



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 9495 LE

Approved by IATD Quality:

Steven Winship
Test Coordinator

3M™ Double Coated Tape 9490LE			Expiration Date: March 31, 2023				
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)	
B182069539-002	Stainless Steel	*Adhesive Thickness					
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.164	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	.174	0.174	
		Solids Content	9985281 Appendix A	94.5% min	98.3	98.4	
	Stainless Steel	Adhesion to Steel					
		As Received 3M™ Laminating Adhesive 300MP	ASTM D3330 E	535 N/m min	519.2*	N/A	
		90 Day Aged 3M™ Laminating Adhesive 300MP	ASTM D3330 E	420 N/m min	N/A	502.3	
		As Received 3M™ High Performance Acrylic Adhesive 300LSE	ASTM D3330 E	535 N/m min	644.5	N/A	
		90 Day Aged 3M™ High Performance Acrylic Adhesive 300LSE	ASTM D3330 E	420 N/m min	N/A	623.8	
		Shear Adhesion	ASTM D3330 A	3000 mins @ 23°C (73°F)	3000+	3000+	
		Liner Removability	ASTM D3330 D	45 N/m max	38.4	46.9	

Adhesive thickness values include 0.0127 mm carrier film

*Outside of Specification

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3M™ Adhesive Transfer Tape 6035PC and 6035PL					Expiration Date: August 31, 2023	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
(6035PC)	Stainless Steel	Adhesive Thickness				
(6035PL)		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.111	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.110
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.06 to 0.20 kg/m ²	0.125	0.125
		Solids Content	9985281 Appendix A	94.5% min	99.6	98.6
		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	33.6	24.3
		6035PL	ASTM D3330 D	45 N/m max	34.0	25.7

3M™ Adhesive Transfer Tape 6038PC					Expiration Date: July 31, 2023	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
22075	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.195	NA
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	NA	0.193
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.118 to 0.219 kg/m ²	0.205	0.222
		Solids Content	9985281 Appendix A	94.5% min	98.7	98.2
		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	22.0	28.4

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3M™ Adhesive Transfer Tape 9472, 9672, 950 and 969					Expiration Date: August 31, 2023	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
(950)	Stainless Steel	Adhesive Thickness				
(9472)		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.125	N/A
(9672)		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.132
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.06 to 0.20 kg/m ²	0.137	0.134
		Solids Content	9985281 Appendix A	94.5% min	99.4	99.5
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	956.9	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	946.7
		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	36.4	9.79*
		9472	ASTM D3330 D	45 N/m max	11.4	9.8
		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, 2023			
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
(9472LE) (9672LE)	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.133	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.126
		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	0.129
		Solids Content	9985281 Appendix A	94.5% min	98.5	98.5
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	694.9	N/A
	90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	665.1	
	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	47.5	62.1
		9672LE	ASTM D3330 D	45 N/m max	40.6	43.7

*Data pending testing

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3M™ Adhesive Transfer Tape 9627					Expiration Date: September 30, 2023	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
	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	99.3	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	44.8	41.7

3M™ Double Coated Tape 9629PC					Expiration Date: September 30, 2023	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.124	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.131
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.06 to 0.20 kg/m ²	0.110	0.111
		Solids Content	9985281 Appendix A	94.5% min	98.4	98.4
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	987.7	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	989.1
		Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+	25+
		Liner Removability	ASTM D3330 D	45 N/m max	44.8	39.6

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3M™ Double Coated Tape 9495MP				Expiration Date: October 31, 2023		
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	0.132	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.136
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.06 to 0.20 kg/m ²	0.145	0.144
		Solids Content	9985281 Appendix A	94.5% min	99.0	99.3
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	531.2	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	417.6
		Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+	25+
		Liner Removability	ASTM D3330 D	45 N/m max	30.2	29.7

3M™ Double Coated Tape 9495LE				Expiration Date: December 31, 2023		
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	0.156
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.06 to 0.20 kg/m ²	0.172	0.175
		Solids Content	9985281 Appendix A	94.5% min	99.2	99.3
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	--*	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	--*
		Shear Adhesion	ASTM D3654 A & 9985281	3000 min @ 23°C (73°F)	3000+	3000+
		Liner Removability	ASTM D3330 D	45 N/m max	--*	--*

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