



# Acrylic *Plus* Sealing Tape ST1200

Technical Data Sheet

April 2009

Supersedes Technical Data Sheet dated January 2005

**General Description** 3M™ Acrylic *Plus* Sealing Tape ST1200 is a black acrylic foam tape, 1.20 mm thick, constructed with two different adhesives. The heat-activated adhesive on the non-liner side forms an immediate, consistent and durable bond to most EPDM formulations and Santoprene® materials. The liner-side adhesive is a pressure sensitive adhesive characterized by high adhesion and holding strength to many surfaces, including automotive paints and metals. This tape utilizes a soft acrylic foam core uniquely designed for excellent conformability of the seal to the substrate.

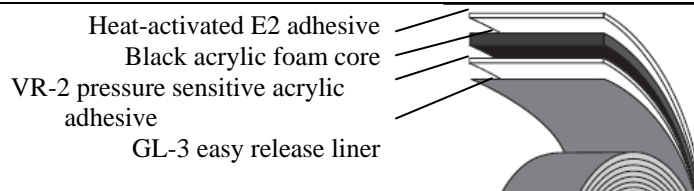
3M Acrylic *Plus* Sealing Tape offers the following key features in attaching weatherstrip and gasket seals:

- Superior adhesion to automotive paint surfaces
- Conformable core delivering excellent wet-out
- Black, high-strength core resulting in improved bond line quality
- Ability to tape seal components prior to high temperature processing
- Easy liner release

The result is the most versatile and robust method for applying a continuous seal to the vehicle to minimize water, NVH, and dirt intrusion into the cabin.

**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 (RH). The optimum storage conditions are 22°C (72°F) and 50% relative humidity.

**Product Construction**



**Physical Properties** Values shown are typical values not to be used for specification purposes.

Tape thickness (excluding liner)	1.20 mm $\pm$ 0.13 mm (0.047 inch $\pm$ 0.005 inch)
Tape density (excluding liner)	689 kg/m <sup>3</sup> $\pm$ 64 kg/m <sup>3</sup> (43 lb/ft <sup>3</sup> $\pm$ 4 lb/ft <sup>3</sup> )
Heat Bond Tabbings options	3M™ Tabbings Tape 5400 or 5081

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## 3M™ Acrylic Plus Sealing Tape ST1200

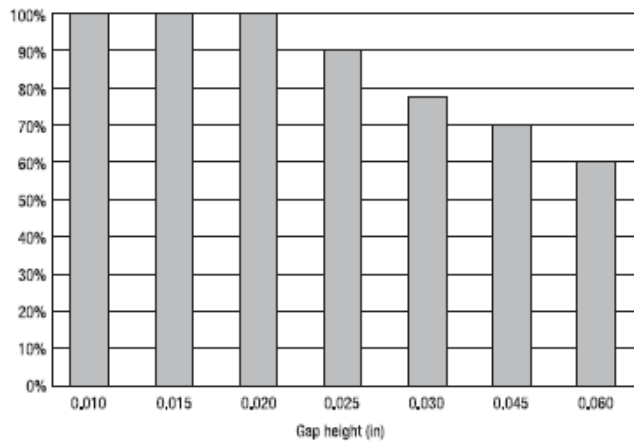
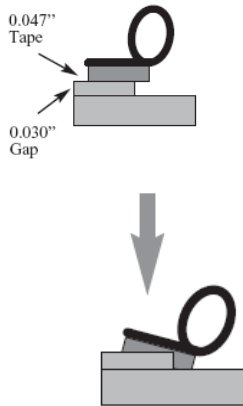
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**Roll Width and Length** 3M™ Acrylic *Plus* Tapes are available in the following standard widths. Millimeter widths are rounded to the nearest whole numbers (7, 8, 9 mm . . .) and 1/8 inch increments starting with 1/4 inch (0.25, 0.375, 0.50, 0.625 inch . . .).

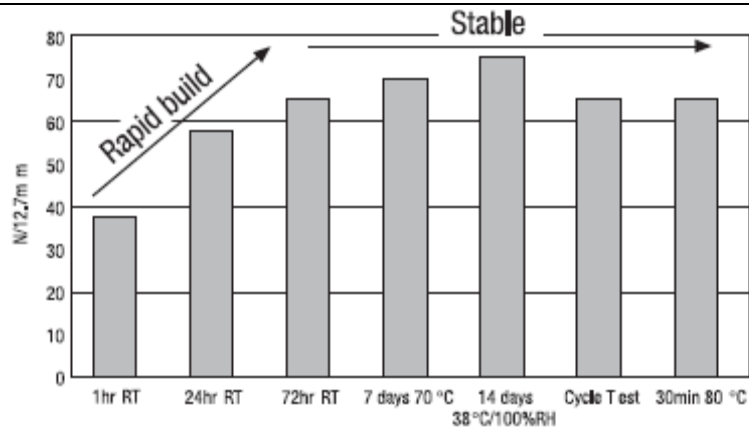
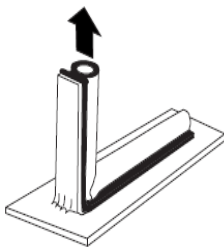
Minimum widths: 4 mm Levelwound 6 mm Planetary	Roll Width	Roll Width Tolerance	Roll Length (maximum)
	Planetary Rolls		
	< 8 mm (< 0.315 in)	+/- 0.40 mm (+/-0.015 in.)	66 meters (72 yards)
	8 - 9 mm (0.315 - 0.375 in)	+/- 0.40 mm (+/-0.015 in.)	99 meters (108 yards)
	> 10 - 18 mm (0.394 – 0.709 in)	+/- 0.40 mm (+/-0.015 in.)	132 meters (144 yards)
	> 18 mm (> 0.709 in.)	+/- 0.80 mm (+/- 0.031 in.)	132 meters (144 yards)
Levelwound Rolls			
	4 – 16 mm (0.157 – 0.630 in.)	+/- 0.40 mm (+/-0.015 in.)	700 meters (765 yards)

**Performance Properties** Typical performance of 3M™ Acrylic *Plus* Sealing Tape ST1200 is shown below. Peel values depend on the composition and cross-section of a particular weatherstrip. These values are for reference only.

### Conformability/Wet-Out



### 90° Peel Adhesion



3M Acrylic *Plus* Sealing Tape ST1200 has excellent initial adhesion at assembly and excellent long-term adhesion over all environmental conditions during vehicle life.

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**Contact Information** The information provided in this technical document is intended as a guide for this product. For more information or help in selecting a 3M product for an application, please contact 3M HELPS at 1-888-3M HELPS (1-888-364-3577).

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