



Primerless Acrylic Foam Tape 5850

For Professional Market Applications

Technical Data Sheet

June 2000

General Description

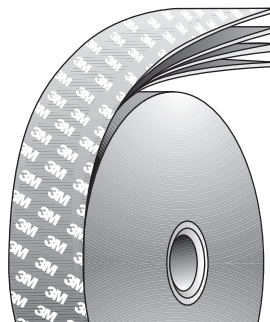
3M™ Primerless Acrylic Foam Tape 5850 is a 30-mil thick, medium-density, dark gray acrylic foam, with TX-1 and DS-4 adhesives on the liner and non-liner sides of the product, respectively. 3M primerless acrylic foam tape 5850 is designed to give a thin bond line for attachment of wood and decorative dash appliqué to interior plastic dash and trim substrates without the use of adhesion promoters. TX-1 adhesive is characterized by high peel and shear adhesion to unprimed low surface energy plastics, typically used in the manufacture of interior automotive dash and trim parts (i.e., TPO, PP, PPO, PC, ABS, plastic alloys, etc.). DS-4 adhesive exhibits excellent adhesion to primed plastics and veneers. 3M primerless acrylic foam tape 5850 utilizes an easy-release liner for liner startability and removal. The maroon liner is printed with 3M logos. Applications for this acrylic foam tape include attachment of wood dash appliqué to interior factory dash and trim and miscellaneous decorative interior/exterior trim to low surface energy plastics.

Typical Applications

Interior Wood Dash and
Decorative Appliqués



Product Construction



Maroon Easy-Release Liner Printed with 3M Logo
TX-1 Acrylic Adhesive
Acrylic Foam Core
DS-4 Acrylic Adhesive

Shelf Life

One year from date of receipt by customer when stored at 4°C-38°C (40°F -100°F) and 0-95% relative humidity. Optimum storage conditions are 22°C (72°F) and 50% relative humidity.

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Physical Properties

Foam	Dark Gray Acrylic	
Adhesive	Liner Side Non-liner Side	TX-1 DS-4
Thickness Range	0.76 mm min. 0.69 mm max. 0.84 mm	(0.030 in.) (0.027 in.) (0.033 in.)
Density Range	689 kg/m ³ min. 609 kg/m ³ max. 769 kg/m ³	(43 lb/ft ³) (38 lb/ft ³) (48 lb/ft ³)
Liner	Maroon easy-release liner printed with 3M logo	
Roll Widths	min. 6.4 mm max. 1219 mm	(0.25 in.) (48 in.)
Roll Lengths:	For widths less than 8 mm (0.314 in.): Up to 98.8 m (108 yds.). For widths between 8 - 9.5 mm (0.315 - 0.375 in.): Up to 131.6 m (144 yds.). For widths greater than 9.5 mm (0.376 in.): Up to 160 m (175 yds.).	

Typical Performance Properties

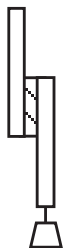
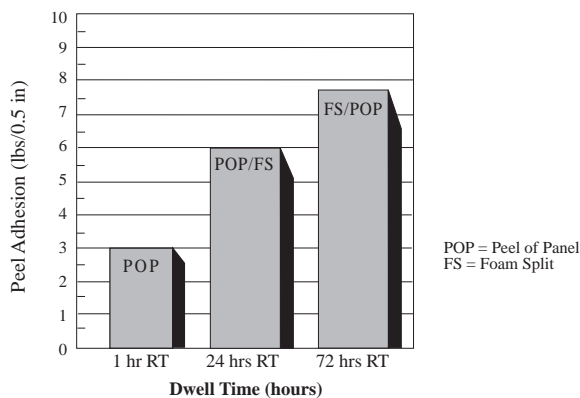
Performance tests are run using standard test procedures. The values presented are typical values not to be used for specification purposes.



1. Peel Adhesion

90 Degree Peel
Adhesion (lbs/0.5 in)

Adhesion to Polypropylene (PP) without Adhesion Promoter



250 g (0.55 lb)

2. Static Shear

Exceeds 10,000 min.
at 79° C (175°F).

Static shear tests are run with 12.7 mm (0.5 in) wide by 50.8 mm (2.0 in) long tape on a polypropylene (PP) test panel with a 6.8 kg (15 lb) roll down against anodized aluminum. Weight is 250 g (0.55 lb).

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Printed in U.S.A.
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0061-EMC M
75-3469-1211-8