

April, 2019

## 3M™ VHB™ Tape 5925WF

### Product Description

Finite Element Analysis (FEA) data is available for this product at: [3m.com/FEA](https://www.3m.com/FEA)

3M™ VHB™ Tape 5925WF is a 0.025 inch (0.6 mm) thick white double coated acrylic foam tape with PE film liner. The modified acrylic adhesive on both sides bonds to a broad range of high, medium and medium/low surface energy substrates including metals, glass and a wide variety of plastics and paints, including many powder coated paints. The very conformable foam provides good contact between substrates even when they are slightly mismatched. 3M™ VHB™ Tape 5925WF is part of the 5952 tape family. Each product in this family has modified acrylic adhesive and very conformable foam but varies in thickness, color and liner type.



### Product Features

- Fast and easy-to-use permanent bonding method provides high strength and long-term durability
- Virtually invisible fastening keeps surfaces smooth
- Can replace mechanical fasteners (rivets, welding, screws) or liquid adhesives
- White, 0.025 in (0.6 mm), modified acrylic adhesive and very conformable acrylic foam core bonds to a wide variety of substrates including powder coated paints and irregular surfaces
- Eliminate drilling, grinding, refinishing, screwing, welding and clean-up
- Creates a permanent seal against water, moisture and more by offering better gap filling capabilities
- Pressure sensitive adhesive bonds on contact to provide immediate handling strength
- Allows the use of thinner, lighter weight and dissimilar materials

**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**

Property	Values		Method	Notes	Attribute Modifier
Color	White				
Tape Thickness	0.6 mm	0.025 in			
Thickness Tolerance	±15 %				
Adhesive Type	Modified Acrylic				
Foam Type	Very Conformable Acrylic Foam				
Density	590 kg/m <sup>3</sup>	37 lb/ft <sup>3</sup>	ASTM D3574	Foam with adhesive	
Liner	PE Film				
Liner Color	Red (printed)				Primary
Liner Thickness	0.13 mm	0.005 in			

**Typical Performance Characteristics**

Property	Values	Method	Dwell Time	Dwell Units	Temp C	Temp F	Environmental Conditions	Substrate	Backing	Notes	Test Condition
90° Peel Adhesion	17 lb/in 30 N/cm	ASTM D3330	72 hr		22C	72F	52%RH	Stainless Steel	2 mil Aluminum Foil	12 in/min (300 mm/min)	
Normal Tensile	515 kPa 75 lb/in <sup>2</sup>	ASTM D897	72 hr @ Room Temperature					Aluminum		1 in <sup>2</sup> (6.45 cm <sup>2</sup> ), Jaw Speed 2 in/min (50.8 mm/min). Peak force to separate is measured.	Room Temperature

Table continued on next page

Typical Performance Characteristics (continued)

Property	Values	Method	Dwell Time	Dwell Units	Temp C	Temp F	Environmental Conditions	Substrate	Backing	Notes	Test Condition
Overlap Shear Strength	620 kPa 90 lb/in <sup>2</sup>	ASTM D1002	72 hr @ Room Temperature					Stainless Steel		1 in <sup>2</sup> (6.45 cm <sup>2</sup> ), Jaw speed 0.5 in/min (12.7 mm/min). Peak force to separate is measured.	Room Temperature
Short Term Temperature Resistance	149 °C 300 °F									No change in room temperature dynamic shear properties following 4 hours conditioning at indicated temperature with 100 g/static load. (Represents minutes, hours in a process type temperature exposure).	
Long Term Temperature Tolerance	93 °C 200 °F									Maximum temperature where tape supports at least 250 g load per 0.5 in <sup>2</sup> in static shear for 10,000 minutes. (Represents continuous exposure for days or weeks).	

Static Shear	Test Condition
1000 g	Room Temperature
500 g	66°C (150°F)
250 g	93°C (200°F)

Property: Static Shear  
 Method: ASTM D3654  
 Substrate: Stainless Steel  
 notes: Tested at various temperatures and gram loadings. 0.5 in<sup>2</sup> (3.23 cm<sup>2</sup>). Will hold listed weight for 10,000 minutes (approximately 7 days).

