

Scotch-Mount™

4032 Double Coated Foam Tape

Product Data Sheet

Updated : February 1996
Supersedes : November 1993

Product Description A-20 is a firm acrylic pressure sensitive adhesive system. It features high ultimate bond strength, high temperature and solvent resistance and very high shear holding power. Bond strength increases substantially with time.

Physical Properties
Not for specification purposes

Adhesive Type	Acrylic	3M ref : A-20
Foam Core	Polyurethane Foam (Open Cell)	Foam Density 320 kg/m ³
Thickness (ASTM D-3652) Tape Liner Total	0.80 mm 0.08 mm 0.88 mm	
Thickness Tolerance	0.64 - 1.02 mm	
Release Liner	Green Plaid Paper	
Tape Colour	Natural	
Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

Performance Characteristics
Not for specification purposes

Static Shear Strength weight held for 100 hours to stainless steel with ½ sq in (3.23 sq cm) overlap	2000 g @ 20°C 1500 g @ 50°C 1000 g @ 65°C 1000 g @ 90°C	
Temperature Performance Max (hours/minutes) Max Continuous (days/weeks)	190°C 105°C	
Normal Tensile (T-Block) to Aluminium at room temp, 6.45 sq cm, jaw speed 50 mm/min.	41.5 N/cm ²	
Solvent Resistance	No apparent degradation when exposed to splash testing of most hydrocarbon solvents.	
UV Light Resistance	No apparent degradation when exposed to 7 days in U. V. Chamber.	

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Additional Product Information	Cold Flex at -30°C(-20°F) No cracking when flexed around a 6.4mm mandrel.	Thermal Conductivity (Watt/m Kelvin) 0.062	Dielectric Strength (Volts/25µm) 200-300
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Application Techniques	<p>1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact & thus improves bond strength.</p> <p>2. To obtain optimum adhesion, the bonding</p>	<p>surfaces must be clean dry and well unified. A typical surface cleaning solvent is isopropyl alcohol. Use proper safety precautions for handling solvents.</p> <p>3. Ideal tape application temperature range is 21°C to 38°C (70°F to 100°F).</p>	<p>Initial tape application to surfaces at temperatures below 10°C (50°F) is not recommended because the adhesive becomes too firm to adhere readily. However once properly applied low temperature holding is generally satisfactory.</p>
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Applications	<p>4032 urethane foam is soft, conformable and high in internal strength which makes it ideal for general purpose joining.</p>	<p>The excellent cold temperature properties of this product makes it suited for applications on snowmobiles, freezers etc.</p>
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