



3M™ VHB™ Tape

ST515, ST520, ST525, ST530

Technical data

January, 2013

Product Description	3M™ VHB™ Tapes ST515, ST520, ST525 and ST530 are thin foam tapes with pressure sensitive adhesive on both sides and are used for bonding a wide range of materials, including many paints and lower surface energy plastics in addition to metals and other plastics. The foam is conformable to increase contact with the surfaces.
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Product Construction	Adhesive:	Modified Acrylic	
	Thickness:	ST515	0.006in(0.15mm)
		ST520	0.008in(0.20mm)
		ST525	0.010in(0.25mm)
		ST530	0.012in(0.30mm)
	Thickness Tolerance:	+/- 15%	
	Density:	45lb/ft ³ (720kg/m ³)	
Product Construction	Liner:	0.03in(0.08mm) clear polyester	
	Tape Color:	Black	

Typical Physical Properties and Performance Characteristics	Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.		
	Peel Adhesion:	ST515	10lb/inch(175N/100mm)
	(stainless steel)	ST520	10lb/inch(175N/100mm)
		ST525	12lb/inch(210N/100mm)
		ST530	12lb/inch(210N/100mm)
	Static shear:	72°F (22°C)	1000 g/0.5 sq in (holds 10,000 min.)
	(stainless steel)	150°F (66°C)	500 g/0.5 sq in (holds 10,000 min.)
	Solvent Resistance:	High	
	Temperature Resistance:		
	Short Term: (minutes, hours)	250°F (121°C)	
	Long Term: (days, weeks)	200°F (93°C)	

Available Sizes	Standard Length:	72 yards (65.8 meters)
	Maximum Length	
	1 inch (25.4 mm) to 8 inch (203 mm)	360 yards (329 meters)
	All other	180 yards (165 meters)
	Minimum Width:	0.5 inch (12.7 mm)
	Maximum Width:	46 inch (1170 mm)
	Slitting Tolerance:	+/-1/32 inch (0.8 mm)
	Core Size(ID):	3.0 inch (76.2 mm)

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Application Guidelines	For maximum bond strength the surfaces should be thoroughly cleaned with a 50:50 mixture of isopropyl alcohol and water. Consult manufacturers directions for use and precautions when using cleaning solvents. Ideal tape application is accomplished when temperature is between 70°F and 100°F (between 21°C and 38°C) and the bond is allowed to dwell 72 hours. Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended.
Shelf Life	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.
Technical Information	The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.
Product Use	Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.
Limited 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 limited 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. AN APPLICATION WARRANTY EXPRESSLY APPROVED AND ISSUED BY 3M IS AN EXCEPTION. THE CUSTOMER MUST APPLY FOR A SPECIFIC APPLICATION WARRANTY AND MEET ALL WARRANTY AND PROCESS REQUIREMENTS TO OBTAIN AN APPLICATION WARRANTY. CONTACT 3M FOR MORE INFORMATION ON APPLICATION WARRANTY TERMS AND CONDITIONS.
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.

ISO 9001

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



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