Available Sizes

Property	Values	Attribute Modifier
Standard Roll Length	65.8 m	72 yd
Minimum Available Width	6.4 mm	0.25 in
Maximum Available Width	1168 mm	46 in
Normal Slitting Tolerance	±0.79 mm	±1/32 in
Core Size	76.2 mm	3 in ID

Available Sizes (continued)

Available Sizes:

Available Sizes				Maximum Roll Length		
Tape Thickness inches (mm)	Standard Length yards (meters)	Minimum Width inches (mm)	Maximum Width inches (mm)	Width 1/4" up to 3/8" (6.4mm up to 9.5mm) yards (meters)	Width >3/8" up to 1/2" (>9.5mm up to 12.7mm) yards (meters)	Width 1/2" and wider (12.7mm and wider) yards (meters)
< 0.015 (0.4)	72 (65.8)	0.5 (13)	46 (1168)	N/A N/A	N/A N/A	See Note Below
0.015/0.016 (0.4)	72 (65.8)	0.25 (6)	48* (1219)	144 (131.7)	175 (160.0)	360 (329.2)
0.025 (0.6)	72 (65.8)	0.25 (6)	48* (1219)	72 (65.8)	108 (98.8)	175 (160.0)
0.032 (0.8)	72 (65.8)	0.25 (6)	48 (1219)	72 (65.8)	108 (98.8)	175 (160.0)
0.040 (1.0)	36 (32.9)	0.25 (6)	48 (1219)	72 (65.8)	108 (98.8)	144 (131.7)
0.045 (1.1)	36 (32.9)	0.25 (6)	48 (1219)	72 (65.8)	108 (98.8)	144 (131.7)
0.062 (1.6)	36 (32.9)	0.25 (6)	46 (1168)	72 (65.8)	72 (65.8)	108 (98.8)
0.090 (2.3)	36 (32.9)	0.25 (6)	46 (1168)	36 (32.9)	36 (32.9)	72 (65.8)

\*Exception – 5915 (P) max. width 46 inches (1168 mm); 5925 (P) max. width 47 inches (1194 mm).

Note: 5952 family tapes thinner than 0.015 in (0.4 mm) have max. length 360 yd (329.2 m) for widths 1 in (25 mm) to 8 in (203 mm) and 180 yd (164.6 m) for all other widths.

Converted Parts

In addition to standard and custom roll sizes available from 3M through the distribution network, 3M™ VHB™ Tapes are also available in limitless shapes and sizes through the 3M Converter network. For additional information, contact 3M Converter Markets at 1-800-223-7427 or on the web at [www.3M.com/converter](http://www.3M.com/converter).

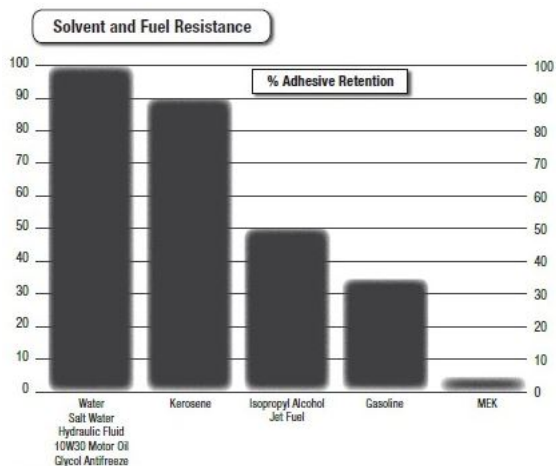
UL746C Listings

3M™ VHB™ Tapes UL746C Listings - File MH 17478 Category 000W2 Component - Polymeric Adhesive Systems, Electrical Equipment			
3M™ VHB™ Tapes/ Product Families	Substrates	Temperature Rating	
		Minimum	Maximum
4919F, 4926, 4936, 4936F, 4941, 4941F, 4947F, 4956, 4956F, 4979F	Ceramic	-35°C	110°C
	Aluminum, Galvanized Steel, Stainless Steel, Enameled Steel, Nickel Coated ABS, Glass (with or without Silane Coating) PVC, Glass/Epoxy, PBT, Polycarbonate, Acrylic/Polyurethane Paint, Polyester Paint	-35°C	90°C
4991	ABS	-35°C	75°C
	Polycarbonate, Aluminum, Acrylic/ Polyurethane Paint, Polyester Paint	-35°	90°C
5915, 5915P, 5915WF 5925, 5925P, 5925WF 5930, 5930P, 5930WF, 5952, 5952P, 5952WF, 5962, 5962P, 5962WF	Polycarbonate, Primer 94 Coated Polycarbonate, Aluminum, Acrylic/ Polyurethane Paint, Galvanized Steel, Polyester Paint, Epoxy Paint, Silane Coated Glass, Uncoated Glass, Stainless Steel, Enameled Steel, Glass Epoxy, Polybutylene Terephthalate, Nylon, Polyphenylene Ether (PPE), Acrylic	-35°C	90°C
	Rigid PVC, ABS	-35°C	75°C
5952, 5952P, 5952WF	Cellulose Acetate Butyrate	-35°C	90°C
RP16	Aluminum, Silane Coated Glass	-35°C	90°C
RP16, RP25, RP32, RP45, RP62	PVC, ABS	-35°C	75°C
	Galvanized Steel, Enameled Steel, Nylon, Polycarbonate, Glass Epoxy, Phenolic, PPE/PS Blend, PBT, Epoxy Paint, Polyester Paint, Adhesion Promoter 111 Coated Epoxy Paint, Promoter 111 Coated Polyester Paint, Acrylic Urethane Paint, Epoxy/ Polyester Paint	-35°C	90°C
RP62	Stainless Steel, Glass, Acrylic	-35°C	90°C
	PVC, ABS	-35°C	75°C

