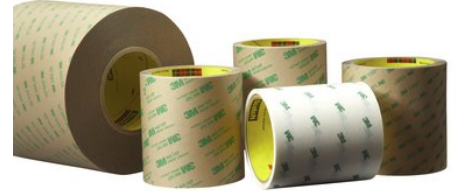


August, 2016

3M™ Adhesive Transfer Tape 6035PL

Product Description

3M™ Acrylic Adhesive Transfer Tape 6035PL is a 5 mil transfer tape formulated for low fog characteristics. The 300MP adhesive is suitable for bonding to most substrates including foams, fabrics and substrates with rough or textured surfaces.



General Information

- 3M 6035PL meets automotive OEM fogging specifications
- Provides excellent bond to a wide variety of surfaces.
- High initial tack for quick and easy assembly line application.
- High temperature resistance to withstand environmental conditions normally associated with automotive interiors.

Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Physical Properties

Property	Values	
Adhesive Type	#300MP Acrylic Adhesive	
Adhesive Thickness	0.127 mm	5 mil
Liner	83# Polycoated Kraft Paper	
Liner Thickness	0.157 mm	6.2 mil

Typical Performance Characteristics

Property	Values		Test Condition
Relative High Temperature Operating Ranges	121 °C	250 °F	Short Term (minutes, hours)
Flammability Test	Pass FMVSS 302/SAE J369		
Automotive Fogging Test	99		SAE J1756 @ 100°C

Environmental Performance (90° Peel)		Environmental Condition
7.1 N/cm	65 oz/in	Unleaded Gas at 1 Hour Room Temperature
4.3 N/cm	39 oz/in	MEK at 1 Hour Room Temperature
9.7 N/cm	89 oz/in	Weak Acid (pH 4) at 4 Hours Room Temperature
8.9 N/cm	81 oz/in	Weak Base (pH 10) at 4 Hours Room Temperature
12.4 N/cm	114 oz/in	Oil (10W30) at 72 Hours 120°F(49°C)
14.7 N/cm	137 oz/in	Water – 100 hours, Room Temperature
15.3 N/cm	140 oz/in	7 Days at 90°F(32°C) and 90% Relative Humidity
14.7 N/cm	134 oz/in	Temperature Cycling: 4 Hours at 158°F (70°C) 4 Hours at -20°F (-29°C) 16 Hours at Room Temperature Repeat three times

Table continued on next page

Typical Performance Characteristics (continued)

Environmental Performance (90° Peel)		Environmental Condition
12.4 N/cm	113 oz/in	Sodium Chloride Solution (5%) - 72 hrs. @ R.T
20.9 N/cm	191 oz/in	Ultraviolet Light - 30 days exposure

Property: Environmental Performance (90° Peel)

Dwell/Cure Time: 24 hr

Substrate: Stainless Steel

Backing: Aluminum Foil

notes: 12 inches/minute (305 mm/minute)

90° Peel Adhesion		Dwell/Cure Time	Substrate
11.2 N/cm	102 oz/in	15 min @ Room Temperature	Stainless Steel
14.3 N/cm	131 oz/in	72 hr @ Room Temperature	Stainless Steel
18.2 N/cm	166 oz/in	72 hr @ 158°F(70°C)	Stainless Steel
9.7 N/cm	89 oz/in	15 min @ Room Temperature	Polycarbonate (PC)
10.5 N/cm	96 oz/in	72 hr @ Room Temperature	Polycarbonate (PC)
7.3 N/cm	67 oz/in	72 hr @ 158°F(70°C)	Polycarbonate (PC)
8 N/cm	73 oz/in	72 hr @ Room Temperature	Polypropylene (PP)
6.9 N/cm	63 oz/in	72 hr @ 158°F(70°C)	Polypropylene (PP)
10 N/cm	93 oz/in	72 hr @ Room Temperature	ABS
8.5 N/cm	78 oz/in	72 hr @ 158°F(70°C)	ABS

Property: 90° Peel Adhesion

Method: ASTM D3330

Backing: 2 mil Aluminum Foil

notes: 12 in/min (300 mm/min)

Typical Environmental Performance

Property	Values
Humidity Resistance	No adverse effect on the bond after exposure to 100% relative humidity at 100°F (38°C)
U.V. Resistance	Adhesive is resistant to oxidation and ozone when exposed to air or ultraviolet light.
Bond Build-Up	The bond strength of the adhesive increases as a function of time and temperature.

Storage and Shelf Life

Product retains its performance properties for 24 months from date of manufacture if properly stored at room temperature conditions of 72°F (22°C) and 50% relative humidity.

Information

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Trademarks

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References

Safety Data Sheet (SDS)

https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=6035PL

Family Group

	6035PC	6035PL	6038PC	6038PL
Relative High Temperature Operating Ranges (°C) Test Condition: Short Term (minutes, hours)	121	121	121	121
Adhesive Type	#300MP Acrylic Adhesive	#300MP Acrylic Adhesive	#300MP Acrylic Adhesive	#300MP Acrylic Adhesive
Adhesive Thickness (mm)	0.127	0.127	0.203	0.203
Liner	58# Polycoated Kraft Paper	83# Polycoated Kraft Paper	58# Polycoated Kraft Paper	83# Polycoated Kraft Paper
Liner Thickness (mm)	0.107	0.157	0.107	0.157

3M™ Adhesive Transfer Tape 6035PL

ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.



Industrial Adhesives and Tapes Division
3M Center
St. Paul, MN 55144-1000
800-362-3550
www.3M.com

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