Masking and Bonding Powder Coating Solutions
3M Powder Coat Masking and Bonding Solutions

Masking

3M™ Powder Coating 8991 and 8992 Polyester Masking Tapes
With pressure sensitive silicone adhesive, 3M™ Polyester Tapes 8991 and 8992 grab on contact for reliable masking in most powder coat painting operations with baking up to 204°C.

- Clean removal, with a sharp clean paint edge. Also used for masking in electroplating, anodising and as a flashbreaker.
- 8991 Blue – 0.025mm polyester backing and 0.036mm silicone adhesive.
- 8992 Green – 0.052mm polyester backing and 0.030mm silicone adhesive.
- Resists shrinking, curling and edge lifting.
- Available with polyester liners for die-cutting and conversion.

Pre-Powder Coat Bonding

3M™ VHB™ GPH General Purpose High Temperature
A firm acrylic adhesive allows 3M VHB GPH to deliver a high strength bond between metal parts. The composition of the 3M VHB GPH family allows the tape to resist high temperatures making it ideal for use on jobs that go through a powder coating process.

3M™ Scotch-Weld™ Structural Acrylic Adhesives DP8805NS and DP8405NS
3M next generation structural acrylic adhesives provide a faster bond, deliver higher impact resistance and high temperature performance, helping you to build better products and improve productivity.

- Fast curing, low odour.
- Non-sag.
- 5 Minutes Work Life.
- Time to handling strength 7 minutes (DP8805NS) and 15 minutes (DP8405NS) approximately.

3M™ Scotch-Weld™ Acrylic Adhesives strength at high temperature
Tested to ASTM D1002 Standard Test Method

- Ability to hold weight at powder coat temperatures.
- Parts bonded at room temperature for 30 minutes.
- 30 Minutes at 200°C

3M™ Scotch-Weld™ Acrylic Adhesives strength at room temperature after going through powder coat temperatures
Tested to ASTM D1002 Standard Test Method

- Etched Aluminium Substrates
- Tested at 23°C 24 Hours after heat soak
Why choose a tape or adhesive?

Benefits of Tape and Adhesive Bonding Solutions;
✓ Improves aesthetics
✓ Weight reduction
✓ Quick and easy application

Benefits of a tape solution;
✓ Very strong bond that can replace spot welds and rivets
✓ Provides instant handling

Benefits of an adhesive solution:
Even stronger bonds that give structural strength
✓ Smaller bond areas required
✓ Quick cure time
✓ Repositionable

Post Powder Coat Bonding
3M™ VHB™ Tape 5952
3M VHB Tape 5952 acrylic foam tape gives a strong bond on powder coated surfaces and difficult to stick surfaces.

3M™ Scotch-Weld™ Structural Acrylic Adhesive DP8405NS
✓ Over three times the impact strength of conventional acrylic adhesives.
✓ Fast curing with an 18 months shelf life.

3M™ Scotch-Weld™ Urethane Adhesive DP620NS
✓ High performing two component polyurethane.
✓ Easy mixing, exceptional non-sag formulation.
✓ Suitable for bonding to a wide variety of substrates including painted surfaces.

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<table>
<thead>
<tr>
<th>Product Description and Features</th>
<th>3M Product</th>
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<tbody>
<tr>
<td>0.025mm polyester backing.</td>
<td>3M™ 8991 Polyester Powder Coat Masking Tape*</td>
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<td>0.036mm silicone adhesive.</td>
<td>*Also available in linered and log roll format.</td>
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<tr>
<td>0.052mm polyester backing.</td>
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<td>0.030mm silicone adhesive.</td>
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<td>High temperature resistance (150°C Continuous, 230°C Intermittent)</td>
<td>3M™ VHB™ GPH</td>
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<tr>
<td>Fast curing, low odour</td>
<td>3M™ Scotch-Weld™ Structural Acrylic Adhesive DP8805NS</td>
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<tr>
<td>Bondline control 250μm</td>
<td>Non-sag</td>
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<tr>
<td>5 Minutes Work Life*</td>
<td>Time to Handling Strength 7 minutes*</td>
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<tr>
<td>10 Minutes Structural Strength*</td>
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<td>Fast curing</td>
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<tr>
<td>5 Minutes Work Life*</td>
<td>Time to Handling Strength 15 minutes*</td>
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<tr>
<td>20 Minutes Structural Strength*</td>
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<tr>
<td>Adheres to painted and difficult to bond surfaces usually without the need for specialist surface preparation including priming or abrading</td>
<td>3M™ VHB™ Tape 5952</td>
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<td>Best Gap Filling</td>
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<td>Low temperature flexibility</td>
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*All times quoted are approximate

Important Notice: The information contained in this brochure is based on tests and data which 3M believes to be reliable, but the accuracy or completeness of such statements and information is not guaranteed. The user is responsible for determining whether a specific 3M Adhesive and or Tape is suitable for the purpose intended and for the user’s method of application. All questions of liability relating to 3M Adhesives and or Tapes are governed by our terms of sale subject, where applicable to prevailing law.