


VHB™

9460PC Adhesive Transfer Tape

Product Data Sheet

Updated : September 2022
Supersedes : November 2001

Product Description A-10 is a very firm acrylic pressure-sensitive system. It features very high shear holding power. Bond strength increases substantially with natural ageing.

Physical Properties
Not for specification purposes

| | | |
|--|--|-----------------------|
| Adhesive Type | Acrylic | 3M ref : A-10 |
| Thickness (ASTM D-3652) Tape Liner Total | 0.05 mm 2 Thou 0.10 mm 0.15 mm | |
| Release Liner | Poly Coated Tan Paper. | Printed Green 3M VHB™ |
| Tape Colour | Clear | |
| Shelf Life | 24 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity | |

Performance Characteristics
Not for specification purposes

| | | |
|--|---|--|
| Peel Adhesion to Stainless Steel 180° peel @ room temp, 72 hr dwell, jaw speed 300mm/min ASTM D-3330 | 12 N/10mm | Please see Peel Adhesion Continued below. |
| Static Shear Strength weight held for 10,000 mins to stainless steel with ½ sq in (3.23 sq cm) overlap | 1000g @ 20°C 1000g @ 65°C 1000g @ 95°C 1000g @ 120°C 500g @ 150°C 500g @ 175°C | Minutes to failure 10,000+ 10,000+ 10,000+ 10,000+ 10,000+ 10,000+ |
| Temperature Performance Minutes/Hours Days/Weeks | 260°C 150°C | |
| Solvent Resistance | When properly laminated between two impervious materials, adhesive will resist mild acids and alkalis, most oils, grease, gasoline, kerosene, JP-4 fuel, hydraulic fluids and other typical aromatic and aliphatic hydrocarbon and ketone solvents. | |

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Performance Characteristics (Cont..)
 Not for specification purposes

| | | | |
|--|---|------|--------|
| UV Light Resistance | Excellent. | | |
| Water Resistance | When properly laminated between two impervious materials and submitted to 100 hour immersion in water at 20°C the adhesive bond is not affected. | | |
| Environmental Resistance | Peel adhesion tests on tapes applied to glass, stainless steel, and aluminium and subjected to 1000 hours Weather - o meter exposure showed no decrease in bond strength and no degradation of the adhesive. Adhesive laminated between glass and clear polyester and exposed to Florida sunshine for 1 year showed no degradation of the adhesive. | | |
| Insulation Resistance | >1 x 10 ⁶ | | |
| Peel Adhesion (Cont...) 180° peel @ room temp, 72 hr dwell, jaw speed 300mm/min ASTM D-3330 | Aluminium | 11.5 | N/10mm |
| | Rigid Vinyl | 7.1 | N/10mm |
| | ABS | 6.6 | N/10mm |
| | Polycarbonate | 7.1 | N/10mm |
| | Glass | 7.7 | N/10mm |
| | Acrylic | 7.7 | N/10mm |
| | Epoxy | 8.8 | N/10mm |

Additional Product Information

Thermal Conductivity
 Watt/cm °C 0.0-016

Dielectric Strength
 (Volts/25µm)
 1,000 Volts

A-10 acrylic adhesive is designed for applications requiring high peel and shear strength. Performance data on various tests are shown above.

Application Techniques

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 38°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.

Applications of 4950F 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 4951 (see VHB Special Feature products data sheet).

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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 tapes 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, PTFE, 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. (see VHB Special Feature products data sheet).

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.

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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.



Tapes & Adhesives Group

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3M United Kingdom PLC
3M House, PO Box 1,
Market Place,
Brocknall, Berkshire

Product Information :
Tel 0870 60 800 50
Fax 0870 60 700 00

3M Ireland
3M House, Adelphi Centre,
Upper Georges Street,
Dun Laoghaire, Co. Dublin

Customer Service :
Tel (01) 280 3555
Fax (01) 280 3500