A current list can be found at [www.ul.com](http://www.ul.com) (select certifications, search file MH17478)

**Solvent and Fuel Resistance**

**Solvent Resistance:**



**Test Method**

- Tape between stainless steel and aluminum foil
- 72 hours dwell at room temperature
- Solvent immersion for 72 hours
- Test within 45 minutes after removing from solvent
- 90° peel angle
- 12 in/min rate of peel
- Peel adhesion compared to control

**Note:** Continuous submersion in chemical solutions is not recommended. The above information is presented to show that occasional chemical contact should not be detrimental to tape performance in most applications in ordinary use.

**Additional Typical Performance Characteristics**

Property	Values	Method	Test Condition
Water Vapor Transmission	See 3M™ VHB™ Tape 5952 g/m <sup>2</sup> /24 hr	ASTM F1249	@ 38°C/100% RH
Shear Modulus	See 3M™ VHB™ Tape 5952 Pa		
Poisson's Ratio	See 3M™ VHB™ Tape 5952		
Coefficient of Thermal Expansion	See 3M™ VHB™ Tape 5952 m/m/°C		

**Electrical and Thermal Properties**

Property	Values	Method	Test Condition
Dielectric Constant	See 3M™ VHB™ Tape 5952	ASTM D150	1 KHz, Room Temperature
Dielectric Constant	See 3M™ VHB™ Tape 5952	ASTM D150	1MHz, Room Temperature
Dissipation Factor	See 3M™ VHB™ Tape 5952	ASTM D150	1 KHz, Room Temperature
Dissipation Factor	See 3M™ VHB™ Tape 5952	ASTM D150	1MHz, Room Temperature

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**Electrical and Thermal Properties (continued)**

Property	Values	Method	Test Condition
Dielectric Strength	See 3M™ VHB™ Tape 5952 V/μm	ASTM D140	
Thermal Conductivity	See 3M™ VHB™ Tape 5952 W/m/K		
Volume Resistivity	See 3M™ VHB™ Tape 5952 Ω-cm	ASTM D257	Room Temperature
Surface Resistivity	See 3M™ VHB™ Tape 5952 Ω/sq	ASTM D257	Room Temperature

**Design Considerations**

Adhesion to the substrate is important in achieving bonding success. Adhesives must flow onto the substrate surfaces in order to achieve intimate contact area and allow the molecular force of attraction to develop. The degree of flow of the adhesive on the substrate is largely determined by the surface energy of the substrate. 3M™ VHB™ 5952 family tapes bond well to high (HSE), medium (MSE), and medium/low (M/LSE) surface energy materials. The image below shows typical materials in these categories.

Achieving good contact is also important. The necessary thickness of tape depends on the rigidity of substrates and their flatness irregularity. While the 3M™ VHB™ Tapes will conform to a certain amount of irregularity, they will not flow to fill gaps between the materials. For bonding rigid materials with normal flatness, consider use of tapes with thickness of 45 mils (1.1 mm) or greater. As the substrate flexibility increases thinner tapes can be considered.

Using the right amount of tape is important to handle the expected stresses. Because 3M™ VHB™ Tapes are viscoelastic by nature their strength and stiffness is a function of the rate at which they are stressed. They behave stronger with relatively faster rate of stress load (dynamic stresses) and will tend to show creep behavior with stress load acting over a long period of time (static stresses). As a general rule, for static loads, approximately four square inches of tape should be used for each pound (57 cm<sup>2</sup> of tape per kg) of weight to be supported in order to prevent excessive creep. For dynamic loads a useful design factor is 12 lb/in<sup>2</sup> (85 kPa) for most dynamic stresses in general applications.

Allow for thermal expansion/contraction. 3M™ VHB™ Tapes can perform well in applications where two bonded surfaces may expand and contract differentially.

