



Acrylic Foam Tape 5344

Technical Data Sheet

May 1998

QS 9000 Certified

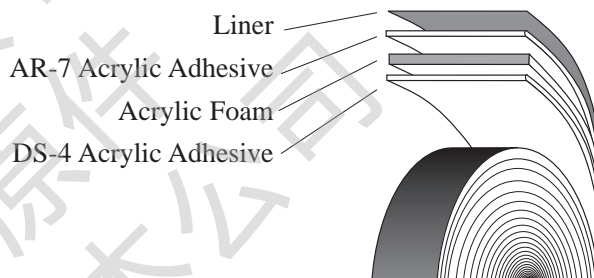
Supersedes Technical Data Sheet dated 1995

General Description

3M™ Acrylic Foam Tape (AFT) 5344 is a gray, double-coated acrylic foam tape commonly used for the attachment of automotive exterior trim parts such as body side moldings. AFT 5344 is a medium density foam tape providing a balance of conformability and strength. The acrylic foam core has unique viscoelastic properties that allow it to elongate and relax when put under a load, thereby minimizing stress on the adhesive bond line. AFT 5344 has AR-7 adhesive on the liner side of the product for bonding to automotive paint surfaces. DS-4 adhesive is used on the non-liner side of this product for bonding to the exterior trim part.

Product Construction

3M Acrylic Foam Tape 5344



Shelf Life

One year from date of receipt by customer when stored at 22°C (72°F) and 50% relative humidity.

Physical Properties

Values shown are typical values not to be used for specification purposes.

Foam	Gray acrylic	
Adhesive	Liner side:	AR-7
	Non-liner side:	DS-4
Thickness	1.14 mm (± 0.10 mm)	(0.045 in ± 0.004 in)
Density	688 kg/m ³ (± 80 kg/m ³)	(43 lb/ft ³ ± 5 lb/ft ³)

Roll Width and Length

3M acrylic foam tapes are available in the following standard widths. Millimeter widths rounded to the nearest whole numbers (7, 8, 9 mm . . .) and 1/8 inch increments starting with 1/4 inch (0.25, 0.375, 0.50, 0.625 inch . . .).

Roll widths	min. 4 mm	(0.157 in)
Tolerance	± 0.38 mm	(± 0.015 in)

Roll Width	Roll Length (maximum)
< 8 mm (< 0.315 in)	66 meters (72 yards)
8 - 9.5 mm (0.315 - 0.375 in)	99 meters (108 yards)
> 9.5 mm (> 0.375 in)	132 meters (144 yards)

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Performance Properties Performance tests are run using standard test procedures. These values presented are typical values not to be used for specification purposes.



1. Breakaway and Continuing Peel

72 hrs at 22°C (72°F)	Breakaway Peel	111 N/12.7 mm	(25 lbs/.5 in)
	Continuing Peel	51 N/12.7 mm	(9 lbs/.5 in)
72 hrs at 70°C (158°F)	Breakaway Peel	133 N/12.7 mm	(30 lbs/.5 in)
	Continuing Peel	58 N/12.7 mm	(12 lbs/.5 in)
72 hrs at 38°C/100% RH (100°F/100%RH)	Breakaway Peel	133 N/12.7 mm	(30 lbs/.5 in)
	Continuing Peel	49 N/12.7 mm	(10 lbs/.5 in)

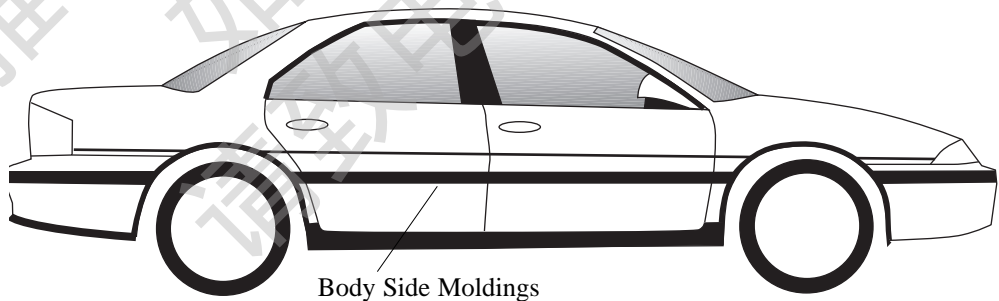
Breakaway and continuing peel tests are run with 12.7 mm (0.5 in) wide tape on PVC test bars. Tests were run on base coat/clear coat paint at a separation rate of 305 mm/min (12 in/min).



2. Static Shear

Exceeds 100 hours at 70°C (158°F). Static shear tests are run with 12.7 mm (0.5 in) wide by 50.8 mm (2 in) long tape on PVC test bars, 6.8 kg (15 lbs) roll-down against stainless steel. Static weight is 250 gm (0.55 lbs)

**Typical Applications of
3M™ Acrylic Foam Tape 5344**



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