



VHB™ Double Coated Acrylic Foam Tape 4920

Product Data Sheet

Updated :September 2022
Supersedes :September 2002

Product Description

4920 is an acrylic foam coated on both sides with a firm acrylic adhesive. This product is 0.48mm thick, making it suitable for applications where a thin bond line is required. 4920 is suitable for use in many interior and exterior industrial applications.

Physical Properties

Not for specification purposes

Adhesive Type	Firm Acrylic
Thickness (ASTM D-3652) Tape Liner Total	0.40 mm ± 15 % 0.08 mm 0.48 mm
Foam Density	800 kg/m ²
Release Liner	Printed Paper White printed Red 3M VHB™
Tape Colour	White

Performance Characteristics

Not for specification purposes

Peel Adhesion to Stainless Steel 90° peel @ room temp, 72 hr dwell, jaw speed 300mm/min	26 N/10mm
Static Shear Strength weight held for 10,000 mins to stainless steel with ½ sq in (3.23 sq cm) overlap	1500 g @ 22°C 500 g @ 66°C 500 g @ 93°C
Temperature Performance Max (minutes/hours) Max Continuous (days/weeks)	150 °C 90 °C
Normal Tensile (T-Block) to Aluminium at room temp, 6.45 sq cm, jaw speed 50 mm/min	1100 kPa
Solvent Resistance	No apparent degradation when exposed to splash testing of most solvents including gasoline, JP-4 jet fuel, mineral spirits, motor oil, ammonia cleaner, acetone, methyl ethyl ketone. 20 seconds air dry.
UV Light Resistance	Excellent

Additional Product Information

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact and thus improving bond strength.

To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Typical surface cleaning solvents are isopropyl alcohol/water mixture (rubbing alcohol) or heptane. Use proper safety precautions for handling solvents.

It may be necessary to seal or prime some substrates prior to bonding.

a. Most porous or fibred materials (e.g. wood) will require sealing to provide a unified surface.

b. Some materials (e.g. copper, brass, plasticised vinyl) will require priming or coating to prevent interaction between adhesive and substrates.

Ideal tape application temperature range is 20 to 40°C. Initial tape application to surfaces at temperatures below 10°C is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

In some cases bond strength can be increased and ultimate bond strength can be achieved more quickly by exposure of the bond to elevated temperatures (e.g. 65°C) for one hour. This provides better adhesive wetout on to the substrates.

CAUTION

The following situations must be evaluated thoroughly to determine whether VHB products are suitable for the intended use.

1. Applications of 4920 which require performance at severe cold temperatures must be thoroughly evaluated, if the expected use will subject the VHB Joining System fastener to high impact stresses. For cold temperature applications from 0 to 10°C use 4943.

Applications

VHB Joining Systems are suited for use in many interior and exterior industrial applications. In many situations, they can replace rivets, spot welds, liquid adhesives, and other permanent fasteners. Each product in the VHB family has specific strengths. These can include high tensile, shear and peel adhesion and resistance to solvents, moisture and plasticiser migration. All VHB tape should be thoroughly evaluated by the user under actual use conditions with intended substrates, especially if expected use involved extreme environmental conditions.

VHB Joining Systems are suitable for bonding a variety of substrates, including sealed wood, many plastics, composites and metals. Plastics which can be a problem are polyethylene, polypropylene, teflon, silicones and other low surface energy materials.

Plasticised vinyl bonding is dependent upon the types and concentrations of plasticisers which can migrate into the adhesives causing a reduction in bond strength; 4945 is most resistant to plasticiser migration. Galvanised surfaces are potential problems and should be carefully evaluated.

To prevent corrosion on copper and brass, only lacquer coated material should be used with VHB Joining Systems.

Thorough evaluations are recommended when bonding is required to any questionable surface.

Shelf Life

24 months from date of despatch by 3M when stored in the original carton at 20°C & 50 % Relative Humidity

Automotive Disclaimer

Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, including, but not limited to, automotive electric powertrain battery or high voltage applications. This product does not fully adhere to typical automotive design or quality system requirements, such as IATF 16949 or VDA 6.3. This product may not be manufactured in an IATF certified facility and may not meet a Ppk of 1.33 for all properties. The product may not undergo an automotive production part approval process (PPAP). Customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's automotive application and for conducting incoming inspections before use of the product. Failure to do so may result in injury, death, and/or harm to property. No written or verbal statement, report, data or recommendation by 3M related to automotive use of the product shall have any force or effect unless in an agreement signed by the Technical Director of 3M's Automotive Division. Customer assumes all responsibility and risk if customer chooses to use this product in an automotive electric powertrain battery or high voltage application, and 3M will not be liable for any loss or damage arising from or related to the 3M product or customer's use of the product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity or recall costs), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability. In no event shall 3M be liable for any damages in excess of the purchase price paid for the product.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications.

This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations

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