VHB™ Tape 5915

Product Data Sheet

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Supersedes: new

Product Description

3M™ VHB™ Acrylic Foam Tapes 5915 is a pressure sensitive adhesive tape for bonding a wide range of materials, including many paints and lower surface energy plastics in addition to metals and other plastics. The foam is conformable to increase contact with the surfaces. This tape is similar to other products in the 3M™ VHB™ Tape 5952 family except thickness.

Construction

	VHB Tape 5915
Tape Thickness	0.4 mm
Release Liner	Red Polyethylene Film
Tape Colour	Black
Foam Density	690 kg/m^3
Adhesive Type	Modified Acrylic
Adhesive Carrier	Very Conformable Acrylic Foam (closed cell)

Performance Characteristics

Peel Adhesion (stainless steel) Based on ASTM D3330 [1]	230 N/100 mm
Temperature Performance Short Term: (minutes, hours) Long Term: (days, weeks)	 300°F (149°C) 250°F (121°C)
Static Shear Strength (stainless steel) ASTM D3654 [2]	72°F (22°C) 1000 g/0.5 sq. in. (holds 10,000 min.) 158°F (70°C) 500 g/0.5 sq. in. (holds 10,000 min.) 200°F (93°C) 500 g/0.5 sq. in. (holds 10,000 min.) 250°F (121°C) 250 g/0.5 sq. in. (holds 10,000 min.)
Normal Tensile (aluminium T-block) ASTM D-897 [3]	90 lb./in.2 (620 kPa)
Dynamic Shear (stainless steel) ASTM D-1002 [4]	90 lb./in.2 (620 kPa)
Solvent Resistance	High

[1] **90° Peel Adhesion -** Based on ASTM D3330 -To stainless steel, room temperature, jaw speed 12 in/min (305 mm/min). Average force to remove is measured.
[2] **Static Shear** - ASTM D3654 - To stainless steel, tested at various temperatures and

gram loadings. 0.5 in_2 (3.22 cm_2). Will hold listed weight for 10,000 minutes (approx 7 days). Conversion: 1500 g/0.5 in_2 equals 6.6 lb/in_2; 500 g/0.5 in_2 = 2.2 lb/in_2.
[3] **Normal Tensile** (T-Block Tensile) - ASTM D-897 - To aluminium, room temperature, 1 in_2 (6.45 cm_2), jaw speed 2 in/min (50 mm/min.) Peak force to separate is measured.
[4] **Dynamic Overlap Shear** - ASTM D-1002 - To stainless steel, room temperature, 1 in_2 (6.45 cm_2), jaw speed 0.5 in/min (12.7 mm/min.) Peak force to separate is measured.

Application Guidelines	For maximum bond strength the surfaces should be thoroughly cleaned with a 50:50 mixture of isopropyl alcohol and water. Consult manufacturer's directions for use and precautions when using cleaning solvents. Ideal tape application is accomplished when temperature is between 70° and 100°F (between 21° and 38°C) and the bond is allowed to dwell 72 hours. Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended.
Storage	The optimum storage condition of 3M VHB 5915 is 72°F (22°C) and 50% relative humidity.
Shelf Life	3M VHB 5915 has a shelf life of 24 months from date of manufacture when stored at 40° to 100°F (4° to 38°C) and 0-95% relative humidity.
For Additional Information	To request additional product information or to arrange for sales assistance, please see below for contact details.
Important Notice	All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law

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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