



GMW 14892 Specification Revision July 2023

Adhesion Requirements for Bonded Interior Parts Automotive Interior Spec Testing

Technical Bulletin rev 4

May 2025

3M™ tested the following adhesives to the Automotive OEM Spec: GMW 14892 Adhesion Requirements for Bonded Interior Parts. The results of the testing are provided in the following information. Adhesives not listed on this document have not been tested to this specification.

Automotive specification testing was performed on lab substrates and not on actual automotive production parts. Additional testing by the converter, tier or supplier is needed to show that parts and adhesives meet such specification. Please carefully read the latest version of the automotive specification for further information.

Revision	Date	Comments
Revision 4	May 2025	Updated Dynamic Shear and Heat Aging results
Revision 3	March 2025	Add 59812LVC & 9490LE+
Revision 2	March 2024	Remove 56815LVC & 59812LVC
Revision 1	January 2024	Testing to 300MP+ adhesives, 59812LVC & 56815LVC
Original release	May 2021	Testing and bulletin complete

3M™ Adhesive Transfer Tape 9472LE/9672LE
3M™ Adhesive Transfer Tape 6035PC+/6035PL+
3M™ Adhesive Transfer Tape 9627
3M™ Adhesive Transfer Tape 950/9472
3M™ Low VOC Adhesive Transfer Tape 59812LVC

3M™ Double Coated Tape 93015LE
3M™ Adhesive Transfer Tape 9775WL+
3M™ Double Coated Tape 9832+/9832HL+
3M™ Double Coated Tape 9490LE+

Test	Test Condition / Environment	
180° Peel Adhesion 300mm / 12 inch per min	As Received 3.2.3.2	72 hours @ Room Temp
	Humidity 3.2.3.2.1	144 hours GMW14729 Option A: Water Fog
	Heat Age 3.2.3.2.2	24 hours @ 105°C / 221°F
	Environmental Cycle 3.2.3.2.3	GMW14124 Cycle M (2 cycles)
Shear Testing	Dynamic Lap Shear 3.2.4.1.1	2" per minute
	Static Shear : Dead Load 3.2.4.1.2	200g

Note: Data reported in this technical bulletin, for all test methods, is the average of three replicates using one typical lot of adhesive.

3M Low VOC Adhesive Transfer Tape 59812LVC

3.2.3.2 As received – 72 hour dwell @ Room Temp						
59812LVC	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	890.26	81.38	Clean peel from PP	
	ABS		975.30	89.15	Clean peel from ABS	

3.2.3.2.1 Humidity – GMW14729 Option A: Water Fog 144 hours						
59812LVC	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	873.01	79.80	Clean peel from PP	
	ABS		883.88	80.79	Clean peel from ABS	

3.2.3.2.2 Heat Aging – 24 hours @ 105°C / 221°F						
59812LVC	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	9.85	.90	Clean peel from PP	
	ABS		366.93	33.54	Clean peel from ABS	

3.2.3.2.3 Environmental Cycle – GMW14124 Cycle M (2 cycles)						
59812LVC	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	969.79	88.65	Clean peel from PP	
	ABS		673.54	61.57	Clean peel from ABS	

3.2.4.1.1 Dynamic Shear – As Received				
59812LVC	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		525
	ABS to ABS			737

3.2.4.1.1 Dynamic Shear – Cycle				
59812LVC	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		625
	ABS to ABS			548

3.2.4.1.2 Static Shear 200g				
59812LVC	Substrate	Adhesive Size		Requirement 24 hours
	PP	1" x 1"		Fail
	ABS			Pass

3M Adhesive Transfer Tape 9472LE / 9672LE

3.2.3.2 As received – 72 hour dwell @ Room Temp						
9472LE 9672LE	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1510.56	138.08	Clean peel from PP	
	ABS		1156.47	105.71	Clean peel from ABS	

3.2.3.2.1 Humidity – GMW14729 Option A: Water Fog 144 hours						
9472LE 9672LE	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1416.91	129.52	Slight cohesive	
	ABS		1177.44	107.63	Cohesive	

3.2.3.2.2 Heat Aging – 24 hours @ 105°C / 221°F						
9472LE 9672LE	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	31.51	4.19	Clean peel from PP	
	ABS		340.93	31.16	Clean peel from ABS	

3.2.3.2.3 Environmental Cycle – GMW14124 Cycle M (2 cycles)						
9472LE 9672LE	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	906.12	82.83	Clean peel from PP	
	ABS		1143.85	104.56	Cohesive	

3.2.4.1.1 Dynamic Shear – As Received				
9472LE 9672LE	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		579
	ABS to ABS			744

3.2.4.1.1 Dynamic Shear – Cycle				
9472LE 9672LE	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		292
	ABS to ABS			257