Assuming good adhesion to the substrates, the tapes can typically tolerate differential movement in the shear plane up to 3 times their thickness.

Bond Flexibility: While an advantage for many applications where allowing differential movement is a benefit, the tape bonds are typically more flexible than alternative bonding methods. Suitable design modifications or periodic use of rigid fasteners or adhesives may be needed if additional stiffness is required.

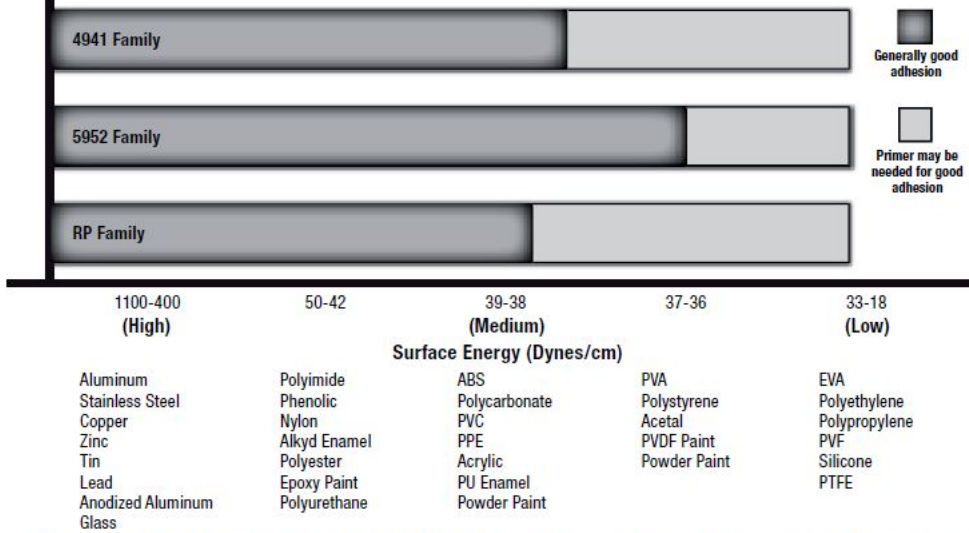
Performance in Severe Cold Temperature can be challenging. Applications which require performance at severe cold temperatures must be thoroughly evaluated by the user if the intended use will subject the tape product to high impact stresses. A technical bulletin “3M™ VHB™ Tape Cold Temperature Performance” (70-0707-3991-0) is available for additional information.

**Design Considerations (continued)**



This illustration demonstrates the effect of surface energy on adhesive interfacial contact. High surface energy materials draw the adhesive closer for high bond strength.

**Relationship of Adhesion and Surface Energy for 3M™ VHB™ Tape Adhesive Families**



**NOTES:** There are a wide variety of formulations, surfaces finishes and surface treatments available on substrate materials which can affect adhesion. This chart is intended to provide only a rough estimate of the adhesion levels which can be expected on some common materials relative to a reference surface such as aluminum. Foam type can affect and/or limit maximum adhesive strength.

## Handling/Application Information

### Application Techniques

Clean: Most substrates are best prepared by cleaning with a 50:50 mixture of isopropyl alcohol (IPA\*) and water prior to applying 3M™ VHB™ Tapes.

Exceptions to the general procedure that may require additional surface preparation include:

- Heavy Oils: A degreaser or solvent-based cleaner may be required to remove heavy oil or grease from a surface and should be followed by cleaning with IPA/water.
- Abrasion: Abrading a surface, followed by cleaning with IPA/water, can remove heavy dirt or oxidation and can increase surface area to improve adhesion.
- Adhesion Promoters: Priming a surface can significantly improve initial and ultimate adhesion to many materials such as plastics and paints.
- Porous surfaces: Most porous and fibred materials such as wood, particleboard, concrete, etc. need to be sealed to provide a unified surface.
- Unique Materials: Special surface preparation may be needed for glass and glass-like materials, copper and copper containing metals, and plastics or rubber that contain components that migrate (e.g. plasticizers).

Refer to 3M Technical Bulletin “Surface Preparation for 3M™ VHB™ Tape Applications” for additional details and suggestions. (70-0704-8701-5)

\*Note: These cleaner solutions contain greater than 250 g/l of volatile organic compounds (VOC). Please consult your local Air Quality Regulations to be sure the cleaner is compliant. When using solvents, be sure to follow the manufacturer’s precautions and directions for use when handling such materials.

