



VHB™ GPH Series

Product Data Sheet

February 2017
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Product Description 3M™ VHB™ GPH Series, a general purpose, high temperature, grey conformable double coated acrylic foam tape with a high initial tack and a soft foam. Available in three different thicknesses with a 3M branded red siliconised polyethylene film liner.

- Key Features**
- Double coated acrylic foam tape
 - 100 % closed cell acrylic foam
 - High temperature performance (short term 230 °C)
 - Good balance of high temperature and peel & shear performance
 - High initial tack
 - Soft foam enables stress relaxation & an easy application
 - Good sealing properties
 - For indoor and outdoor applications

- Applications & Benefits**
- Its temperature performance enables bonding of materials in applications with high operating temperatures such as prior to processing in a powder coating line
 - Capability to bond to a variety of substrates makes it a good fit for multi material bonding - those substrates have a high or medium surface energy including many metals (e.g. stainless steel) and plastics (e.g. Polyamide, PMMA, ABS)
 - For applications in metal working, signage, appliances and specialty vehicle

Physical Properties

	GPH-060GF	GPH-110GF	GPH-160GF
Adhesive Type	Acrylic foam adhesive		
Thickness acc. to ASTM D-3652	0.60 mm	1.10 mm	1.60 mm
Foam Density	710 kg/m ³		
Release Liner	3M branded red siliconised polyethylene film		
Tape Colour	Grey		

Performance Characteristics

Type	GPH-060GF	GPH-110GF	GPH-160GF
90 ° Peel adhesion to Stainless Steel acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	25 N/cm	37 N/cm	34 N/cm
90 ° Peel adhesion to PA6 acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	33 N/cm	48 N/cm	55 N/cm
90 ° Peel adhesion to ABS acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	21 N/cm	33 N/cm	32 N/cm
90 ° Peel adhesion to PMMA acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	21 N/cm	34 N/cm	37 N/cm
Dynamic Shear acc. to ASTM D1002 on stainless steel, after 72h @ RT dwell	547 N/6.54 cm ²	476 N/6.54 cm ²	375 N/6.54 cm ²
Static Shear Strength acc. to ASTM D3654, after 72h @ RT dwell (Weight held for 10.000 minutes to stainless steel, 3.32cm ² (0.5in ²))	23 °C - 1000 g 150 °C - 500 g		
Normal Tensile (T-Block) acc. to ASTM D897 to Aluminium @ RT, after 72h @ RT dwell, 6.45 cm ² , test speed 50 mm/min	410 N/6.54 cm ²	439 N/6.54 cm ²	470 N/6.54 cm ²
Temperature Performance	Short term (minutes, hours): 230 °C Long term (days, weeks): 150 °C		

Application Temperature

Ideal application temperature range is 21 °C to 38 °C. Pressure sensitive adhesives use viscous flow to achieve substrate contact area.
To obtain good performance with all 3M™ VHB™ Tapes, it is important to ensure that the surfaces are clean, dry and free of condensed moisture.

Shelf Life

24 months from date of production when stored at 16 °C – 25 °C and 40-65 % relative humidity.
Performance of tapes is not projected to change even after shelf life expires; however, 3M does suggest that 3M™ VHB™ Tapes are used prior to the shelf life date whenever possible.

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**3M Svenska AB
Industri**

Bollstanäsvägen 3
191 89 Sollentuna
Tel: 08-92 21 00
Fax: 08-92 22 88
E-post:
kundservice@mmm.com
www.3M.se/tejp

**3M a/s
Industri**

Hannemanns Allé 53
2300 København S
Tlf.: 43 48 01 00
Fax.: 43 20 15 65
E-mail:
dkindustri@mmm.com
www.3Mindustri.dk

**3M Norge AS
Avd. Industri**

Hvamveien 6
2013 Skjetten
Tel: 0 63 84
Fax: 63 84 17 88
E-post:
Kundeservice@mmm.com
www.3M.no/tape

**Suomen 3M Oy
Teollisuustuotteet**

PL 600
Keilaranta 6
02151 Espoo
Puh: 09-525 21
Fax: 09-525 2279
www.3M.fi/teollisuus