3.2.4.1.2 Static Shear 200g				
9472LE 9672LE	Substrate	Adhesive Size		Requirement 24 hours
	PP	1" x 1"		Fail
	ABS			Fail

3M Double Coated Tape 93015LE

3.2.3.2 As received – 72 hour dwell @ Room Temp						
93015LE	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1101.62	100.70	2 bond	
	ABS		1119.13	102.30	2 bond	

3.2.3.2.1 Humidity – GMW14729 Option A: Water Fog 144 hours						
93015LE	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1060.30	96.92	2 bond	
	ABS		1155.23	105.60	Cohesive	

3.2.3.2.2 Heat Aging – 24 hours @ 105°C / 221°F						
93015LE	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	2.01	0.18	Clean peel from PP	
	ABS		159.76	14.60	Clean peel from ABS	

3.2.3.2.3 Environmental Cycle – GMW14124 Cycle M (2 cycles)						
93015LE	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	657.20	60.07	Clean peel from PP	
	ABS		994.85	90.94	Cohesive	

3.2.4.1.1 Dynamic Shear – As Received				
93015LE	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		854
	ABS to ABS			1227

3.2.4.1.1 Dynamic Shear – Cycle				
93015LE	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		351
	ABS to ABS			418

3.2.4.1.2 Static Shear 200g				
93015LE	Substrate	Adhesive Size		Requirement 24 hours
	PP	1" x 1"		Fail
	ABS			Pass

3M Adhesive Transfer Tape 6035PC+/6035PL+

3.1.5.1 As received – 72 hour dwell @ Room Temp						
6035PC+/ 6035PL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	327.36	29.92	Clean peel from PP	
	ABS		770.54	70.43	Clean peel from ABS	

3.2.3.2.1 Humidity – GMW14729 Option A: Water Fog 144 hours						
6035PC+/ 6035PL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1280.75	117.07	Clean peel from PP	
	ABS		1583.38	144.73	Cohesive	

3.2.3.2.2 Heat Aging – 24 hours @ 105°C / 221°F						
6035PC+/ 6035PL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	708.44	64.76	Clean peel from PP	
	ABS		641.70	58.66	Cohesive	

3.2.3.2.3 Environmental Cycle – GMW14124 Cycle M (2 cycles)						
6035PC+/ 6035PL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	691.63	63.22	Clean peel from PP	
	ABS		1550.85	141.76	Slight cohesive	

3.2.4.1.1 Dynamic Shear – As Received				
6035PC+/ 6035PL+	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		420
	ABS to ABS			544

3.2.4.1.1 Dynamic Shear – Cycle				
6035PC+/ 6035PL+	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		317
	ABS to ABS			53

3.2.4.1.2 Static Shear 200g				
6035PC+/ 6035PL+	Substrate	Adhesive Size		Requirement 24 hours
	PP	1" x 1"		Fail
	ABS			Fail

3M Adhesive Transfer Tape 9775WL+

3.1.5.1 As received – 72 hour dwell @ Room Temp						
9775WL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	688.42	62.93	Clean peel from PP	
	ABS		1013.15	92.61	Clean peel from ABS	

3.2.3.2.1 Humidity – GMW14729 Option A: Water Fog 144 hours						
9775WL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	826.55	75.55	Clean peel from PP	
	ABS		1362.72	124.56	Clean peel from ABS	

3.2.3.2.2 Heat Aging – 24 hours @ 105°C / 221°F						
9775WL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	3.90	0.36	Clean peel from PP	
	ABS		518.96	47.44	Slt Cohesive	

3.2.3.2.3 Environmental Cycle – GMW14124 Cycle M (2 cycles)						
9775WL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	630.95	57.67	Clean peel from PP	
	ABS		1181.78	108.02	Clean peel from ABS	

3.2.4.1.1 Dynamic Shear – As Received				
9775WL+	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		436
	ABS to ABS			370

3.2.4.1.1 Dynamic Shear – Cycle				
9775WL+	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		142
	ABS to ABS			143

3.2.4.1.2 Static Shear 200g				
9775WL+	Substrate	Adhesive Size		Requirement 24 hours
	PP	1" x 1"		Fail
	ABS			Pass

3M Adhesive Transfer Tape 9627

3.2.3.2 As Received - 72 hour dwell @ Room Temp						
9627	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1544.65	141.19	Slight cohesive	
	ABS		1488.28	136.04	Clean peel from ABS	

3.2.3.2.1 Humidity – GMW14729 Option A: Water Fog 144 hours						
9627	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1465.38	133.95	Slight cohesive	
	ABS		1187.94	108.59	Cohesive	

3.2.3.2.2 Heat Aging – 24 hours @ 105°C / 221°F						
9627	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1.24	0.11	Clean peel from PP	
	ABS		8.53	0.78	Slight cohesive	

