



# Scotch-Mount™

## 4016 Double Coated Foam Tape

### Product Data Sheet

Updated : February 1996

Supersedes : January 1994

#### Product Description

A-20 is a firm acrylic pressure sensitive adhesive system. It features high ultimate bond strength, very good high temperature

and solvent resistance and very high shear holding power. Bond strength increases substantially with time.

#### Physical Properties

Not for specification purposes

<b>Adhesive Type</b>	Acrylic	<b>3M ref</b> : A-20
<b>Foam Core</b>	Polyurethane Foam (Open Cell)	<b>Foam Density</b> 175 kg/m <sup>3</sup>
<b>Thickness</b> (ASTM D-3652) Tape Liner Total	1.60 mm 0.08 mm 1.68 mm	
<b>Thickness Tolerance</b>	1.14 - 2.03 mm	
<b>Release Liner</b>	Green Plaid Paper	
<b>Tape Colour</b>	Natural*	* The tape colour varies from white to light yellow. The colour will change to light yellow upon exposure to sunlight (ultraviolet radiation). This colour change is normal and does not affect tape performance.
<b>Shelf Life</b>	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

#### Performance

##### Characteristics

Not for specification purposes

<b>Static Shear Strength</b> weight held for 100 hours to stainless steel with ½ sq in (3.23 sq cm) overlap	1500 g @ 22°C 1000 g @ 49°C 750 g @ 66°C 750 g @ 93°C	
<b>Temperature Performance</b> Max (hours/minutes) Max Continuous (days/weeks)	190°C 105°C	
<b>Normal Tensile (T-Block)</b> to Aluminium at room temp, 6.45 sq cm, jaw speed 50 mm/min.	345 kPa	
<b>Solvent Resistance</b>	No apparent degradation when exposed to splash testing of most hydrocarbon solvents.	
<b>UV Light Resistance</b>	No apparent degradation when exposed to 7 days in U. V. Chamber.	

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4016 Double Coated Foam  
Tape

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### Additional Product Information

**Cold Flex at -30°C(-20°F)**  
No cracking when flexed around a 6.4mm mandrel.

**Thermal Conductivity**  
(Watt/m Kelvin)  
0.062

**Dielectric Strength**  
(Volts/25µm)  
200-300

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### Application Techniques

1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact & thus improves bond strength.

2. To obtain optimum adhesion, the bonding

surfaces must be clean dry and well unified. A typical surface cleaning solvent is isopropyl alcohol. Use proper safety precautions for handling solvents.

3. Ideal tape application temperature range is 21°C to 38°C (70°F to 100°F).

Initial tape application to surfaces at temperatures below 10°C (50°F) is not recommended because the adhesive becomes too firm to adhere readily. However once properly applied low temperature holding is generally satisfactory.

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### Applications

4016 urethane foam is soft, conformable and high in internal strength which makes it ideal for general purpose joining.

The excellent cold temperature properties of this product makes it suited for applications on snowmobiles, freezers etc.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



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