Double Coated Tissue Tape 6615

Technical Data **Oct, 2013**

Product Description

6615 is a double coated pressure sensitive adhesive tape. High adhesion acrylic pressure sensitive adhesive is coated on both sides of flexible tissue carrier. High adhesion acrylic pressure sensitive adhesive provides good bonding strength on many types of substrate including low surface energy plastics on which most acrylic adhesive cannot adhere well. Soft acrylic adhesive can easily wet rough surface and establish good bonding strength. Polycoated paper liner is chosen to provide good humidity resistance and easy convertibility.

Construction Information

Liner
Backside Adhesive
Tissue
Faceside Adhesive

Product	Faceside Adhesive Thickness (mm)	Carrier Type Carrier (g/sqm)	Backside Adhesive Thickness (mm)	Liner Type Liner Thickness (mm)	Liner Color	Tape Thickness Without Liner (mm)
6615	0.075	Tissue 14	0.075	PCK liner 0.13	White	0.15

Note: Backside adhesive is on the interior of the roll, exposed when liner is removed; Faceside adhesive is on the exterior of the roll, exposed when unwound.

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.

180˚ peel strength on different substrates (N/mm)

Test method: ASTM D3330; Backing material: 2mil polyester film; Test speed: 304.8 mm/min

	SS	PP	PC	ABS	Al	Glass
Dwell 30 min	1.00	0.80	0.90	0.90	0.80	0.90
Dwell 3 day	1.20	0.85	1.00	0.95	0.85	0.95

Static Shear Strength

Test method: ASTM D3654; Backing material: 2mil polyester film

Temperature	Size	Weight	Minutes
72º (23ºC) 50%RH	1” x 1”	1000 grams	10000
158ºF (70ºC) 50% RH	1” x 1”	500 grams	5000

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Environmental Performance	**Humidity Resistance –** High humidity has a minimal effect on adhesive performance. Bond strength (is generally higher/shows no significant reduction) after exposure for 7 days at 90°F (32°C) and 90% relative humidity. **UV Resistance –** When properly applied, nameplates and decorative trim parts are not adversely affected by outdoor exposure. **Temperature Cycling Resistance –** High bond strength (is maintained /increases) after cycling four times through: 4 hours at 158°F (70°C) 4 hours at -20°F (-29°C) 4 hours at 73°F (22°C) **Chemical Resistance –** When properly applied, nameplate and decorative trim parts will hold securely after exposure to numerous chemicals including oil, mild acids and alkalis. **Bond Build-up:** The bond strength of 3M™ double coated tissue tape 6615 increases as a function of time. **Lower Temperature Service Limit:** 50°F (10°C).
Application Ideas	Nameplate bonding Plastic film lamination/bonding Foam bonding
Application techniques	Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure helps develop better adhesive contact and improves bond strength. To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Some typical surface cleaning solvents are isopropyl alcohol or heptane. **Note**: Carefully read and follow the manufacturer's precautions and directions for use when working with solvents. Ideal tape application temperature range is 70°F to 100°F (21°C to 38°C). Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.
Master Width	
Storage	It is suggested that products are stored at room temperature conditions of 70°F (21°C) and 50% relative humidity.
Shelf Life	If stored properly, product retains its performance and properties for 24 months from date of shipment.

Product	Master Width
6615	1200 mm

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ISO 9001

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For more information contact your local 3M representative

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