VHB™ Tapes

Proven in a variety of sign bonding applications for over 25 years

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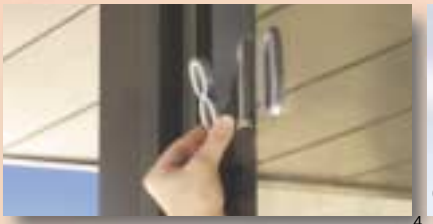
3M™ VHB™ Tape provides durable bonding in outdoor applications.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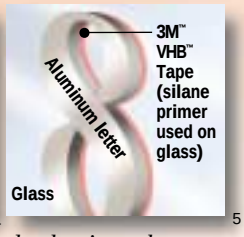

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Clear 3M™ VHB™ Tape permanently bonds aluminum letters to glass and appears almost invisible from behind the pane.

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Bond dimensional letters to a painted wall.

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3M™ VHB™ Tape bonds the aluminum skin to the light cabinet replacing unsightly screws and weld lines.

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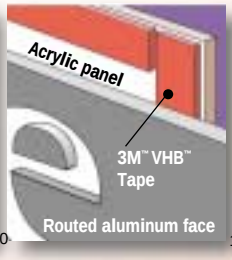

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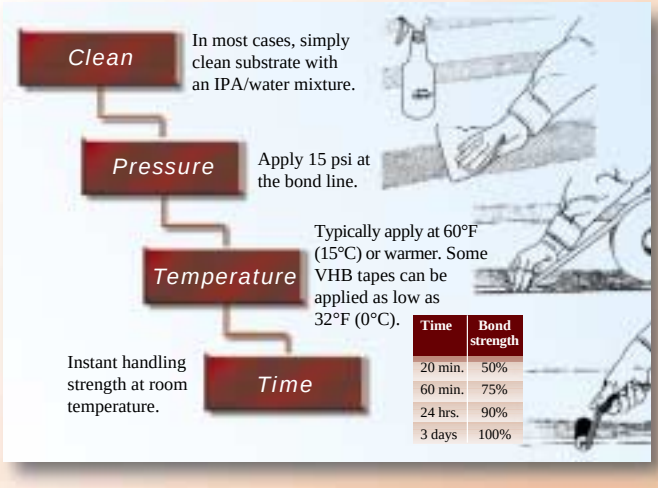
For a smooth surface on a monument sign, 3M™ VHB™ Tape bonds an acrylic panel behind a routed aluminum face.

- High holding power and long-term reliability indoors and outdoors
- Bonds metals, plastics, glass, foam board, and more
- Invisible fastening for smooth, attractive surfaces
- Instant handling strength compared to liquid adhesives
- Easy application without drilling, screwing, riveting, or welding

Details and more applications – www.3M.com/VHBsigns



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3M™ VHB™ Tapes Sign Bonding Guide

	Unpainted Aluminum and Steel	Acrylic, Polycarbonate	Expanded Rigid PVC Board	Flexible Vinyl
Unpainted Aluminum and Steel	5952	5952	5952	4941
Painted Surfaces (drywall, metal, wood, concrete)	5952	5952	5952	4941
Acrylic, Polycarbonate	5952	5952	5952	4941
Glass	5952	5952	5952	4941
Transparent Applications	4910	4910	-	-

General application considerations

Additional technical information is available at www.3M.com/VHBsigns (see bulletins under Product Documentation in the website)

Tape Thickness and Roll Sizes

- Minimum suggested tape thickness is 0.04" for most rigid substrates to provide adequate gap filling

  4910 is 0.04"; 5952 and 4941 are 0.045"
- Thinner 3M™ VHB™ Tapes as thin as 0.015" may be evaluated if one of the substrates is thin and/or flexible
- Thicker 3M™ VHB™ Tapes up to 0.12" should be evaluated for rough and uneven substrates (like concrete)
- Standard stocked tape widths are typically 1/2", 3/4" and 1"

  Custom widths from 1/4" to 46-48" are also available
- For additional information on tape type, thickness, widths and roll lengths consult 3M™ VHB™ Tapes Data Page on the website

Load Holding

- For static loads a minimum of 4 square inches of tape contact area is recommended to support 1 pound of weight
- For dynamic loads consult 3M™ VHB™ Tapes Data Page on the website

Initial Bonding Temperature

- Recommended initial bonding temperature is 60°F (15°C) or higher
- For low-temperature initial bonding down to 32°F (0°C) consult 3M™ VHB™ Tapes Data Page on the website
- Once properly bonded, low-temperature holding is generally satisfactory

Surface Preparation

- Most aluminum, steel, acrylic, polycarbonate, and painted/sealed substrates are best prepared by cleaning with a 50:50 mixture of isopropyl alcohol (IPA) and water prior to applying 3M™ VHB™ Tape
- Some glossy surfaces (certain paints and expanded rigid PVC board) may benefit from slight scuffing with a mild abrasive pad prior to cleaning with the IPA/water mixture
- Glass, unpainted surfaces (concrete, drywall, wood, copper, brass, bronze), and some plasticized vinyl substrates may require additional priming
- For additional details and primer suggestions consult bulletin: Surface Preparation for 3M™ VHB™ Tapes Applications on the website

Tape Colors and Backing

5952: Black tape with plastic backing

4941: Grey tape with paper backing (white and black versions and plastic backing available)

4910: Clear tape with plastic backing

4950: White tape with paper backing (black version available)

UL® Listing

- 3M™ VHB™ Tapes are listed in the Sign Accessory Manual under file number E65361
- See listing information under UL® Certification Sign Accessories on the website

Warranty: 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 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. **Important Notice:** User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be bonded with the product, the surface preparation of these materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which 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. **Limitation of Remedies and Liability:** 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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Display and Graphics Business

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