



# Technical Data Sheet

## 3M™ Adhesive Transfer Tape 6035PET+

### Product Description

Finite Element Analysis (FEA) data is available for this product at: [3m.com/FEA](https://www.3m.com/FEA)

3M™ Acrylic Adhesive Transfer Tape 6035PET+ is a 5 mil transfer tape formulated for low fog characteristics. The 300MP+ adhesive is suitable for bonding to most substrates including foams, fabrics and substrates with rough or textured surfaces.

### Product Features

- Low fogging, double sided, acrylic adhesive tested to SAE J1756 specifications.
- Bonds to a variety of surfaces
- Initial tack for high speed production processes

### Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

### Typical Physical Properties

Attribute Name	Test Method	Value
Adhesive Type		300MP+ Acrylic
Total Tape Thickness	ASTM D3652	0.127 mm (5 mil)
Density		0.91 g/cm <sup>3</sup>

Attribute Name	Value
Liner	2.0 PET
Liner Thickness	0.0508 mm (2.0 mil)
Primary Liner Color	Clear
Liner Print	None

### Typical Performance Characteristics

#### 180° Peel Adhesion

Backing: 2 mil Aluminum Foil

Test Method: ASTM D3330

Dwell Time	Temperature	Substrate	Value
20 min	23 °C (73 °F)	Stainless Steel	7.4 N/cm (68 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	Stainless Steel	13.3 N/cm (121 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	ABS	7.5 N/cm (68 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	Polypropylene (PP)	6.6 N/cm (60 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Stainless Steel	17.2 N/cm (157 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	ABS	12.9 N/cm (117 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Polypropylene (PP)	6.7 N/cm (61 oz/in) <sup>1</sup>

<sup>1</sup> 304 mm/min (12 in/min)

## 90° Peel Adhesion

Backing: 2 mil Aluminum Foil  
Test Method: ASTM D3330

Dwell Time	Temperature	Substrate	Value
20 min	23 °C (73 °F)	Stainless Steel	7.0 N/cm (63 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	Stainless Steel	11.6 N/cm (106 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	ABS	6.1 N/cm (55 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	Polypropylene (PP)	5.2 N/cm (47 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Stainless Steel	17.1 N/cm (156 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	ABS	7.9 N/cm (71 oz/in) <sup>1</sup>
72 h	70 °C (158 °F)	Polypropylene (PP)	4.6 N/cm (42 oz/in) <sup>1</sup>

<sup>1</sup> 304 mm/min (12 in/min)

## Static Shear

Substrate: Stainless Steel  
Dwell Time: 72 h  
Backing: 2 mil Aluminum Foil  
Test Method: ASTM D3654

Temperature	Test Condition	Value
23 °C (73 °F)	1000 g	761 min <sup>1</sup>
70 °C (158 °F)	500 g	72 min <sup>1</sup>

<sup>1</sup> 25 x 25 mm (1 in x 1 in) sample area, test terminated after 10,000 minutes

Dwell Time: 1 h

Attribute Name	Test Method	Value
Fogging (Photometric method)	SAEJ1756	95 % <sup>1</sup>

<sup>1</sup> Fogging condensate on the glass plate determined by measuring the 60o specular gloss. The 60o specular gloss for the same glass plate is used as a reference value. The higher value indicates less fogging.

## Typical Environmental Performance

Temperature: 32 °C (90 °F)  
Dwell Time: 72 h  
Backing: 2 mil Aluminum Foil  
Test Method: ASTM D3330  
Environmental Condition: 90%RH

Attribute Name	Substrate	Value
180° Peel Adhesion	Stainless Steel	17.8 N/cm (162 oz/in) <sup>1</sup>
180° Peel Adhesion	ABS	8.0 N/cm (73 oz/in) <sup>1</sup>
180° Peel Adhesion	Polypropylene (PP)	7.8 N/cm (71 oz/in) <sup>1</sup>
90° Peel Adhesion	Stainless Steel	16.0 N/cm (145 oz/in) <sup>1</sup>
90° Peel Adhesion	ABS	6.3 N/cm (57 oz/in) <sup>1</sup>
90° Peel Adhesion	Polypropylene (PP)	5.6 N/cm (51 oz/in) <sup>1</sup>

<sup>1</sup> 304 mm/min (12 in/min)

## Electrical and Thermal Properties

Attribute Name	Test Method	Value
Glass Transition Temperature (Tg)	ASTM E1356	-60 °C <sup>1</sup>

<sup>1</sup> Glass Transition Temperature (Tg) determined using DSC Analyzer with a heating rate of 4 °C per minute. First heat values given.

## Storage and Shelf Life

Store under normal conditions of 16° to 27°C (60° to 80°F) and 40 to 60% relative humidity in the original packaging, out of direct sunlight. For best performance, use this product within 18 months from date of manufacture.

## Automotive Disclaimer

### Select Automotive Applications:

This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

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## ISO Statement

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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