

3M™ Acrylic Plus Tape WT4100 Series

Technical Data Sheet

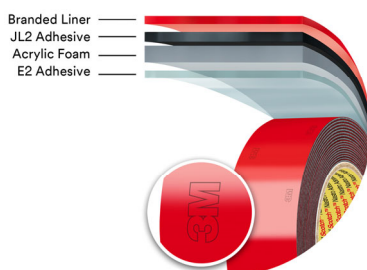
3M™ Acrylic Plus Tape WT4100 Series tapes are acrylic foam tapes, constructed with two different adhesives, and are available in two thicknesses – 0.8 mm and 1.2 mm. These tapes are typically used to attach weatherstrip and/or gasket seals for automotive and industrial applications, such as sunroof seals, lamp seals, and taped seals on the vehicle door.



3M WT4100 Series tapes offer the following key features:

- Heat-activated adhesive on the non-liner side forms an immediate, consistent and durable bond to most EPDM formulations and TPE materials
- Excellent adhesion to a wide variety of automotive paints, including the new scratch-and mar-resistant, low surface energy, and traditional paint systems
- Combination of high initial adhesion with a stress handling core for demanding applications
- Acrylic foam core uniquely designed for excellent conformability of the seal to the substrate, delivers excellent wet-out
- Dark gray core and black adhesive provides improved bond-line aesthetics
- Ability to apply tape to seal components prior to high-temperature processing such as seal coating bakes

Product Construction



Physical Properties

	WT4108	WT4112
Thickness Range	0.83 mm ± 0.10 mm (0.033 inch ± 0.004 in)	1.20mm ± 0.10 mm (0.047 inch ± 0.004 in)
Density Range	633 kg/m ³ ± 65 kg/m ³ (39.5 lb/ft ³ ± 4 lb/ft ³)	545 kg/m ³ ± 65 kg/m ³ (34 lb/ft ³ ± 4 lb/ft ³)
Core	Acrylic Plus Core	
Color	Gray with Black Adhesive	
Liner	3M branded liner, red polyethylene, one-side siliconized	
Adhesive	Liner-side: JL2 acrylic adhesive Non liner-side: E2 heat-activated adhesive	
Tabbing	<ul style="list-style-type: none"> • Heat-bond tabbing: 3M™ Tabbing Tape 5400 and 3M™ Tabbing Tape 5081 or 5082 • PSA tab: 3M™ Tabbing Tape 5300 	

Physical Properties (continued)

WT4100 Series	
Splices	<ul style="list-style-type: none"> Number of splices depends on order quantity or roll length Level wound rolls have an average of 3 to 4 splices Smaller order quantities (smaller than one jumbo) rolls could contain up to 14 splices

Performance Properties

Typical performance of 3M™ Acrylic Plus Tape WT4100 Series is shown below. Peel values depend on the composition and cross-section of a particular weatherstrip. These values are for reference only.

Typical Values	WT4108	WT4112
90° Peel		
Uregloss Clearcoat 20 min RT (LS)	32 N/cm	36 N/cm
Uregloss Clearcoat 24 h RT (LS)	34 N/cm	38 N/cm
TMAC9000 Clearcoat 20 in RT (LS)	10 N/cm	12 N/cm
Other		
Temperature Resistance	-40°C to +90°C, short term 120°C (both values are load-dependent)	
Shelf Life	Two years from date of manufacture when stored at 4°C - 38°C (40°F - 100°F) and 0-95% relative humidity (RH). The optimum storage conditions are 22°C (72°F) and 50% relative humidity.	

Regulatory Information

Please refer to the product label and Safety Data Sheet (SDS) for health and safety information before using. Observe proper handling precautions as outlined in the SDS, which is available on request or at www.3M.com/msds. The product is published as a material entry and is available for access on www.mdsystem.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 technical service representative or call 1-800-328-1684.

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