



Acrylic Foam Tape 4218P

For Professional Market Applications

Data Sheet

September 2004

Supersedes technical data sheet dated May 1998

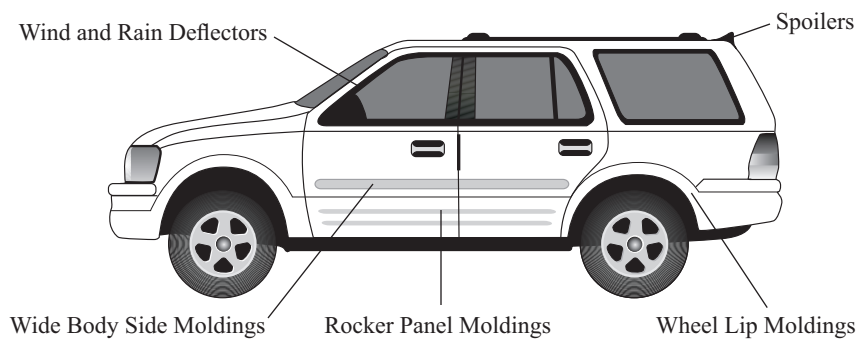
General Description

3M™ Acrylic Foam Tape 4218P is a medium-density, dark gray acrylic foam tape with high performance acrylic adhesives. 3M acrylic foam tape 4218P is characterized by high performance peel and shear adhesion to many automotive substrates, high internal strength, good conformability and excellent plasticizer resistance.

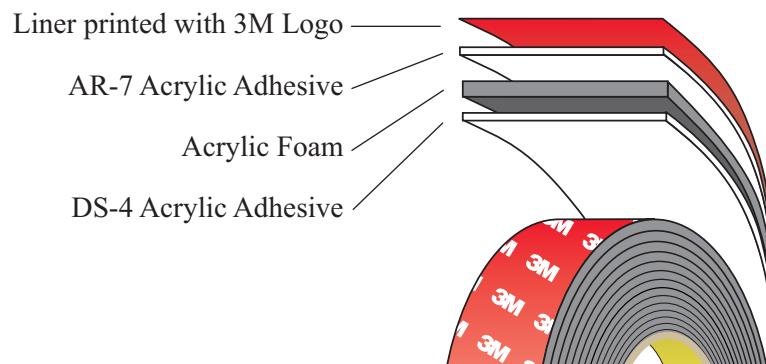
Typical applications include body side moldings, rocker panels moldings and claddings, wheel lip moldings, luggage rack slats, wind and rain deflectors, and lightweight rear spoilers.

3M acrylic foam tape 4218P utilizes the same proprietary acrylic foam core and adhesive technology that has been proven successful on numerous OEM automotive applications. **The acrylic foam core has unique viscoelastic properties that allow it to elongate and relax when put under load, thereby minimizing stress on the adhesive bond line.** These properties allow the tape to bond more effectively to a wide variety of automotive surfaces.

Typical Applications



Product Construction



Shelf Life

One year from date of receipt by customer when stored at 4°C - 38°C (40°F - 100°F) and 0-95% relative humidity. Optimum storage conditions are 22°C (72°F) and 50% relative humidity.

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Physical Properties

Values shown are typical values not to be used for specification purposes.

Foam:	Dark Gray Acrylic
Adhesive:	Liner Side: AR7 High Performance Acrylic Non-liner Side: DS4 High Performance Acrylic
Thickness:	1.14 mm (0.045 in.)
Range:	min. 1.04 mm (0.041 in.) max. 1.24 mm (0.049 in.)
Density:	688 kg/m ³ (43 lb/ft ³)
Range:	min. 608 kg/m ³ (38 lb/ft ³) max. 768 kg/m ³ (48 lb/ft ³)
Release Liner:	Red Polyethylene - 3M Logo Printed
Roll widths:	min. 4 mm (0.157 in.)
Roll Lengths:	For widths less than 8 mm (0.314 in.): Up to 65.8 m (72 yds.). For widths between 8 - 9.5 mm (0.314 - 0.375 in.): Up to 98.8 m (108 yds.). For widths greater than 9.5 mm (0.375 in.): Up to 131.6 m (144 yds.)

Performance Properties

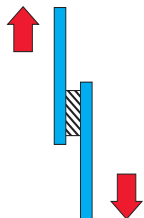


Performance tests are run using standard test procedures. The values presented are typical values not to be used for specification purposes.

1. Breakaway and Continuing Peel

72 hrs. at 22°C (72°F) Breakaway Peel 9.5 kg (21 lbs.)
Continuing Peel 5.0 kg (11 lbs.)

Breakaway and Continuing Peel tests are run with 12.7 mm (0.5 in.) wide tape on PVC test bars. Tests were run on base coat/clear coat paint at a separation rate of 305 mm/min. (12 in./min.).



2. Static Shear

Exceeds 100 hours at 70°C (158°F).
Static shear tests are run with 12.7 mm (0.5 in.) wide by 50.8 mm (2 in.) long tape on PVC test bars. 6.8 kg (15 lbs.) roll-down against stainless steel. Static weight is 250 gm (0.55 lbs.).

Many plastic substrates can be difficult to adhere to and may require the use of a 3M™ Adhesion Promoter to ensure a reliable bond. Please contact 3M Automotive Technical Service or Sales for assistance with application questions.

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