



# VHB™ GPH Series

## Product Data Sheet

August 2016  
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**Product Description** 3M™ VHB™ GPH Series, a general purpose, high temperature, grey conformable double coated acrylic foam tape with a high initial tack and a soft foam. Available in three different thicknesses with a 3M branded red siliconised polyethylene film.

- Key Features**
- Double coated acrylic foam tape
  - 100% closed cell acrylic foam
  - High temperature performance (short term 230°C)
  - Good balance of high temperature and peel & shear performance
  - High initial tack
  - Soft foam enables stress relaxation & an easy application
  - Good sealing properties
  - For indoor and outdoor applications

- Applications & Benefits**
- Its temperature performance enables bonding of materials in applications with high operating temperatures such as prior to processing in a powder coating line
  - Capability to bond to a variety of substrates makes it a good fit for multi material bonding - those substrates have a high or medium surface energy including many metals (e.g. stainless steel) and plastics (e.g. Polyamide, PMMA, ABS)
  - For applications in metal working, signage, appliances and specialty vehicle

**Physical Properties**

	GPH-060GF	GPH-110GF	GPH-160GF
<b>Adhesive Type</b>	Acrylic foam adhesive		
<b>Thickness</b> acc. to ASTM D-3652	0.60 mm	1.10 mm	1.60 mm
<b>Foam Density</b>	710 kg/m <sup>3</sup>		
<b>Release Liner</b>	3M branded red siliconised polyethylene film liner		
<b>Tape Colour</b>	Grey		

**Performance Characteristics**

Type	GPH-110GF
<b>90° Peel adhesion to Stainless Steel</b> acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	39 N/cm
<b>90° Peel adhesion to Polyamide 6</b> acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	48 N/cm
<b>90° Peel adhesion to ABS</b> acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	33 N/cm
<b>90° Peel adhesion to PMMA</b> acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	34 N/cm

**Performance Characteristics**

Type	GPH-060GF	GPH-110GF	GPH-160GF
<b>Dynamic Shear</b> acc. to ASTM D1002 on stainless steel, after 72h @ RT dwell	559 N/ 6.54 cm <sup>2</sup>	476 N/ 6.54 cm <sup>2</sup>	387 N/ 6.54 cm <sup>2</sup>
<b>Static Shear Strength</b> acc. to ASTM D3654, after 72h @ RT dwell (Weight held for 10.000 minutes to stainless steel, 3.32cm <sup>2</sup> (0.5in <sup>2</sup> ))	23°C - 1000 g 150°C - 500 g		
<b>Normal Tensile (T-Block)</b> acc. to ASTM D897 to Aluminium @ RT, after 72h @ RT dwell, 6.45 cm <sup>2</sup> , test speed 50 mm/min	399 N/ 6.54 cm <sup>2</sup>	438 N/ 6.54 cm <sup>2</sup>	454 N/ 6.54 cm <sup>2</sup>
<b>Temperature Performance</b>	Short term (minutes, hours): 230°C Long term (days, weeks): 150°C		

**Application Temperature**

Ideal application temperature range is 21 °C to 38 °C. Pressure sensitive adhesives use viscous flow to achieve substrate contact area. To obtain good performance with all 3M™ VHB™ Tapes, it is important to ensure that the surfaces are clean, dry and free of condensed moisture.

**Shelf Life**

24 months from date of production when stored at 16°C – 25°C and 40-65 % relative humidity. Performance of tapes is not projected to change even after shelf life expires; however, 3M does suggest that 3M™ VHB™ Tapes are used prior to the shelf life date whenever possible.

**Important Notice**

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 or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law.

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3M United Kingdom PLC 4 <sup>th</sup> Floor, Building 8, Exchange Quay, Salford Quay, Manchester, M5 3EH	Product Information :  Tel 0870 60 800 50 Fax 0870 60 700 99	3M Ireland Limited The Iveagh Building The Park, Carrickmines Dublin 18, Ireland	Customer Service :  Tel (01) 280 3555 Fax (01) 280 3509
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