



3M™ Acrylic Foam Tape PX5000 Series

Frequently Asked Questions - External

General Product Information

- Q.** What is 3M™ Acrylic Foam Tape Series PX5000?
- A.** 3M Series PX5000 tapes are an advanced line of products featuring 3M™ Acrylic Foam Tape technology designed for adhesion to Low Surface Energy (LSE) and Medium Surface Energy (MSE) substrates without the need for adhesion promoter or other surface pre-treatment methods.
- Q.** What makes 3M Series PX5000 tapes stick without adhesion promoter or other pre-treatments?
- A.** This new tape utilizes ZX adhesive – a new to the world, proprietary 3M technology – on both sides of the tape to ensure compatibility with a variety of LSE and MSE substrates and automotive clear coats.
- Q.** How is this product different from the existing 3M “Primerless” line of products featuring TX-1 adhesive?
- A.** Although impressive for their time, the TX-1 line of adhesives does not offer high temperature holding power required by many OEMs in their specifications today. The ZX adhesive has been developed to provide good initial tack, excellent adhesive build, and high temperature holding performance on a variety of low and medium surface energy substrates.
- Q.** What types of applications would be good targets for this tape?
- A.** Any application that requires bonding performance to medium and low surface energy plastics and/or chrome as well as medium to difficult paints, including: sensor bonding, pillar garnishes, body-side moldings, step plates, vent visors, and chrome appliques. Contact a 3M technical service representative for more details.
- Q.** What are LSE Plastics?
- A.** The LSE family of plastics consists of PP, PP/EPDM, and TPO. If you have a question as to whether or not your particular substrate is LSE, please contact a 3M technical service representative.
- Q.** What about difficult paints and clear coats?
- A.** The PX5000 series will offer a general performance increase over existing AR7 products on most automotive clear coats – especially the more difficult clear coats. Work with your 3M technical service engineer to develop testing specific to the requirements of your applications and clear coats to understand how the ZX adhesive system can perform for you.
- Q.** What calipers (thicknesses) and configurations are available?
- A.** The product is available in the 0.5 mm, 0.8 mm, 1.1 mm, and 1.5 mm caliper configurations and in all standard widths provided by 3M today.
- Q.** Will the product be available with a paper liner?
- A.** A paper liner version is in development.

Processing

- Q:** Is the product die-cuttable?
- A:** Yes, this product is die-cuttable. Die-cuttability is in line with existing 3M™ Acrylic Foam Tape products.
- Q:** What tabbing options are available for this product?
- A:** 3M Acrylic Foam Tape PX5000 Series tapes are available with a heat-tabbable liner option: 3M™ Acrylic Foam Tape PX5000T and PX5000DT Series. 3M™ Tabbing Tape 5400 or 3M™ Tabbing Tape 5081 is recommended for use with 3M Acrylic Foam Tape PX5000T and PX5000DT Series tapes. For PSA tabbing we recommend 3M™ Tabbing and Splicing Tape 5699 and use of an extended liner tab.

Processing (continued)

- Q.** Can I use a primer with PX5000 Series Primerless tape?
- A.** PX5000 Series is designed to be used without primer. If an application requires primer, PX5000 series tapes can still be used. Please work with a 3M technical service representative to determine viability of PX5000 series tapes for your application.
- Q.** What are the recommended maximum and minimum operating temperatures?
- A.** Recommend operating range is 18 - 40°C (64.4 - 104°F). For temperatures outside this range contact your 3M technical service representative.

Product Performance

- Q:** How is the liner release?
- A:** This product features a recently introduced SC-12 liner on levelwound rolls that offers excellent release characteristics. GL-1B and GL-3B liners are used on planetary rolls of the product to offer excellent release. Contact your 3M technical service representative for a product sample.
- Q:** How is the performance on TPO (thermoplastic polyolefin), PP (polypropylene), and PP+EPDM (ethylene propylene diene monomer)?
- A:** This product has been specifically developed to provide the highest level of performance on TPO, PP and PP/EPDM without the use of adhesion promoter. Many applications that historically would have required adhesion promoter can now be achieved with the use of the PX5000 series alone. Some applications are too challenging for any primerless tape – including parts with difficult ribbed landing configurations or extreme part mismatch. Work with your 3M technical representative for more details.
- Q.** Can this tape be used with seals – EPDM, TPE, PVC (plasticized rubbers)?
- A.** This product can be used with an adhesion promoter to adhere to EPDM, TPE, and PVC. The product is not designed for primerless adhesion to these materials.
- Q:** Are OEM specification data packages available?
- A:** OEM specification data packages are available. If you have an OEM application and need specification data, contact a 3M technical service representative for technical support.

Delivery/Supply

- Q.** What is the minimum order quantity (MOQ)?
- A.** Contact your local 3M customer service representative.
- Q.** What is the lead time for the product?
- A.** Lead times are determined by receiving location, local import regulations, and product availability. Contact your 3M customer representative for additional information.

Pricing

- Q.** How much will this product cost?
- A.** The product is priced competitively and in line with the current portfolio of products. The price reflect the appropriate value to customers and allows for total system savings for lower overall costs through production efficiencies, lower cost of poor quality, and EHS improvements. Contact your local 3M representative.

Source of Supply

- Q.** Where is the product produced?
- A.** The product is produced entirely in 3M manufacturing facilities.
- Q.** When may we audit the plant?
- A.** The quality system may be audited, but due to the confidential nature of the process we are unable to offer tours of operations.
- Q.** Where are the raw materials sourced?
- A.** The formulation is confidential. The raw materials are sourced from multiple suppliers around the world.

Quality

- Q.** How do you ensure the continuity of product quality?
- A.** 3M uses ISO 16949 standards to ensure a robust quality system is in place and utilizes regular quality control in the labs to measure the products quality.
- Q.** How is the dimension of the product controlled? What test methods are used for dimension measurement? What is the test method for dimension measurement? Can you meet the dimension tolerance +/- 1.0mm requirement?
- A.** Procedures are in place to ensure products will meet all aspects of product specifications.
- Q.** Is 3M able to provide a statement of quality assurance?
- A.** Your 3M quality engineer or sales representative can provide you with a statement of quality assurance.

Samples

- Q:** What is the process for ordering prototypes?
- A:** Contact your local 3M representative.

Contact Information

The information provided in this technical document is intended as a guide for these products. For more information or help in selecting a 3M product for an application, please contact your 3M technical service representative or call 1-800-328-1684.

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