3.2.3.2.3 Environmental Cycle – GMW14124 Cycle M (2 cycles)						
9627	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1304.67	119.26	Cohesive	
	ABS		1011.44	92.45	Cohesive	

3.2.4.1.1 Dynamic Shear – As Received				
9627	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		644
	ABS to ABS			511

3.2.4.1.1 Dynamic Shear – Cycle				
9627	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		358
	ABS to ABS			44

3.2.4.1.2 Static Shear 200g				
9627	Substrate	Adhesive Size		Requirement 24 hours
	PP	1" x 1"		Fail
	ABS			Pass

3M Double Coated Tape 9832+ / 9832HL+

3.1.5.1 As received – 72 hour dwell @ Room Temp						
9832+ / 9832HL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	621.06	56.77	Clean peel from PP	
	ABS		899.92	82.26	Clean peel from ABS	

3.2.3.2.1 Humidity – GMW14729 Option A: Water Fog 144 hours						
9832+ / 9832HL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	493.90	45.15	Clean peel from PP	
	ABS		957.29	87.50	Clean peel from ABS	

3.2.3.2.2 Heat Aging – 24 hours @ 105°C / 221°F						
9832+ / 9832HL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	25.38	2.32	Clean peel from PP	
	ABS		550.43	50.31	Slight cohesive	

3.2.3.2.3 Environmental Cycle – GMW14124 Cycle M (2 cycles)						
9832+ / 9832HL+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	3.39	0.31	Clean peel from PP	
	ABS		910.68	83.24	Clean peel from ABS	

3.2.4.1.1 Dynamic Shear – As Received				
9832+ / 9832HL+	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		613
	ABS to ABS			630

3.2.4.1.1 Dynamic Shear – Cycle				
9832+ / 9832HL+	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		296
	ABS to ABS			204

3.2.4.1.2 Static Shear 200g				
9832+ / 9832HL+	Substrate	Adhesive Size		Requirement 24 hours
	PP	1" x 1"		Fail
	ABS			Pass

3M Adhesive Transfer Tape 950 / 9472

3.1.5.1 As received – 72 hour dwell @ Room Temp						
950 / 9472	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1435.44	131.21	Cohesive	
	ABS		1346.06	123.04	Cohesive	

3.2.3.2.1 Humidity – GMW14729 Option A: Water Fog 144 hours						
950 / 9472	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	1025.70	93.76	Cohesive	
	ABS		748.11	68.38	Cohesive	

3.2.3.2.2 Heat Aging – 24 hours @ 105°C / 221°F						
950 / 9472	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	38.51	3.52	Clean peel from PP	
	ABS		406.09	37.12	Cohesive	

3.2.3.2.3 Environmental Cycle – GMW14124 Cycle M (2 cycles)						
950 / 9472	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	436.54	39.90	Clean peel from PP	
	ABS		1023.80	93.58	Cohesive	

3.2.4.1.1 Dynamic Shear – As Received				
950 / 9472	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		1030
	ABS to ABS			953

3.2.4.1.1 Dynamic Shear – Cycle				
950 / 9472	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		325
	ABS to ABS			237

3.2.4.1.2 Static Shear 200g				
950 / 9472	Substrate	Adhesive Size		Requirement 24 hours
	PP	1" x 1"		Fail
	ABS			Fail

3M Double Coated Tape 9490LE+

3.1.5.1 As received – 72 hour dwell @ Room Temp						
9490LE+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	794.90	72.66	2 bond	
	ABS		663.78	60.68	2 bond	

3.2.3.2.1 Humidity – GMW14729 Option A: Water Fog 144 hours						
9490LE+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	971.29	88.78	2 bond	
	ABS		1290.26	117.94	cohesive	

3.2.3.2.2 Heat Aging – 24 hours @ 105°C / 221°F						
9490LE+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	5.14	0.47	Clean peel from PP	
	ABS		76.32	6.98	Clean peel from ABS	

3.2.3.2.3 Environmental Cycle – GMW14124 Cycle M (2 cycles)						
9490LE+	Substrate	Backing	AVG Peel N/m	AVG Peel oz/in	Observation	Requirement 525 N/m / 47.93 oz/in or substrate failure
	PP	2 mil PET	906.12	82.83	Clean peel from PP	
	ABS		9+41.90	86.10	Clean peel from ABS	

3.2.4.1.1 Dynamic Shear – As Received				
9490LE+	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		576
	ABS to ABS			472

3.2.4.1.1 Dynamic Shear – Cycle				
9490LE+	Substrate	Adhesive Size		Requirement 250 kPa
	PP to PP	1" x 1"		349
	ABS to ABS			295

3.2.4.1.2 Static Shear 200g				
9490LE+	Substrate	Adhesive Size		Requirement 24 hours
	PP	1" x 1"		Fail
	ABS			Fail

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