



**Adhesive  
Solutions**

GROUP OF COMPANY

R/O- Plot No. 120, A Block First Floor, Qutub Vihar Phase-1, Near Sec-19, Dwarka, New Delhi-110071  
M- +91 9871417131, +91 8376920360, E-admin@adhesivesolutions.in,  
Web- www.adhesivesolutions.in

**3M**

# VHB™ GPH Series

## Product Data Sheet

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### Product Description

3M™ VHB™ GPH Series, a general purpose, high temperature, grey conformable double coated acrylic foam tape with a high initial tack and a soft foam. Available in three different thicknesses with a 3M branded red siliconised polyethylene film liner.

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### Key Features

- Double coated acrylic foam tape
- 100 % closed cell acrylic foam
- High temperature performance (short term 230 °C)
- Good balance of high temperature and peel & shear performance
- High initial tack
- Soft foam enables stress relaxation & an easy application
- Good sealing properties
- For indoor and outdoor applications

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### Applications & Benefits

- Its temperature performance enables bonding of materials in applications with high operating temperatures such as prior to processing in a powder coating line
- Capability to bond to a variety of substrates makes it a good fit for multi material bonding - those substrates have a high or medium surface energy including many metals (e.g. stainless steel) and plastics (e.g. Polyamide, PMMA, ABS)
- For applications in metal working, signage, appliances and specialty vehicle

**Physical Properties**

	<b>GPH-060GF</b>	<b>GPH-110GF</b>	<b>GPH-160GF</b>
<b>Adhesive Type</b>	Acrylic foam adhesive		
<b>Thickness</b> acc. to ASTM D-3652	0.60 mm	1.10 mm	1.60 mm
<b>Foam Density</b>	710 kg/m <sup>3</sup>		
<b>Release Liner</b>	3M branded red siliconised polyethylene film		
<b>Tape Colour</b>	Grey		

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Performance Characteristics	Type	GPH-060GF	GPH-110GF	GPH-160GF
	<b>90 ° Peel adhesion to Stainless Steel</b> acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	25 N/cm	37 N/cm	34 N/cm
	<b>90 ° Peel adhesion to PA6</b> acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	33 N/cm	48 N/cm	55 N/cm
	<b>90 ° Peel adhesion to ABS</b> acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	21 N/cm	33 N/cm	32 N/cm
	<b>90 ° Peel adhesion to PMMA</b> acc. to ASTM D3330, 90° peel angle @ RT, after 72h @ RT dwell	21 N/cm	34 N/cm	37 N/cm
	<b>Dynamic Shear</b> acc. to ASTM D1002 on stainless steel, after 72h @ RT dwell	547 N/6.54 cm <sup>2</sup>	476 N/6.54 cm <sup>2</sup>	375 N/6.54 cm <sup>2</sup>
	<b>Static Shear Strength</b> acc. to ASTM D3654, after 72h @ RT dwell (Weight held for 10.000 minutes to stainless steel, 3.32cm <sup>2</sup> (0.5in <sup>2</sup> ))		23 °C - 1000 g 150 °C - 500 g	
	<b>Normal Tensile (T-Block)</b> acc. to ASTM D897 to Aluminium @ RT, after 72h @ RT dwell, 6.45 cm <sup>2</sup> , test speed 50 mm/min	410 N/6.54 cm <sup>2</sup>	439 N/6.54 cm <sup>2</sup>	470 N/6.54 cm <sup>2</sup>
	<b>Temperature Performance</b>	Short term (minutes, hours): 230 °C Long term (days, weeks): 150 °C		

**Application Temperature**

Ideal application temperature range is 21 °C to 38 °C. Pressure sensitive adhesives use viscous flow to achieve substrate contact area.

**Low Temperature Application:**

3M™ VHB™ GPH Tape be applied at 10 °C and down to 5 °C when using 3M Adhesion Promoter AP111 or Primer 94

To obtain good performance with all 3M™ VHB™ Tapes, it is important to ensure that the surfaces are clean, dry and free of condensed moisture.

**Shelf Life**

24 months from date of production when stored at 16 °C – 25 °C and 40-65 % 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.

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**Important Notice**

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.

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**3M Afrique Francophone**

Société à responsabilité limitée Au capital de 19.756.400 Dirhams Siège Social: ZF Ksar Almajaz Bureau 6 Plateforme Lot n°2 Immeuble 4 zénith Tanger R.C : 74327, I.F. : 18745050

**3M Gulf Limited**

Ein El Mreisseh Saint Charles City Center, 4th Floor P.O.Box: 11-5025 Riad el Solh Beirut 1107 2180 Lebanon

**3M Minnesota Mining and Manufacturing Nigeria Limited**

No 2 Sheraton Opebi Link Road Ikeja Lagos Nigeria

**3M Arabia, LLC**

Building 24-25 3M Saudi Arabia Zone C, Business Gate Airport Road Riyadh Saudi Arabia

**3M Gulf (Representation Office)**

Suhaim Bin Hamad St. Al Mana Towers Tower B, 2nd Floor, Office No.4 Doha Qatar P.O.Box 14684

**3M Pakistan**

Islamic Chamber of Commerce Building ST-2/A, Block 9, KDA Scheme 5, Clifton, Karachi Pakistan

**3M Egypt**

Finance Center, New Cairo Plot 140, Banking Sector 5th settlement Cairo Egypt

**3M Kenya Ltd**

Victoria Towers, 3rd Floor Kilimanjaro Av, Upperhill Kenya

**3M South Africa and Sub-Saharan Africa**

146A Kelvin Drive Woodmead Sandton South Africa

**3M Gulf Limited**

Dubai Internet City Building No. 11, 3rd Floor U.A.E

**3M Maroc**

Société à responsabilité limitée Au capital de 18.000.000 de Dirhams Siège Social: 33, lot la colline II Sidi Maarouf - Casablanca R.C:78517, I.F.: 1084514 Morocco