

3M™ VHB™ Structural Glazing Tape

Process Steps

1. Select the “Start A Project” button to fill out the Project Initiation form.

While filling out this form, upload the drawing attachment(s) which will notify 3M of the new project.

2. 3M Application Engineer completes the Application Review.

An email is sent to the customer and the selected 3M Distributor which includes the 3M Application Review document. A mailing label is also provided to send 3M project specific substrates for adhesion testing. This testing must be completed before the project start-up training. Allow 10 working days for completion of the adhesion testing after 3M receives the project substrates.

3. 3M Application Engineer completes the adhesion tests.

An email is sent to the customer and the 3M Distributor which includes the 3M Adhesion Test Report and the project specific Standard Operating Procedure (SOP). The customer may then order the 3M™ VHB™ Structural Glazing Tape (VHB SGT) B23F or G23F and appropriate 3M cleaner/primers. The customer should coordinate this with their 3M Distributor representative and set up a date for the mandatory training session.

Before the training session and start-up of the VHB SGT bonding process, ensure these items are in place. [Click here](#) for a list of required items required to start the project.

4. 3M Distributor or 3M representative conducts the mandatory project start-up training session.

Training is done per the SOP for all operators that will be involved in the 3M™ VHB™ Structural Glazing Tape (VHB SGT) bonding process. Untrained operators are not allowed to work with VHB SGT or be involved in the cleaning, priming or tape application steps as outlined in the SOP. All trained workers must sign a VHB SGT Training Form. Production may begin immediately after the training session.

5. 3M Distributor or a 3M representative conducts random process audits.

Audits are done during the production process to ensure there is no deviation from the SOP and if needed, any deviation must be corrected. Production process audits will be documented by the signing of the VHB SGT Process Audit Form. Audits must be documented to obtain a 3M Application Warranty.