



# Automotive Technical Datasheet

## 3M™ Heatactivable Tapping Tapes 5081 (blue) and 5082 (clear)

### Description

5081 and 5082 are 3M™ heat sealing polyamide/polyethylene composite foils (heatactivable foils), which are different in colour, blue and clear, but comparable in their physical properties.

An important use is heat tabbing with liners of 3M™ Acrylic Foam Tapes or 3M™ Acrylic Plus Tapes (ST- and EX-series), which ensures that the liner can be removed cleanly and efficiently before the tape is put into use.

Both foils show an excellent adherence to the liner of 3M™ Acrylic Foam Tapes and 3M™ Acrylic Plus Tapes (ST- and EX- series).

The foils have a matt finish on the sealing side.

**Therefore the matt side must always face the liner/tape surface.**

### Product Overview

Foil		5081	5082
Winding direction	Colour	blue	clear
matt sealing side		X	X
inside wound			

General Properties	Typical Value	Test Method
Thickness	105 µm	DIN 53370
Weight per area	104.4 g/m <sup>2</sup>	DIN 53352
E-Modulus (longitudinal)	450 MPa	EN ISO 527-1
Elongation at break (longitudinal)	450 %	EN ISO 527-1
Shelf Life	12 months*	

\* From date of receipt by customer when stored in original cartons at +4°C until +38°C and 0 – 95 % relative humidity

### Sealing Guidelines

Typical sealing conditions on automatic heat tabbing equipment:

- 145 - 180°C (measured directly on the heat plate)
- 1 - 2 seconds with a pressure of 65 N/cm<sup>2</sup>

IMDS No.: <http://www.mdssystem.de>



## Attention

Each type of liner has its own optimal temperature window. This window is generally narrower and on a higher level for liners of Acrylic Plus tapes of the ST- and EX- series as for liners of Acrylic Foam tapes. The temperature range for sealing is furthermore dependent on the sealing time, sealing pressure type of equipment and substrate. Therefore some evaluations are necessary to adjust the right conditions.

## Additional Information

The information in this data sheet is product related. It is necessary that the user investigates the product to that effect whether it fits to his special application and application method.

## Important notice

All statements, technical information and recommendations herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed. Please ensure before using our product that it is suitable for your intended use.

All questions of liability relating to this product are governed by the Terms of Sale subject, where applicable, to the prevailing law.

