

# 3M VHB™ Adhesive Transfer Tapes with High Performance Acrylic Adhesive 100MP

## F9460PC • F9469PC • F9473PC • 9460PC • 9469PC • 9473PC • 9469FL

### Product Data Sheet

Date: September 2022  
Supersedes: July 2018

#### Product Description

3M™ VHB™ Adhesive Transfer Tapes F9460PC, 9460PC, F9469PC, 9469PC, 9469FL, F9473PC and 9473PC utilize the 3M™ High Performance Acrylic Adhesive 100MP, which has good long term holding power.

#### Key Features

- For interior and exterior industrial applications to replace rivets, spot welds and other permanent fasteners.
- 3M™ VHB™ Adhesive Transfer Tapes are transparent

#### Physical Properties

| Products            | F9460PC<br>9460PC                                                                     | F9469PC<br>9469PC | F9473PC<br>9473PC |
|---------------------|---------------------------------------------------------------------------------------|-------------------|-------------------|
| Adhesive thickness* | 0,050 mm                                                                              | 0,125 mm          | 0,250 mm          |
| Liner thickness *   | 0,100 mm                                                                              |                   |                   |
| Liner weight        | 100 g/sqm                                                                             |                   |                   |
| Liner material      | Polycoated paper, brown                                                               |                   |                   |
| Liner printing      | Versions with "F" prefix have liner printing<br>Versions without "F" have no printing |                   |                   |
| Adhesive colour     | transparent                                                                           |                   |                   |

\*AFERA 5006

| Products            | 9469FL                   |
|---------------------|--------------------------|
| Adhesive thickness* | 0,125 mm                 |
| Liner thickness *   | 0,100 mm                 |
| Liner weight        | 100 g/sqm                |
| Liner material      | Polypropylene, unprinted |
| Adhesive colour     | transparent              |

## Performance Characteristics

| Products                                                                                | F9460PC<br>9460PC | F9469PC<br>9469PC<br>9469FL | F9473PC<br>9473PC |
|-----------------------------------------------------------------------------------------|-------------------|-----------------------------|-------------------|
| <b>Adhesion to Stainless Steel</b><br>(FTM2 - after 72 h RT using 50 µm aluminium foil) | 12,0 N/cm         | 19,5 N/cm                   | 19,5 N/cm         |
| <b>Adhesion to PET</b><br>(FTM2 - after 72 h RT using 50 µm aluminium foil)             | 8,7 N/cm          | 11,1 N/cm                   | 12,4 N/cm         |
| <b>Static Shear</b><br>(FTM8 - 1000 g/25 mm* 12,5 mm on stainless steel, 150 °C)        | > 10,000 Minutes  |                             |                   |

|                                                                            |                                                                |
|----------------------------------------------------------------------------|----------------------------------------------------------------|
| <b>Immersion 7 days in Engine oil at 50 °C</b>                             | No changes in appearance                                       |
| <b>Immersion 7 days in 5 % salt water</b>                                  | No changes in appearance                                       |
| <b>7 days high humidity chamber 38 °C, 100 RH</b>                          | No changes in appearance                                       |
| <b>7 days automotive cycle 4 h -40 °C, 4 h 90 °C, 16 h 38 °C, 100 % RH</b> | No changes in appearance                                       |
| <b>Storage 4 h at 260 °C</b>                                               | No changes in appearance                                       |
| <b>Immersion 1 h in Gasoline</b>                                           | No changes in appearance                                       |
| <b>Immersion 1 h 5 % H<sub>2</sub>SO<sub>4</sub></b>                       | No changes in appearance<br>Slight adhesión loss 1 mm at edges |
| <b>Immersion 1 h 5 % NaOH</b>                                              | No changes in appearance<br>Slight adhesión loss 1 mm at edges |

These 3M™ VHB™ Adhesive Transfer Tapes are made from the same adhesive system and are thermoplastic in nature, becoming softer as temperature increases and firmer as temperature decreases. As the adhesive becomes firmer, the adhesion performance generally increases. At low temperatures (lower than -40 °C, the 3M™ VHB™ Adhesive Transfer Tapes become very firm and glassy; the ability to absorb impact energy is reduced.

## Application Techniques

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure helps develop better adhesive contact and improve bond strength. To obtain optimum adhesion, the bonding surfaces must be clean, dry, and well unified. Some typical surface cleaning solvents are isopropyl alcohol/water mixture or heptane. \*

Ideal tape application temperature range is 21 °C to 38 °C. Initial tape application to surfaces at temperatures below 10 °C is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

**\*Note:** Be sure to follow the manufacturer's precautions and directions for use when using solvents.

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|------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Storage &amp; Shelf Life</b>    | Store at 16 °C – 25 °C and 40-65 % relative humidity in its original box. The product can be stored up to 18 months after production.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |
| <b>Recognition / Certification</b> | UL-Recognised in File MH17478                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |
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| <b>For Additional Information</b>  | <p>To request additional product information or to arrange for sales assistance, call.....</p> <p>Address correspondence to: 3M</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
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