



Adhesive, Foam Tape, Vinyl, Double Coated

1 Scope

This specification covers a double coated vinyl foam tape. The adhesive is a high tack, permanent acrylic pressure sensitive type.

1.1 Material Description. This tape is identified by type.

1.1.1 Type 1: 0.8 mm nominal thickness.

1.1.2 Type 2: 1.6 mm nominal thickness.

1.1.3 Type 3: 3.2 mm nominal thickness.

1.2 Symbols. Not applicable.

1.3 Applicability. Bonding of various interior plastics except for plastics with a low surface energy.

2 References

Note: Only the latest approved standards are applicable unless otherwise specified.

2.1 External Standards/Specifications.

ASTM D412

ASTM D1667

ASTM D3330

ASTM D3652

2.2 GM Standards/Specifications.

GMW3059

GMW3221

GMW14444

GMW16853

3 Requirements

3.1 Requirements on Test Specimens. Reference GMW3221.

3.2 Emissions Testing of Interior Materials and Parts. For all Code E designated parts per GMW14444, reference GMW16853 for emissions testing of interior materials and parts.

3.3 Properties. See Table 1.

Table 1: Properties

Properties	Type 1	Type 2	Type 3	Test Method
	Type 1	Type 2	Type 3	-
Color	White/Black	White/Black	Black	-
Liner Removability (90 degree peel @ 2286 mm/minimum)	-	-	-	ASTM D3330
90 degree Peel Strength ^{Note 1} @ 300 mm/minute				-
To Stainless Steel	0.52 N•m	0.88 N•m	0.35 N•m	
To ABS	0.09 N•m	0.09 N•m	0.05 N•m	
To Polypropylene	0.09 N•m	0.09 N•m	0.05 N•m	
Tensile Strength minimum	650 kPa	650 kPa	650 kPa	ASTM D412
Elongation percentage minimum	200%	200%	200%	ASTM D412
Density, without adhesive	0.42 g/cm ³ to 0.75 g/cm ³	0.30 g/cm ³ to 0.48 g/cm ³	0.25 g/cm ³ to 0.37 g/cm ³	ASTM D1667
Compression Modulus @ 25% Deflection	170 kPa to 240 kPa	55 kPa to 80 kPa	55 kPa to 80 kPa	ASTM D1667
Compression Set @ 25% Deflection	20% maximum	20% maximum	20% maximum	ASTM D1667

Note 1: Apply with 6.8 kg roller, GMW3221, Code A for 72 h dwell. Apply 2 mm foil to side not bonded to substrate.

ABS = Acrylonitrile Butadiene Styrene

3.3.1 Shelf Life. Material shall pass all requirements of this specification after aging material in the original container 90 days at 35 °C.

3.3.2 Width. To be called out on engineering drawing or math file.

3.3.3 Thickness ASTM D3652. See Table 2.

Table 2: Thickness

	Thickness (Millimeters)	
Type	Total (Nominal)	Tolerance
I	0.8	0.72 to 0.98
II	1.6	1.17 to 1.93
III	3.2	2.80 to 3.50

3.4 Packaging. Tape to be furnished in evenly and uniformly wound rolls on suitable covers with a silicone treated paper or polyethylene release liner (if applicable), easily removable with no separation of material.

4 Manufacturing Process

Not applicable.