

**3M** Science.  
Applied to Life.™

# Trusted Attachment

3M™ Acrylic Foam and Acrylic Plus Tapes  
Selection and Sample Guide



# Our tapes are designed to bond to a variety of substrates

- Unique composition provides stress relaxation to combat high application loads
- Maintains tight bond-line aesthetics
- Robust final adhesion, shear and peel strength
- Excellent conformability and wet out
- Temperature, weather, UV and solvent resistant
- Both manual and automated application

This chart does not include all OEM specifications we test to at the request of certain customers that this information be kept confidential.

Tape Family	Product		Thicknesses (mm)		Adhesives Liner Side	Adhesives Non-Liner Side	Acrylic Foam Core Color	Liner Color
	3M™ Acrylic Foam Tape	PX5005	PX5008	0.45	0.76	ZX	ZX	Dark Gray
PX5011		PX5015	1.14	1.52				
4257YCL		0.38		AR5	DS6	Gray	Orange	
5314		0.76		AR7	DS4	Gray	3M Branded Liner	
5344		1.14		AR7	DS4	Gray	3M Branded Liner	
5390		2.3		AR7	AR7	Gray	3M Branded Liner	
5567		1.52		AR7	DS4	Gray	3M Branded Liner	
GT7108		0.8		SS	SS	Gray	Translucent Red	
RT8004US		RT8008US	0.4	0.8	SS	SS	Gray	Transparent Orange
RT8012US		RT8016	1.2	1.6				
3M™ Acrylic Plus Tape	EX4511	EX4515	1.14	1.52	JLx-2	JLx-1	Black	3M Branded Liner
	EX4008	EX4011	0.76	1.14	JL2	VR1	Black	3M Branded Liner
	EX4015		1.52					
	PT1100	PT1500	1.14	1.52	VR2	VR1	Dark Gray	3M Branded Liner
3M™ Die-Cuttable Tape	DC2005	DC2008	0.51	0.76	DL2	DL	Black	White or Clear
	DC2011	DC2015	1.14	1.52				

This selection chart is intended as an initial guide for selecting the appropriate 3M™ Acrylic Foam and Acrylic Plus Tapes. Since applications vary with materials, stress, procedures, and environmental exposures, it is important to determine through testing the most suitable 3M tape to meet your specific application. This chart cannot take into account every variable for each application. 3M has an extensive product offering. If the below selection does not meet your needs or if you need further help and information, please contact your 3M Automotive Division representative.

<sup>1</sup> May bond to substrate without adhesion promoter. Performance testing recommended.

<sup>2</sup> Requires adhesion promoter; contact a 3M application engineer for testing to determine the proper adhesion promoter.

<sup>3</sup> Review with 3M Application Engineering prior to use.



Applications	Non Liner Side Substrates	Liner Side Clear Coat Systems	Tested to OEM Specifications	Tape Sample
Primerless to Low Surface Energy Substrates	MSE <sup>1</sup> LSE <sup>1</sup>	MSE	GMW15201 Type VII	FPO
Windowlace	MSE <sup>2</sup> LSE <sup>2</sup>	MSE	GMW15201 Type XIII A MS-12194	FPO
Body Side Molding Nameplates Sill Plates	MSE <sup>2</sup> LSE <sup>2</sup>	MSE	WSS-M11P65-A2 <sup>3</sup> GMW15201 Type VIA MS-12194	FPO
Body Side Moldings Appliqués	MSE <sup>2</sup> LSE <sup>2</sup>	MSE	WSS-M11P65-A2 <sup>3</sup> GMW15201 Type VIB MS-12194	FPO
Claddings Roof Ditch Moldings	MSE <sup>2</sup> LSE <sup>2</sup>	MSE	WSS-M11P65-A2 <sup>3</sup> GMW15201 Type XIII C MS-12194	FPO
Body Side Moldings Claddings Wheel Flares	MSE <sup>2</sup> LSE <sup>2</sup>	MSE	WSS-M11P65-A2 <sup>3</sup> MS-12194 GMW15201 Type VIC	FPO
Body Side Moldings Appliqués	MSE <sup>2</sup> LSE <sup>2</sup>	MSE	Contact your 3M Application Engineer	FPO
Body Side Moldings Claddings / Spoilers Roof Ditch Moldings	MSE <sup>2</sup> LSE <sup>2</sup>	MSE	Contact your 3M Application Engineer	FPO
Primerless to Medium Surface Energy Substrates	MSE <sup>1</sup>	MSE LSE	GMW15201 Type XVI	FPO
Body Side Moldings Claddings / Spoilers Wheel Flares / Roof Ditch Moldings	MSE <sup>2</sup> LSE <sup>2</sup>	MSE LSE	WSS-M11P65-A2 GMW15201 Type IX MS-12194	FPO
Body Side Moldings Fender Vents Roof Ditch Moldings	MSE <sup>2</sup> LSE <sup>2</sup>	MSE	WSS-M11P65-A2 <sup>3</sup> GMW15201 Type VIII A and VIII B MS-12194	FPO
Nameplates Emblems Badges	MSE <sup>2</sup> LSE <sup>2</sup>	MSE LSE	WSS-M11P65-A GMW15201 Type I MS-12194 Type A	FPO

#### Substrate Descriptions

- Low Surface Energy (LSE): Thermoplastic polyolefin (TPO), Polypropylene (PP)/EPDM
- Medium Surface Energy (MSE): Acrylonitrile-Butadiene-Styrene (ABS), AES, Acrylate-Styrene-Acrylonitrile (ASA), Polycarbonate (PC), PC/ABS, PMMA (Acrylic)

#### Paint Clear Coat System Descriptions

- Low Surface Energy (LSE): Primerless carbamate, 2K Urethane
- Medium Surface Energy (MSE): Epoxy/acid, Acrylosilane, Acrylic/melamine



# Strengthening Tape-to-Surface Bonding

## 3M™ Adhesion Promoters

- Help ensure robust attachment tape bond to automotive parts
- Ready-to-use solution is specifically formulated for use with 3M™ Acrylic Foam Tapes and 3M™ Acrylic Plus Tapes
- Excellent for automotive exterior trim applications

## Selecting the correct 3M™ Adhesion Promoter for your application

This chart should only be used to provide direction on adhesion promoter choices per substrate type. It is important that customers conduct testing to verify adhesion promoter performance on individual substrate choices and application conditions.

	4298UV	4296T	2262AT	C110	G200	K500	K520UV	K540NTUV*	N210
PVC			X	X					P
TPO	P					X	X	X	
TPU	X	P							
Fascia Paint		P							
EPDM	P					X	X	X	
ABS	P		X						X
PP	P					X	X	X	X
TPV/TPE	P					X			
PC	P			X					X
Glass Visible Bond	X				X				X
Glass Hidden Bond	P				X				X
Acrylic	P								X
Nylon	X		X						P
Polyester	X		P			X			
Polyurethane				X					X
PBT									P
RIM	X	P							
SUS				X					X

P – Primary Choice X – Other Possibilities

\* NT products offer a reduction in Hazardous Air Pollutant (HAPs) content by weight.

## Notes:

- 3M™ Adhesion Promoter 2262AT is not a preferred OEM recommendation for exterior applications.
- 3M™ Adhesion Promoters 4298UV, K520UV and K540NTUV are premixed with a UV indicator dye.

**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 engineer or call 1-800-328-1684.



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