



GM Specification 9985281

Annual Test Data

Technical Bulletin

The 3M IATD Quality Laboratory tested the following tapes to the Automotive Specification 9985281. The results of the testing are provided in the following information. Tapes not listed on this document have not been tested to this specification. Date on product chart is valid one year after that date.

3M™ Double Coated Tape 9490LE
3M™ Adhesive Transfer Tapes 6035PC and 6035PL
3M™ Adhesive Transfer Tape 6038PC
3M™ Adhesive Transfer Tapes 9472, 950, 9672 and 969

3M™ Adhesive Transfer Tapes 9472LE and 9672LE
3M™ Adhesive Transfer Tape 9627
3M™ Double Coated Tape 9629PC

Approved by IATD Quality:

Jurene L. Fisher
Test Coordinator

3M™ Double Coated Tape 9490LE Test Date: March 31, 2017

Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
63070617465-004	Stainless Steel	*Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.164	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.168
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.118 to 0.219 kg/m ²	0.173	0.173
		Solids Content	9985281 Appendix A	94.5% min	98.65	98.66
		Adhesion to Steel				
		As Received 3M™ Laminating Adhesive 300MP	ASTM D3330 E	535 N/m min	611.16	N/A
		90 Day Aged 3M™ Laminating Adhesive 300MP	ASTM D3330 E	420 N/m min	N/A	574.39
		As Received 3M™ High Performance Acrylic Adhesive 300LSE	ASTM D3330 E	535 N/m min	564.23	N/A
		90 Day Aged 3M™ High Performance acrylic Adhesive 300LSE	ASTM D3330 E	420 N/m min	N/A	600.48
		Shear Adhesion	ASTM D3330 A	25 min @ 23°C (73°F)	>203	>203
		Liner Removability	ASTM D3330 D	45 N/m max	32.78	29.59

*Adhesive thickness values include 0.0127mm carrier film

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3M™ Adhesive Transfer Tape 6035PC and 6035PL					Test Date: August 31, 2016	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
K15315	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.112	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.113
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.118 to 0.219 kg/m ²	0.129	0.127
		Solids Content	9985281 Appendix A	94.5% min	99.08	99.02
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	769.11	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	818.44
		Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+	25+
		Liner Removability				
		6035PC	ASTM D3330 D	45 N/m max	12.06	10.07
6035PL	ASTM D3330 D	45 N/m max	15.96	12.52		

3M™ Adhesive Transfer Tape 6038PC					Test Date: July 31, 2016	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
K15316	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.136	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.134
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.118 to 0.219 kg/m ²	0.156	0.150
		Solids Content	9985281 Appendix A	94.5% min	99.74	99.75
		Adhesive Thickness				
		As Received	ASTM D3330 E & 9985281	535 N/m min	1702.15	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	1446.47
		Shear Adhesion	ASTM D3654 A	25 min @ 23°C (73°F)	25+	25+
		Liner Removability	ASTM D3330 D	45 N/m max	18.38	15.76

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3M™ Adhesive Transfer Tape 9472, 9672, 950 and 969					Test Date: August 31, 2016	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
K5335 K5336 K4356	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.1384	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.122
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.118 to 0.219 kg/m ²	0.133	0.135
		Solids Content	9985281 Appendix A	94.5% min	99.76	99.71
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	736.84	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	784.41
		Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+	25+
		Liner Removability				
		950	ASTM D3330 D	45 N/m max	22.50	14.34
		9472	ASTM D3330 D	45 N/m max	7.42	7.946
9672	ASTM D3330 D	45 N/m max	11.12	14.27		

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3M™ Adhesive Transfer Tape 9472LE, 9672LE					Test Date: August 31, 2016	
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
15699 16174	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.113	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.129
		Color	Visual	Translucent	Pass	Pass
		Mass				
		9472LE	998521	0.118 to 0.219 kg/m ²	0.130	0.129
		9672LE	998521	0.118 to 0.219 kg/m ²	0.132	0.134
		Solids Content	9985281 Appendix A	94.5% min	98.84	99.07
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	619.63	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	629.78
		Shear Adhesion	ASTM D3654 A	25 min @ 23°C (73°F)	25+	25+
		Liner Removability				
		9472LE	ASTM D3330 D	45 N/m max	10.46	10.31
9672LE	ASTM D3330 D	45 N/m max	23.31	19.26		

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3M™ Adhesive Transfer Tape 9627						Test Date: September 30, 2016
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
K15354	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.134	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.141
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.118 to 0.219 kg/m ²	0.130	0.131
		Solids Content	9985281 Appendix A	94.5% min	99.82	99.77
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	703.22	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	809.86
		Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+	25+
		Liner Removability	ASTM D3330 D	45 N/m max	24.66	23.96

3M™ Double Coated Tape 9629PC						Test Date: September 30, 2016
Lot Number	Substrate	Test	Test Method	Specification	As Received	90 Day Shelf Life @35°C (95°F)
K15332	Stainless Steel	Adhesive Thickness				
		As Received	TAPPI 411 & 9985281	0.09 to 0.165mm	0.105	N/A
		90-Day Aged	TAPPI 411 & 9985281	0.09 to 0.175mm	N/A	0.101
		Color	Visual	Translucent	Pass	Pass
		Mass	9985281	0.118 to 0.219 kg/m ²	0.111	0.111
		Solids Content	9985281 Appendix A	94.5% min	99.51	99.63
		Adhesion to Steel				
		As Received	ASTM D3330 E & 9985281	535 N/m min	762.76	N/A
		90-Day Aged	ASTM D3330 E & 9985281	420 N/m min	N/A	866.48
		Shear Adhesion	ASTM D3654 A & 9985281	25 min @ 23°C (73°F)	25+	25+
		Liner Removability	ASTM D3330 D	45 N/m max	12.15	10.97

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Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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ISO 9001: 2008

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