



Super Strength Molding Tape

03609 • 03614 • 03615 • 03616

Technical Data Sheet

July, 2014

| 3M Part No.(s) | 3M Part Descriptor(s) |
|----------------|---|
| 03609 | 1/2 in. x 5 ft. (12.7 mm x 1.5 m), 24 rolls/case |
| 03614 | 1/2 in. x 15 ft. (12.7 mm x 4.6 m), 24 rolls/case |
| 03615 | 7/8 in. x 5 ft. (22 mm x 1.5 m), 24 rolls/case |
| 03616 | 7/8 in. x 15 ft. (22 mm x 4.6 m), 24 rolls/case |

Product Description 3M™ Super Strength Molding Tape is designed for attaching vehicle body side moldings, trim and emblems. This tape consists of a medium-density foam core with high performance adhesives for good conformability and great adhesion to a variety of automotive surfaces. 3M™ Super Strength Molding Tape will create a strong bond with both painted and unpainted automotive surfaces. The foam core has enhanced properties that allow it to elongate and relax when put under load, which minimizes the stress along where the adhesive bonds to the vehicle surface. The liner makes it easy to cut to size for no-mess application with a variety of projects.

| Features, Advantages, Benefits | Features | Advantages | Benefits |
|--------------------------------|--|--|---|
| | 1. High performance acrylic adhesive provides strong bonding | 1. Enhanced properties allow the foam core to elongate and relax when put under load minimizing stress on the adhesive bond line for a stronger hold | 1. Easy to cut to size for no-mess application |
| | 2. Designed for use on both painted and unpainted vehicle surfaces | 2. Proprietary acrylic adhesive allows for strong bond with a variety of automotive surfaces | 2. Liner on one side makes this double-sided tape easy to use |
| | 3. Good conformability for use on multiple vehicle areas | 3. Medium-density foam core provides a balance between conformability and strength | 3. Can be used to attach moldings as well as other trims |

Typical Physical Properties

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

| | |
|----------------------|--|
| Thickness | 0.045 in (1.14 mm) |
| Density | 43 lbs/ft ³ (608 kg/m ³) |
| Foam | Dark Gray Acrylic |
| Adhesive | AR7 High Performance Acrylic Adhesive - Liner side DS4 High Performance Acrylic Adhesive - Non-liner side |
| Release Liner | Red Polyethylene |

3M™ Super Strength Molding Tape

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Product Uses 3M™ Super Strength Molding Tape is used to attach vehicle body side moldings, trim and emblems to both painted and unpainted vehicle surfaces.

Performance Properties **Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.**

After conditioning for 72 hours at 72°F (22°C), 0.5 in width tape requires:

- 21 lbs (9.5 kg) for breakaway peel
- 11 lbs (5.0 kg) for continuing peel

At 158°F (70°C) 0.5 in width tape exceeds 100 hours under static shear test.

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- Directions for Use**
1. Mark trim piece location with masking tape. Remove previous tape from part and vehicle.
 2. Thoroughly clean both surfaces with an appropriate 3M cleaner to remove any wax or silicone. Finish by wiping both surfaces with rubbing alcohol* and a fresh clean cloth or paper towel. Allow to dry completely.
 3. Without removing the liner apply the molding tape to the entire length of the body side molding or trim piece. Cut the tape flush with the end of the molding.
 4. When you are ready to apply the molding or trim piece to your vehicle, remove the liner from the molding tape.
 5. Press part firmly onto vehicle. Firm application pressure improves bond strength.

* Please consult Federal, State and Local Regulations. State Volatile Organic Compound (VOC) regulations may prohibit the use of certain alcohol solutions or solvents. You should check with your state environmental authorities to determine whether use of a solution or solvent is restricted or prohibited. When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use. Some of the products we recommend using may require the use of Personal Protection Equipment (PPE) such as gloves and/or adequate ventilation/respirators. Consult the product SDS for PPE recommendations as well as other recommended handling procedures.

Product Uses This tape is designed for use on body side moldings, rocker panel moldings, wind and rain deflectors, wheel lip moldings, luggage rack slats, and rear spoilers. The applications for 3M™ Super Strength Molding Tape include but are not limited to these typical applications.

Storage and Handling Apply to surfaces above 65°F (18°C). When using adhesives and cleaners, carefully follow all manufacturers' safety instructions. Optimum storage conditions are 22°C (72°F) and 50% relative humidity.

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Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product. See link below:

http://solutions.3m.com/wps/portal/3M/en_US/MSDS/Search/?gsaAction=msdsSRA&msdsLocate=en_US

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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For Additional Health and Safety Information



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