

# Double-Sided Tapes User's Guidance - 3M™ VHB™



5952



5604A-GF

3M™ VHB™ Double Sided Tape, Easy to Use for Automotive, LED Strips, Home Decor, Office Decor.

## Features

5962 Applicable for a wide range of materials including metals, glass, rigid PVC, acrylic, PC/ABS, and numerous plastic products exhibiting medium to low surface energy. It is also suitable for most powder coated paints, wood, and concrete, as well as other surfaces that are coated or sealed and porous. Additionally, it proves effective for precise die-cutting applications.

5604A-GF Low-temperature bonding performance; suitable for the adhesion of general industrial metals and materials with high surface energy.

## Models

Model.	Thickness(mm)	Color	Temperature Resistant
5952	1.1mm	Black	149°C short-term, 121°C long-term
5604A-GF	0.4mm	Grey	93°C short-term, 70°C long-term

## For Apply 3M Tape on Pre-Existing or Pre-Hung Fixture Follow the Steps Below for Better Quality

### 1. Cleaning

Spray on the surface of the substrate with recommended cleaner (follow chart below) and wipe the surface with a clean lint-free cloth.

Recommended Cleaner	
Dust, Fingerprints, Etc.	Isopropyl Alcohol.
Heavy Oil Stains	Acetone
Release Agent	Cleaning Agent Recommended by The Release Agent Manufacturer

## 2. Drying

After the surface of the substrate is clean, it is necessary to wait until the solution on the surface of the substrate is completely dried. If there is water vapor attached to the surface of the substrate or the humidity in the air is too high, it is necessary to wait until the surface of the substrate is completely dry and free of moisture. If necessary, use a heating source to help speed up the process.

## 3. Applying The Tape

When applying the VHB tape to the surface make sure the surface is place horizontally.

- 1). Apply a small section of the tape to the first surface.
- 2). Roll the tape out in one direction and apply the tape.
- 3). Use a roller or a scraper to apply pressure to the attached tape to help release the air pockets.
- 4). Remove the release paper from the tape and attach the second surface to the tape.

## 4. Pressure

- 1). After the two structures are assemble. To ensure the sticking effect, please press and hold the sticker with proper pressure for at least 1-2 minutes.

Pressure Situation	
Low	Prevent Damages
High	Sufficient Contact

- 2). After applying the necessary amount of pressure to the product, wait 10 minutes to confirm proper pressure was apply.

**\* The ideal temperature range for tape bonding is 53°F-100°F, Not suitable below 50°F.**

### For Bonding Guidelines Follow The Chart Below

Bond Percentage vs. Resting Time (At 70°F)	
50% Bonding	20 Minutes
90% Bonding	24 Hours
100% Bonding	72 Hours