



Adhesive Transfer Tapes

6035PC • 6035PL • 6038PC • 6038PL

Technical Data

August 2016

Description

3M™ Adhesive Transfer Tapes 6035 and 6038 are pressure-sensitive transfer tapes which are specially formulated to be good adhesion to many lower surface energy materials. These tapes are ideal for use in automotive interior applications.

Construction

Product

3M™ Adhesive Transfer Tapes

6035PC

6038PC

Adhesive:	5.0 mils (127 microns) #300MP Acrylic Adhesive	8.0 mils (203 microns) #300MP Acrylic Adhesive
Liner:	4.2 mils (107 microns) 58# Polycoated Kraft Paper	4.2 mils (107 microns) 58# Polycoated Kraft Paper

Product

3M™ Adhesive Transfer Tapes

6035PL

6038PL

Adhesive:	5.0 mils (127 microns) #300MP Acrylic Adhesive	8.0 mils (203 microns) #300MP Acrylic Adhesive
Liner:	6.2 mils (157 microns) 83# Polycoated Kraft Paper	6.2 mils (157 microns) 86# Polycoated Kraft Paper

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.

Flammability Test:
(FMVSS 302/SAE J369) Pass

Automotive Fogging Test:
SAE J1756 @ 100°C 99

Adhesion: ASTM D-3330 (modified) 90° Peel, 12"/minute
(305 mm/minute), 2 mil aluminum foil to various surfaces.

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Typical Physical Properties and Performance Characteristics
(continued)

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

3M™ Adhesive Transfer Tapes 6035PC & 6035PL

Surface	15 Minute Dwell		72 Hour Dwell		72 Hour Dwell @ 158°F	
	Oz./In.	N/100 mm	Oz./In.	N/100 mm	Oz./In.	N/100 mm
Stainless Steel	102	112	131	143	166	182
Polycarbonate (High Surface Energy Plastic)	89	97	96	105	67	73
Polypropylene (Low Surface Energy Plastic)	NA	NA	73	80	63	69
ABS	NA	NA	93	102	78	85

3M™ Adhesive Transfer Tapes 6038PC & 6038PL

Surface	15 Minute Dwell		72 Hour Dwell		72 Hour Dwell @ 158°F	
	Oz./In.	N/100 mm	Oz./In.	N/100 mm	Oz./In.	N/100 mm
Stainless Steel	165	181	210	230	247	270
Polycarbonate (High Surface Energy Plastic)	125	137	146	160	106	116
Polypropylene (Low Surface Energy Plastic)	NA	NA	96	105	82	90
ABS	NA	NA	143	157	120	131

Environmental Performance

Temperature Resistance:	Short term: 250°F (121°C).
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.
Shelf Life:	Product retains its performance properties for two years from date of manufacture if properly stored at room temperature conditions of 72°F (22°C) and 50% relative humidity.

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Environmental Performance (continued)

Properties defined below are based on sample attachment to a stainless steel faceplate material with a 0.002 inch aluminum foil backing. Values are listed based on a 90° peel at 12 inches/minute (305 mm/minute) after a 24 hour dwell. This data is provided as a guideline for the effects on adhesion at the following conditions and should not be used for specification purposes.

Test Condition	3M™ Adhesive Transfer Tapes			
	6035PC & 6035PL		6038PC & 6038PL	
	Oz./In.	N/100 mm	Oz./In.	N/100 mm
Unleaded Gas - 1 hr. @ R.T.	65	71	127	139
Methyl Ethyl Ketone - 1 hr. @ R.T.	39	43	93	102
Oil (10W30) - 72 hrs. @ 120°F (49°C)	114	124	179	196
Weak Acid (pH 4) - 4 hrs. @ R.T.	89	97	139	152
Weak Base (pH 10) - 4 hrs. @ R.T.	81	89	132	145
Water - 100 hrs. @ R.T.	134	147	139	152
7 days @ 90°F (32°C) and 90 R.H.	140	153	215	235
Sodium Chloride Solution (5%) - 72 hrs. @ R.T.	113	124	203	222
Ultraviolet Light - 30 days exposure	191	209	220	241
Temperature Cycling - 4 hrs. @ 158°F (70°C); 4 hrs. @ -20°F (-29°C); 16 hrs. @ R.T. - repeated three times	134	147	200	219

Available Sizes

1" - 3" (25.4 mm - 76.2 mm) Width: 60 yds (54.8 m) maximum roll size
3" - 5" (76.2 mm - 127 mm) Width: 180 yds (165 m) maximum roll size
5" - 60" (127 mm - 1524 mm) Width: 360 yds (329 m) maximum roll size
Standard core size = 3" (76.2 mm) diameter
Width tolerance = $\pm 1/32$ " (0.79 mm)
Sizes other than above are negotiable

Application Techniques

- For maximum bond strength the surface should be thoroughly cleaned and dried. Typical cleaning solvents are heptane or isopropyl alcohol.
Note: Follow the manufacturer's precautions and directions for use when using solvents.
- Bond strength can also be improved with firm application pressure and moderate heat causing the adhesive to develop intimate contact with the bonding surface.
- Ideal adhesive application temperature range is 70°F to 100°F (21°C to 38°C). This is not recommended for application to surfaces at temperatures below 50°F (10°C) because the adhesive becomes too firm to adhere readily. Once properly applied, low temperature holding is satisfactory.

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General Information

- 3M™ Adhesive Transfer Tapes meet OEM fogging specifications.
- Provides excellent bond to a wide variety of smooth surfaces.
- Excellent shear and peel values to both high and low energy surfaces (PP, ABS, painted metal).
- High initial tack for quick and easy assembly line application.
- High temperature resistance to withstand environmental conditions normally associated with automotive interiors.

Application Ideas

- Attaching a wide variety of vibration and sound damping materials.
- Attaching the wiring harness to the automobile headliner.
- Attaching interior panels.
- Attaching glass to rearview mirror assembly.

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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ISO 9001

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

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