



# Technical Data Sheet

3M™ VHB™ Tape 47715



Additional Info

## Product Description

3M™ VHB™ Tape 47715 is a 0.15mm (0.006 inch) thick grey double-sided acrylic foam tape with PET liners and is used for bonding to a variety of high and medium surface energy materials in the electronics industry. This specially formulated product provides impact resistance and high bond strength while also providing high shear and tensile strength.

## Product Features

- High modulus
- Good impact resistance
- High shear and tensile strength
- High bonding strength
- Excellent tensile creep performance
- Waterproof
- Dark Grey color

## Technical Information Note

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

## Typical Physical Properties

Attribute Name	Test Method	Value
Total Tape Thickness	ASTM D3652	0.15 mm (0.006 in)
Color		Dark Grey
Primary Liner Thickness		0.05 mm (0.002 in)
Primary Liner Color		Clear
Secondary Liner Thickness		0.075 mm (0.003 in)
Secondary Liner Color		Clear
Shear Modulus		0.85 MPa <sup>1</sup>

<sup>1</sup> DMA testing at 25 °C, 1Hz

## Typical Performance Characteristics

### **180° Peel Adhesion**

Temperature: 23 °C (73 °F)

Dwell Time: 72 h

Backing: 2 mil PET

Test Method: ASTM D3330

Substrate	Value
Stainless Steel	1.00 N/mm (5.7 lb/in) <sup>1</sup>
Polycarbonate (PC)	1.58 N/mm (9.0 lb/in) <sup>1</sup>
ABS	1.15 N/mm (6.5 lb/in) <sup>1</sup>
Glass	1.00 N/mm (5.7 lb/in) <sup>1</sup>

<sup>1</sup> 300 mm/min (12 in/min)

Dwell Time: 24 h

Attribute Name	Test Method	Temperature	Substrate	Backing	Value
Static Shear	ASTM D3654	23 °C (73 °F)	Stainless Steel	2 mil Aluminum Foil	1,000 g <sup>1</sup>
Static Shear	ASTM D3654	70 °C (158 °F)	Stainless Steel	2 mil Aluminum Foil	500 g <sup>1</sup>
Overlap Shear Strength	ASTM D1002	23 °C (73 °F)	Stainless Steel		0.95 MPa (130 lb/in <sup>2</sup> ) <sup>2</sup>
Normal Tensile	ASTM D897	23 °C (73 °F)	Aluminum		0.85 MPa (120 lb/in <sup>2</sup> ) <sup>2</sup>

<sup>1</sup> 25 x 25 mm (1 in x 1 in) sample area, test terminated after 10,000 minutes

<sup>2</sup> 6.45 cm<sup>2</sup> (1 in<sup>2</sup>), Jaw Speed 10.0 mm/min (0.39 in/min)

## Handling/Application Information

### Application Techniques

For maximum bond strength the surfaces should be thoroughly cleaned with a 50:50 mixture of isopropyl alcohol and water. Consult manufacturer's directions for use and precautions when using cleaning solvents. Ideal tape application is accomplished when temperature is between 21° and 38°C (between 70° and 100°F) and the bond is allowed to dwell 72 hours. Initial tape application to surfaces at temperatures below 10°C (50°F) is not recommended.

### Storage and Shelf Life

This product has a shelf life of 24 months from date of manufacture when stored at 4°C to 38°C (40°F to 100°F) and 0-95% relative humidity. The optimum storage conditions are 22°C (72°F) and 50% relative humidity.

### Available Sizes

Attribute Name	Value
Standard Width	600 mm (23.6 in)
Standard Roll Length	100 m (109 yd)

## Information

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## **ISO Statement**

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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