

3M™ Acrylic Foam Tape GT6000 Series

Technical Data Sheet

General Description

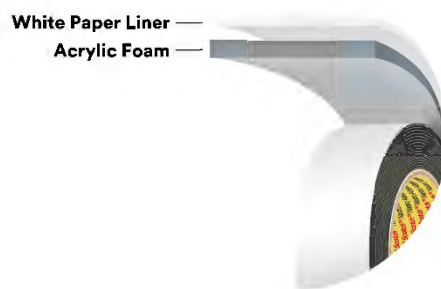
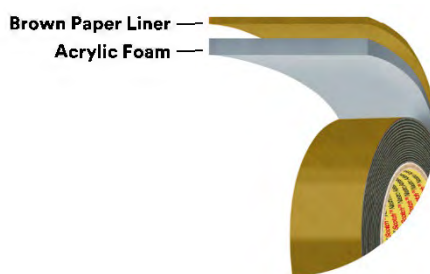
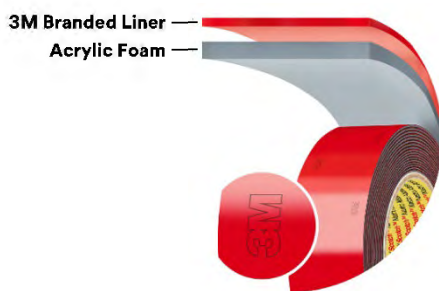
3M™ Acrylic Foam Tape Series GT6000 demonstrates good adhesion to many automotive surfaces, good inner strength, excellent longterm stability and very good adaptability to the bonded areas.

3M Tape GT6000 Series offers the following key features:

- Provides final adhesion and holding power to automotive paints and substrates
- Follows the shrinkage and elongation of the plastic part caused by temperature change, and has good stress relaxation properties
- Good initial adhesion allows immediate further processing often without temporary support or fixtures
- Wide range of operating (on part) temperatures (-40°C - 120°C) allows for process optimization as tape can be applied before paint process
- Meets OEM requirements for temperature, weather, and solvent resistance
- Suitable for both manual and automatic application processes

Typical applications are attachments of exterior add-on-parts such as body side moldings, trims or emblems/inserts.

Product Construction



Physical Properties

Property	GT6006/GT6006P	GT6008/GT6008P	GT6012/GT6012P
Core	Acrylic Foam Core		
Core Color	Gray		
Density	700 +/- 30 kg/m³		
Thickness*	0.6 mm +/- 0.085 mm	0.8 mm +/- 0.10 mm	1.2 mm +/- 0.10 mm
Liner	• 3M Branded Liner: subtle 3M logo, red polyethylene • Brown paper liner, both sides siliconized	• 3M Branded Liner: subtle 3M logo, red polyethylene • White paper liner, both sides siliconized	
Adhesive	Self-Stick		

*Liner thickness is not included

Tabbing

- An extended liner tab is recommended.

Consult application guidelines for detailed product use instructions.



Performance Properties

3M understands that development of automotive applications is typically driven by specification requirements and performance. Each OEM has their own unique criteria and 3M continues to develop products to meet those demands. Please contact your 3M application engineer for support and to obtain specific test data.

Typical performance of 3M™ Acrylic Foam Tape GT6000 Series is shown below. Peel and shear values depend on substrate characteristics and/or paint composition. These values are for reference only, and not to be used for specification purposes. For 3M product specification values please see the certificate of analysis.

Floating Roller Peel Test, v=50mm/min			
Substrate	Conditions	Typical performance value (N/cm)	
Axalta Supermar (MSE clear coat)	24 h at room temperature	GT6006	12
		GT6008	13
		GT6012	13
	After 48 h at -40°C, tested at room temperature	GT6006	13
		GT6008	14
		GT6012	14
	After 10 days at 90°C, tested at room temperature	GT6006	35
		GT6008	42
		GT6012	47
	After 10 days at 70°C and 100% humidity, tested at room temperature	GT6006	21
		GT6008	25
		GT6012	28
Dynamic shear test, v=50 mm/min			
Substrate	Conditions	Typical performance value (N/cm²)	
Axalta Supermar (MSE clear coat) and PP/EPDM+3M™ Adhesion Promoter 4298UV	24 h at room temperature	GT6006	113
		GT6008	116
		GT6012	98
	After 48 h at -40°C, tested at room temperature	GT6006	118
		GT6008	115
		GT6012	105
	After 10 days at 90°C, tested at room temperature	GT6006	139
		GT6008	147
		GT6012	124
	After 10 days at 40°C and 100% humidity + 8 h at 70°C, tested at room temperature	GT6006	88
		GT6008	80
		GT6012	76
Static Shear Holding Power, Minimum			
Substrate	Conditions	Typical performance value (min)	
Axalta Supermar (MSE clear coat) and PP/EPDM+3M™ Adhesion Promoter 4298UV	Area 3 cm², 6 N/cm², Room Temperature	GT6006	> 10000
		GT6008	524
		GT6012	875
	Area 3 cm², 2 N/cm², 70°C	GT6006	662
		GT6008	8790
		GT6012	> 10000

MSE = medium surface energy
Reference 3M test: Report-06-1022285-1

Shelf Life

For rolls with polyethylene liners: shelf life is three years from date of manufacturing when stored in general indoor warehouse conditions, defined as approximately 4°C-38°C (40°F-100°F) and 30-70% relative humidity. The optimum storage conditions are 22°C (72°F) and 50% relative humidity.

For rolls with paper liner: shelf life is two years from date of manufacturing when stored in general indoor warehouse conditions, defined as approximately 4°C-38°C (40°F-100°F) and 30-70% relative humidity. The optimum storage conditions are 22°C (72°F) and 50% relative humidity.

3M Acrylic Foam Tape GT6000 Series tapes should be stored in typical storage conditions for pressure-sensitive adhesives used within the automotive industry.

Levelwound rolls should be stored horizontally. During transportation, storage conditions are uncontrolled for a short period of time (a few days or weeks). This should not impact product performance. However, materials should not be stored in excess of the recommended conditions for extended periods.

Regulatory Information

The product is published as a material entry and is available for access on www.mdssystem.com. For product IMDS I.D. number, email requests to 3M-IMDSrequest@mmm.com.

Contact Information

The information provided in this technical document is intended as a guide for this product. For more information or help in selecting a 3M product for an application, please contact your 3M application engineering representative or [connect with a 3M expert](#).

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