



GM Specification 9985281

Annual Test Data

Technical Bulletin

The 3M IATD Quality Laboratory tested the following tapes to the Automotive Specification 9985281. The results of the testing are provided below in the following information. Tapes not listed on this document have not been tested to this specification.

3M™ Double Coated Tape 9490LE
 3M™ Adhesive Transfer Tapes 6035PC and 6035PL
 3M™ Adhesive Transfer Tape 6038PC
 3M™ Adhesive Transfer Tapes 9472, 950, 9672 and 969

3M™ Adhesive Transfer Tapes 9472LE and 9672LE
 3M™ Adhesive Transfer Tape 9627
 3M™ Double Coated Tape 9629PC
 3M™ Double Coated Tape 9495MP
 3M™ Double Coated Tape 9495LE

Approved by IATD Quality:

Kelly R. Wisnewski
 Test Coordinator

3M™ Double Coated Tape 9490LE			Expiration Date: March 31, 2022				
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)	
A024067942-002	Stainless Steel	*Adhesive Thickness					
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.139	N/A	
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.139	
		Color	Visual	Translucent	Pass	Pass	
		Mass	9985281	0.06 to 0.20 kg/m ²	.177	0.176	
		Solids Content	9985281 Appendix A	94.5% min	98.4	98.7	
	Stainless Steel	Adhesion to Steel					
		As Received 3M™ Laminating Adhesive 300MP	ASTM D3330 E	535 N/m min	710	N/A	
		90 Day Aged 3M™ Laminating Adhesive 300MP	ASTM D3330 E	420 N/m min	N/A	827	
		As Received 3M™ High Performance Acrylic Adhesive 300LSE	ASTM D3330 E	535 N/m min	690	N/A	
		90 Day Aged 3M™ High Performance Acrylic Adhesive 300LSE	ASTM D3330 E	420 N/m min	N/A	676	
		Shear Adhesion	ASTM D3330 A	3000 mins @ 23°C (73°F)	3000+	3000+	
		Liner Removability	ASTM D3330 D	45 N/m max	--**	--**	

*Adhesive thickness values include 0.0127mm carrier film

**Data pending testing

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3M™ Adhesive Transfer Tape 6035PC and 6035PL					Expiration Date: August 31, 2022	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
20046 (6035PC)	Stainless Steel	Adhesive Thickness				
20264 (6035PL)		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.112	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.114
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.06 to 0.20 kg/m ²	0.126	0.129
		Solids Content	9985281 Appendix A	94.5% min	99.2	98.8
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	1209	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	1175
		Stainless Steel	Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+
		Liner Removability				
		6035PC	ASTM D3330 D	45 N/m max	39.6	36.8
		6035PL	ASTM D3330 D	45 N/m max	--*	--*

*Data pending testing

3M™ Adhesive Transfer Tape 6038PC					Expiration Date: July 31, 2022	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
21050	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.112	NA
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	NA	0.115
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.118 to 0.219 kg/m ²	0.130	0.128
		Solids Content	9985281 Appendix A	94.5% min	98.8	99.5
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	1217	NA
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	NA	1050
		Stainless Steel	Shear Adhesion	ASTM D3654 A	25 min @ 23°C (73°F)	25+
	Liner Removability	ASTM D3330 D	45 N/m max	32.2	35.4	

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3M™ Adhesive Transfer Tape 9472, 9672, 950 and 969					Expiration Date: August 31, 2022	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
20343 (950)	Stainless Steel	Adhesive Thickness				
20245 (9472)		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.143	N/A
9162 (9672)		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.144
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.06 to 0.20 kg/m ²	0.135	0.137
		Solids Content	9985281 Appendix A	94.5% min	99.2	98.8
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	963.5	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	933.8
		Stainless Steel	Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+
		Liner Removability				
		950	ASTM D3330 D	45 N/m max	20.0	22.1
		9472	ASTM D3330 D	45 N/m max	10.5	10.5
		9672	ASTM D3330 D	45 N/m max	13.7	13.0

*Data pending testing

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3M™ Adhesive Transfer Tape 9472LE, 9672LE				Expiration Date: August 31, 2022			
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)	
B055593152009 (9472LE) B077069279016 (9672LE)	Stainless Steel	Adhesive Thickness					
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.147	N/A	
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.151	
		Color	Visual	Translucent	Pass	Pass	
		Mass					
		9472LE	998521	0.06 to 0.20 kg/m ²	0.134	0.128	
		9672LE	998521	0.06 to 0.20 kg/m ²	0.131	0.130	
		Solids Content	9985281 Appendix A	94.5% min	99.1	99.0	
		Adhesion to Steel					
		As Received	ASTM D3330 E & 9985281	535 N/m min	688.6	N/A	
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	676.0	
		Stainless Steel	Shear Adhesion	ASTM D3654 A	3000 min @ 23°C (73°F)	3000+	3000+
		Liner Removability					
		9472LE	ASTM D3330 D	45 N/m max	37.1	40.6	
9672LE	ASTM D3330 D	45 N/m max	--*	--*			

*Data pending testing

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3M™ Adhesive Transfer Tape 9627 Expiration Date: September 30, 2022

Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
20055	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.123	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.130
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.06 to 0.20 kg/m ²	0.132	0.134
		Solids Content	9985281 Appendix A	94.5% min	98.7	99.2
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	972.7	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	968.1
		Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+	25+
		Liner Removability	ASTM D3330 D	45 N/m max	--*	--*

*Data pending testing

3M™ Double Coated Tape 9629PC Expiration Date: September 30, 2022

Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
21119	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.113	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	--*
		Color	Visual	Translucent	Pass	--*
		Mass	9985281	0.06 to 0.20 kg/m ²	0.110	--*
		Solids Content	9985281 Appendix A	94.5% min	99.8	--*
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	801.4	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	--*
		Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+	--*
		Liner Removability	ASTM D3330 D	45 N/m max	23.5	--*

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3M™ Double Coated Tape 9495MP					Expiration Date: October 31, 2022		
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)	
9236067392001	Stainless Steel	Adhesive Thickness					
			As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.131	N/A
			90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.137
		Color	Visual	Translucent	Pass	Pass	
		Mass	9985281	0.06 to 0.20 kg/m ²	0.151	0.151	
		Solids Content	9985281 Appendix A	94.5% min	99.6	99.5	
		Adhesion to Steel					
			As Received	ASTM D3330 E & 9985281	535 N/m min	654.6	N/A
			90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	650.4
		Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+	25+	
		Liner Removability	ASTM D3330 D	45 N/m max	30.1	29.8	

3M™ Double Coated Tape 9495LE					Expiration Date: December 31, 2021		
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)	
A039068007-002	Stainless Steel	Adhesive Thickness					
			As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.165	N/A
			90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.168
		Color	Visual	Translucent	Pass	Pass	
		Mass	9985281	0.06 to 0.20 kg/m ²	0.170	0.171	
		Solids Content	9985281 Appendix A	94.5% min	98.5	99.1	
		Adhesion to Steel					
			As Received	ASTM D3330 E & 9985281	535 N/m min	630	N/A
			90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	601
		Shear Adhesion	ASTM D3654 A & 9985281	3000 min @ 23°C (73°F)	3000+	3000+	
		Liner Removability	ASTM D3330 D	45 N/m max	41.7	39.9	

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