August, 2016

3M™ Adhesive Transfer Tape 6035PC

Product Description

Finite Element Analysis (FEA) data is available for this product at: **3m.com/FEA**

3M™ Acrylic Adhesive Transfer Tape 6035PC is a 5 mil transfer tape formulated for low fog characteristics. The 300MP adhesive is suitable for bonding to most substrates including foams, fabrics and substrates with rough or textured surfaces.

3M™ Adhesive Transfer Tape 6035PC

General Information

- 3M 6035PC meets automotive OEM fogging specifications
- Provides excellent bond to a wide variety of surfaces.
- High initial tack for quick and easy assembly line application.
- High temperature resistance to withstand environmental conditions normally associated with automotive interiors.

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	
Adhesive Type	#300MP Acrylic Adhesive	
Adhesive Thickness	0.127 mm	5 mil
Liner	58# Polycoated Kraft Paper	
Liner Thickness	0.107 mm	4.2 mil

Typical Performance Characteristics

90° Peel Adhesion		Dwell/Cure Time	Dwell Time Units	Temp C	Temp F	Environmental Condition	Substrate	Backing	Notes
11.2 N/cm		15	min	22C	72F	52%RH	Stainless Steel	2 mil Aluminum Foil	
102 oz/in		15	min	22C	72F	52%RH	Stainless Steel	2 mil Aluminum Foil	12 in/min (300 mm/min)
9.7 N/cm		15	min	22C	72F	52%RH	Polycarbonate (PC)	2 mil Aluminum Foil	12 in/min (300 mm/min)
89 oz/in		15 min @ Room Temperature					Polycarbonate (PC)	1 mil Aluminum Foil	
14.3 N/cm	131 oz/in	72	hr	22C	72F	52%RH	Stainless Steel	2 mil Aluminum Foil	12 in/min (300 mm/min)
18.2 N/cm	166 oz/in	72	hr	70C	158F	52%RH	Stainless Steel	2 mil Aluminum Foil	12 in/min (300 mm/min)
10 N/cm	93 oz/in	72	hr	22C	72F	52%RH	ABS	2 mil Aluminum Foil	12 in/min (300 mm/min)
8 N/cm	73 oz/in	72	hr	22C	72F	52%RH	Polypropylene (PP)	2 mil Aluminum Foil	12 in/min (300 mm/min)

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Typical Performance Characteristics (continued)

90° Peel Adhesion		Dwell/Cure Time	Dwell Time Units	Temp C	Temp F	Environmental Condition	Substrate	Backing	Notes
10.5 N/cm	96 oz/in	72	hr	22C	72F	52%RH	Polycarbonate (PC)	2 mil Aluminum Foil	12 in/min (300 mm/min)
7.3 N/cm	67 oz/in	72	hr	70C	158F	52%RH	Polycarbonate (PC)	2 mil Aluminum Foil	12 in/min (300 mm/min)
6.9 N/cm	63 oz/in	72	hr	70C	158F	52%RH	Polypropylene (PP)	2 mil Aluminum Foil	12 in/min (300 mm/min)
8.5 N/cm	78 oz/in	72	hr	70C	158F	52%RH	ABS	2 mil Aluminum Foil	12 in/min (300 mm/min)

Property: 90° Peel Adhesion
Method: ASTM D3330

Environmental Resistance		Dwell/Cure Time	Dwell Time Units	Temp C	Temp F	Environmental Condition
7.1 N/cm	65 oz/in	1	hr	22C	72F	Gasoline
4.3 N/cm	39 oz/in	1	hr	22C	72F	MEK
9.7 N/cm	89 oz/in	4	hr	22C	72F	Weak Acid (pH 4)
8.9 N/cm	81 oz/in	4	hr	22C	72F	Weak Base (pH 10)
12.4 N/cm	114 oz/in	72	hr	49C	120F	Oil 10W30
14.7 N/cm	134 oz/in	100	hr	22C	72F	Water
15.3 N/cm	140 oz/in	7	day	32C	90F	90%RH
14.7 N/cm	134 oz/in	72	hr			Temperature Cycling: 4 Hours at 158°F (70°C). 4 Hours at -20°F (-29°C). 16 Hours at Room Tempterature. Repeat three times
12.4 N/cm	113 oz/in	72	hr	22C	72F	Salt Water (5%)
20.9 N/cm	191 oz/in	30	day			UV exposure

Property: Environmental Resistance
Attribute Modifier: 90o Peel
Substrate: Stainless Steel
Backing: 2 mil Aluminum Foil
notes: 12 inches/minute (300 mm/minute)

Typical Performance Characteristics (continued)

Property	Values		Test Condition
Relative High Temperature Operating Ranges	121 °C	250 °F	Short Term (minutes, hours)
UV Resistance	Adhesive is resistant to oxidation and ozone when exposed to air or ultraviolet light.		
Flammability Test	Pass FMVSS 302/SAE J369		
Automotive Fogging Test	99		SAE J1756 @ 100°C

Typical Environmental Performance

Property	Values
Humidity Resistance	No adverse effect on the bond after exposure to 100% relative humidity at 100°F (38°C)
Bond Build-Up	The bond strength of the adhesive increases as a function of time and temperature.

Storage and Shelf Life

Product retains its performance properties for 24 months from date of manufacture if properly stored at room temperature conditions of 72°F (22°C) and 50% relative humidity.

Trademarks

3M is a trademark of 3M Company.

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-Adhesive-Transfer-Tape-6035PC?N=5002385+3293240982&rt=rud
Safety Data Sheet (SDS)	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=6035PC

3M™ Adhesive Transfer Tape 6035PC

Family Group

	6035PC	6035PL	6038PC	6038PL
Relative High Temperature Operating Ranges (°C) Test Condition: Short Term (minutes, hours)	121	121	121	121
Adhesive Type	#300MP Acrylic Adhesive	#300MP Acrylic Adhesive	#300MP Acrylic Adhesive	#300MP Acrylic Adhesive
Adhesive Thickness (mm)	0.127	0.127	0.203	0.203
Liner	58# Polycoated Kraft Paper	83# Polycoated Kraft Paper	58# Polycoated Kraft Paper	83# Polycoated Kraft Paper
Liner Thickness (mm)	0.107	0.157	0.107	0.157

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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