



Acrylic Foam Tape 5665

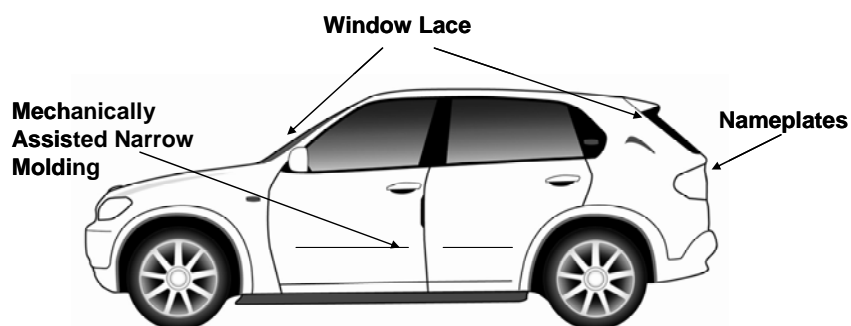
Technical Data Sheet

August 2009

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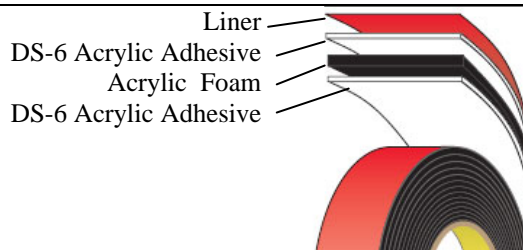
General Description 3M™ Acrylic Foam Tape (AFT) 5665 is a gray, medium performance, double coated acrylic foam tape designed for the attachment of lightweight automotive exterior trim such as nameplates, emblems, and roof slats. 3M AFT 5665 has DS-6 adhesive on both sides of the foam. 3M AFT 5665 is intended for cost effective attachment in less demanding applications.

Applications



Shelf Life One year from date of receipt by customer when stored at 22°C (72°F) and 50% relative humidity.

Product Construction



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

Thickness	0.76 mm (± 0.08 mm) (0.030 in ± 0.003 in)
Density	656 kg/m ³ (± 80 kg/m ³) (41 lb/ft ³ ± 5 lb/ft ³)

Roll Width and Length (Planetary)

3M™ Acrylic Foam Tapes are available in the following standard widths. Millimeter widths 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
5 mm Planetary

Roll Width	Roll Width Tolerance	Roll Length (maximum)
Planetary Rolls		
< 7 mm (< 0.276 in)	+/- 0.38 mm (+/-0.015 in.)	66 meters (72 yards)
7 - 9 mm (0.276 - 0.375 in)	+/- 0.38 mm (+/-0.015 in.)	99 meters (108 yards)
10 - 18 mm (0.394 - 0.709 in)	+/- 0.38 mm (+/-0.015 in.)	160 meters (175 yards)
> 18 mm (> 0.709 in.)	+/- 0.76 mm (+/- 0.030 in.)	160 meters (175 yards)
Levelwound Rolls		
4 - 16 mm (0.157 - 0.630 in.)	+/- 0.38 mm (+/-0.015 in.)	900 meters (984 yards)

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Performance Properties

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

1. Breakaway and Continuing Peel



72 hrs at 22°C (72°F)	Breakaway Peel	71 N/12.7 mm	(16 lbs/.5 in)
	Continuing Peel	24 N/12.7 mm	(5.5 lbs/.5 in)
72 hrs at 70°C (158°F)	Breakaway Peel	102 N/12.7 mm	(23 lbs/.5 in)
	Continuing Peel	38 N/12.7 mm	(8.5 lbs/.5 in)
72 hrs at 38°C /100% RH	Breakaway Peel	71 N/12.7 mm	(16 lbs/.5 in)
(100°F/100%RH)	Continuing Peel	24 N/12.7 mm	(5.5 lbs/.5 in)

Breakaway and continuing peel tests are run with 12.7 mm (0.5 in) wide tape on PVC test bars. Tests were run on base coat/clear coat paint at a separation rate of 305 mm/min (12 in/min).



2. Static Shear

Exceeds 100 hours at 70°C (158°F). Static shear tests are run with 12.7 mm (0.5 in) wide by 50.8 mm (2 in) long tape on PVC test bars, 6.8 kg (15 lbs) roll-down against stainless steel. Static weight is 250 gm (0.55 lbs).

Contact Information

The information provided in this technical document is intended as a guide for this product. For more information, and help selecting a 3M product for an application, please contact a 3M technical service representative.

Regulatory

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