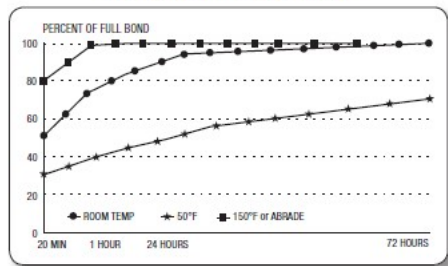
Pressure: Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact and helps improve bond strength. Typically, good surface contact can be attained by applying enough pressure to insure that the tape experiences approximately 15 psi (100 kPa) pressure. Either roller or platen pressure can be used. Note that rigid surfaces may require 2 or 3 times that much pressure to make the tape experience 15 psi.

Temperature: Ideal application temperature range is 70°F to 100°F (21°C to 38°C). Pressure sensitive adhesives use viscous flow to achieve substrate contact area. Minimum suggested application temperature for the 3M™ VHB™ Tape 5952 family is 50°F (10°C). Minimum application temperature does vary by 3M™ VHB™ tape family and ranges from 32°F to 60°F (0°C to 15°C)

Note: Initial tape application to surfaces at temperatures below these suggested minimums is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory. To obtain good performance with all 3M™ VHB™ Tapes, it is important to ensure that the surfaces are dry and free of condensed moisture.

Time: After application, the bond strength will increase as the adhesive flows onto the surface (also referred to as “wet out”). At room temperature approximately 50% of ultimate bond strength will be achieved after 20 minutes, 90% after 24 hours and 100% after 72 hours. This flow is faster at higher temperatures and slower at lower temperatures. Ultimate bond strength can be achieved more quickly (and in some cases bond strength can be increased) by exposure of the bond to elevated temperatures (e.g. 150°F [66°C] for 1 hour). This can provide better adhesive wetout onto the substrates. Abrasion of the surfaces or the use of primers/ adhesion promoters can also have the effect of increasing bond strength and achieving ultimate bond strength more quickly.

Bond Typical Build vs. Time





# 3M™ VHB™ Tape 5925WF

## Storage and Shelf Life

All 3M™ VHB™ Tapes have a shelf life of 24 months from date of manufacture when stored at 40°F to 100°F (4°C to 38°C) and 0-95% relative humidity. The optimum storage conditions are 72°F (22°C) and 50% 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.

The manufacturing date is available on all 3M™ VHB™ Tapes as the lot number, typically marked on the core or on a label on the outer roll lap. The lot number, typically a 4 digit code, is a Julian date (Y D D D). The first digit refers to the year of manufacture, the last 3 digits refer to the days after January 1. Example: A lot number of 7266 (or 17266) would translate to a date of manufacture of Sept. 23 (266th day of year) in 2017.

## Industry Specifications

UL 746C (File MH 17478)

## Trademarks

3M and VHB are trademarks of 3M Company.

## References

Property	Values
3m.com Product Page	<a href="https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-VHB-Tape-5925?N=5002385+3293242419&amp;rt=rud">https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-VHB-Tape-5925?N=5002385+3293242419&amp;rt=rud</a>
Safety Data Sheet (SDS)	<a href="https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=5925WF">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=5925WF</a>

## Family Group

	5906	5908	5909	5915	5915P	5915WF	5925	5925P	5925WF	5930	5907
Liner Color Attribute Modifier: Primary	Clear	Clear	Clear	Red (printed)	White (printed)	Red (printed)	Red (printed)	White (printed)	Red (printed)	Red (printed)	Clear
Color	Black	Black	Black	Black	Black	White	Black	Black	White	Black	Black
Tape Thickness (mm)	0.15	0.25	0.3	0.4	0.4	0.4	0.6	0.6	0.6	0.8	0.2
Adhesive Type	Modified Acrylic	Modified Acrylic	Modified Acrylic	Modified Acrylic	Modified Acrylic	Modified Acrylic	Modified Acrylic	Modified Acrylic	Modified Acrylic	Modified Acrylic	Modified Acrylic
Foam Type	Very Conforma ble Acrylic Foam	Very Conforma ble Acrylic Foam	Very Conforma ble Acrylic Foam	Very Conforma ble Acrylic Foam	Very Conforma ble Acrylic Foam	Very Conforma ble Acrylic Foam	Very Conforma ble Acrylic Foam	Very Conforma ble Acrylic Foam	Very Conforma ble Acrylic Foam	Very Conforma ble Acrylic Foam	Very Conforma ble Acrylic Foam
Liner	PET	PET	PET	PE Film	PCK Paper	PE Film	PE Film	PCK Paper	PE Film	PE Film	PET
Liner Thickness (mm)	0.08	0.08	0.08	0.13	0.1	0.13	0.13	0.1	0.13	0.13	0.08

## ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

## Information

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