



# VHB™ Tape

## 5915 • 5930

### Technical Data

December, 2007

#### Product Description

3M™ VHB™ Acrylic Foam Tapes 5915 and 5930 are pressure sensitive adhesive tapes for bonding a wide range of materials, including many paints and lower surface energy plastics in addition to metals and other plastics. The foam is conformable to increase contact with the surfaces. This tape is similar to other products in the 3M™ VHB™ Tape 5952 family except thickness.

#### Construction

Product	3M™ VHB™ Tape	
	5915	5930
<b>Adhesive:</b>	Modified Acrylic	
<b>Adhesive Carrier:</b>	Very Conformable Acrylic Foam (closed cell)	
<b>Thickness:</b>	0.016 in. (0.4 mm)	0.032 in. (0.8 mm)
<b>Density:</b>	43 lb./ft. <sup>3</sup> (690 kg/m <sup>3</sup> )	37 lb./ft. <sup>3</sup> (590 kg/m <sup>3</sup> )
<b>Liner:</b>	Red polyethylene film	
<b>Tape Color:</b>	Black	

#### Typical Physical Properties and Performance Characteristics

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

Product	3M™ VHB™ Tape	
	5915	5930
<b>Peel Adhesion:</b> (stainless steel)	13 lb./in. width (230 N/100 mm)	18 lb./in. width (315 N/100 mm)
<b>Normal Tensile:</b> (aluminum T-block)	90 lb./in. <sup>2</sup> (620 kPa)	90 lb./in. <sup>2</sup> (620 kPa)
<b>Dynamic Shear:</b> (stainless steel)	90 lb./in. <sup>2</sup> (620 kPa)	85 lb./in. <sup>2</sup> (585 kPa)
<b>Static Shear:</b> (stainless steel)	72°F (22°C) 158°F (70°C) 200°F (93°C) 250°F (121°C)	1000 g/0.5 sq. in. (holds 10,000 min.) 500 g/0.5 sq. in. (holds 10,000 min.) 500 g/0.5 sq. in. (holds 10,000 min.) 250 g/0.5 sq. in. (holds 10,000 min.)
<b>Solvent Resistance:</b>	High	
<b>Temperature Resistance:</b>		
Short Term: (minutes, hours)	300°F (149°C)	
Long Term: (days, weeks)	250°F (121°C)	

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<b>Available Sizes</b>	<b>Standard Length:</b>	72 yds. (65.8 m)
	<b>Minimum Width:</b>	1/4 in. (6.4 mm)
	<b>Slitting Tolerance:</b>	± 1/32 in. (± 0.8 mm)
	<b>Core Size (ID):</b>	3.0 in. (76.2 mm)

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<b>Application Guidelines</b>	For maximum bond strength the surfaces should be thoroughly cleaned with a 50:50 mixture of isopropyl alcohol and water. Consult manufacturers directions for use and precautions when using cleaning solvents. Ideal tape application is accomplished when temperature is between 70° and 100°F (between 21° and 38°C) and the bond is allowed to dwell 72 hours. Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended.
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<b>Storage</b>	The optimum storage conditions are 72°F (22°C) and 50% relative humidity.
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<b>Shelf Life</b>	24 months from date of manufacture when stored at 40° to 100°F (4° to 38°C) and 0-95% relative humidity.
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<b>Product Use</b>	All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.
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<b>Limited Warranty</b>	3M warrants for 24 months from the date of manufacture that 3M™ VHB™ Tape will be free of defects in material and manufacture. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. This limited warranty does not cover damage resulting from the use or inability to use 3M™ VHB™ Tape due to misuse, workmanship in application, or application or storage not in accordance with 3M recommended procedures. AN APPLICATION WARRANTY EXPRESSLY APPROVED AND ISSUED BY 3M IS AN EXCEPTION. THE CUSTOMER MUST APPLY FOR A SPECIFIC APPLICATION WARRANTY AND MEET ALL WARRANTY AND PROCESS REQUIREMENTS TO OBTAIN AN APPLICATION WARRANTY. CONTACT 3M FOR MORE INFORMATION ON APPLICATION WARRANTY TERMS AND CONDITIONS.
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<b>Limitation of Remedies and Liability</b>	If the 3M™ VHB™ Tape is proved to be defective within the warranty period stated above. THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M™ VHB™ TAPE. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or strict liability.
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**ISO 9001:2000**

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.



## Industrial Adhesives and Tapes Division

3M Center, Building 21-1W-10, 900 Bush Avenue  
St. Paul, MN 55144-1000  
800-362-3550 • 877-369-2923 (fax)  
www.3M.com/industrial



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