT6110</li> </ul>
Silicone Gaskets	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ GM18 replace gasket</li> <li>■ 91022</li> <li>■ 9731, 96042</li> </ul>	<ul style="list-style-type: none"> <li>■ 91022</li> <li>■ 9731, 96042</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 91022</li> <li>■ 9731, 96042</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 91022</li> <li>■ 9731, 96042</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 91022</li> <li>■ 9731, 96042</li> </ul>
Neoprene	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 6035PC, 950</li> <li>■ 9832, XT6110</li> </ul>	<ul style="list-style-type: none"> <li>■ 1300</li> <li>■ 6035PC, 950</li> <li>■ 9832, XT6110</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 1300</li> <li>■ 6035PC, 950</li> <li>■ 9832, XT6110</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 1300</li> <li>■ 6035PC, 950</li> <li>■ 9832, XT6110</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 90</li> <li>■ 6035PC, 950</li> <li>■ 9832, XT6110</li> </ul>
Nylon	<ul style="list-style-type: none"> <li>■ PR100</li> <li>■ 9472LE, XP2112</li> </ul>	<ul style="list-style-type: none"> <li>■ 1099</li> <li>■ 9472LE, XP2112</li> </ul>	<ul style="list-style-type: none"> <li>■ PR100</li> <li>■ 1099</li> <li>■ 9472LE, XP2112</li> </ul>	<ul style="list-style-type: none"> <li>■ PR100</li> <li>■ 1099</li> <li>■ 9472LE, XP2112</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 90</li> <li>■ 9472LE, XP2112</li> </ul>
PTFE	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ GM18 replace gasket</li> <li>■ 950</li> </ul>	<ul style="list-style-type: none"> <li>■ 9472LE, XP2112</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 9472LE, XP2112</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 9472LE, XP2112</li> </ul>	<ul style="list-style-type: none"> <li>■ *PR100</li> <li>■ 9472LE, XP2112</li> </ul>

**3M™ VHB™ Tape replaces gaskets on many substrates listed in the chart.**

**3M™ Scotch-Weld™ Gasket Makers are suitable to replace gaskets in metal to metal applications.**



### Key

- 3M™ Scotch-Weld™ Instant Adhesives
- 3M™ Scotch-Weld™ Gasket Makers
- 3M™ Contact and Spray Adhesives
- 3M™ Adhesive Transfer Tapes
- 3M™ Double Coated Tapes

\*Primers may also be required in some cases.

This guide lists products that are commonly used for this specific application. It is important that the customer evaluates these suggested products in their specific application.