

# 3M

## Bonding Films

Products and Specifications



# 3M™ Bonding Films – performance profiles for the most demanding applications

## 3M Bonding Film Specifications

Product	Base Resin	Color	Standard Thickness* (mils)	Bond/Cure Time	Bondline Temp. (°F/°C)	Approximate Percent Elongation
406	EAA	Clear	3	2-5 sec.	320/160	750
615	Polyester	Tan	4	2-5 sec.	280/138	300
620	Polyester	Tan	6	2-5 sec.	280/138	100
668	Polyester	Tan	4	2-5 sec.	320/ 160	1000
AF-111	Epoxy	Off white	10	60 min.	250/121	10
AF-42	Epoxy	Translucent	3	60 min.	350/177	250
583	Nitrile Phenolic	Brown	2	5 min.	250/121	800
588	Nitrile Phenolic	Yellow	6	5 min.	250/121	250

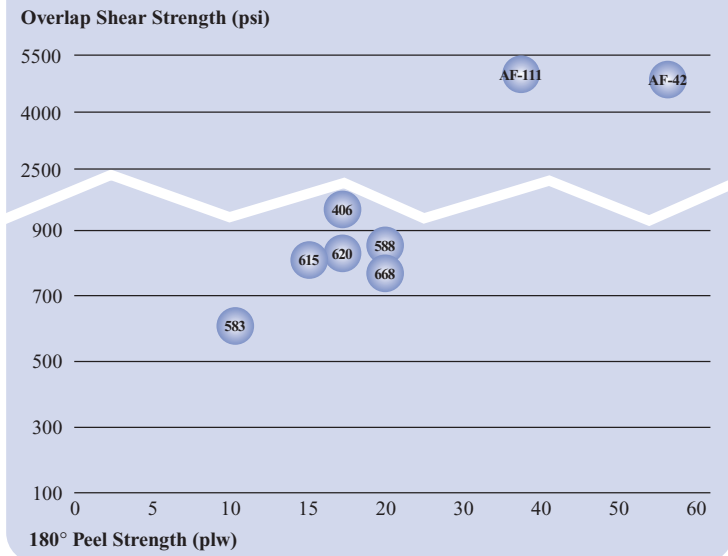
\*Custom thickness available up to 40 mils

**Note:** The technical information and data above should be considered representative or typical only, and should not be used for specification purposes.

Overlap Shear Strength (psi)	180° Peel Strength (piw)	2 Lb. Deadload Heat Resistance (°F/°C)	Release Liner	Key Characteristics
1090 on al	16.6 on ss	200/93	none	Good adhesion to metal. Clear.
810 on al	15 on al	215/102	paper	Good adhesion to a variety of substrates.
825 on al	16 on ss	215/102	paper	3 layers, 2 mils each. One is a dielectric.
860 on al	20 on ss	270/132	paper	High temperature resistance. Slight tack.
5300	38	NA	paper	Excellent heat resistance & structural bond strength. Cures at 250°
4600	55	NA	paper	Excellent heat resistance & structural bond strength. Cures at 350°
630 on al	10 on al	160/71	paper	Heat or solvent activated.
880 on al	20 on al	180/85	polypropylene	Heat activatable only.

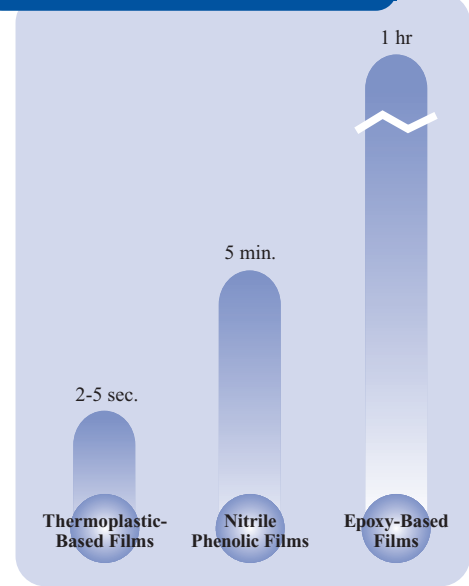
# 3M™ Bonding Films performance characteristics

## Relative Strength\*

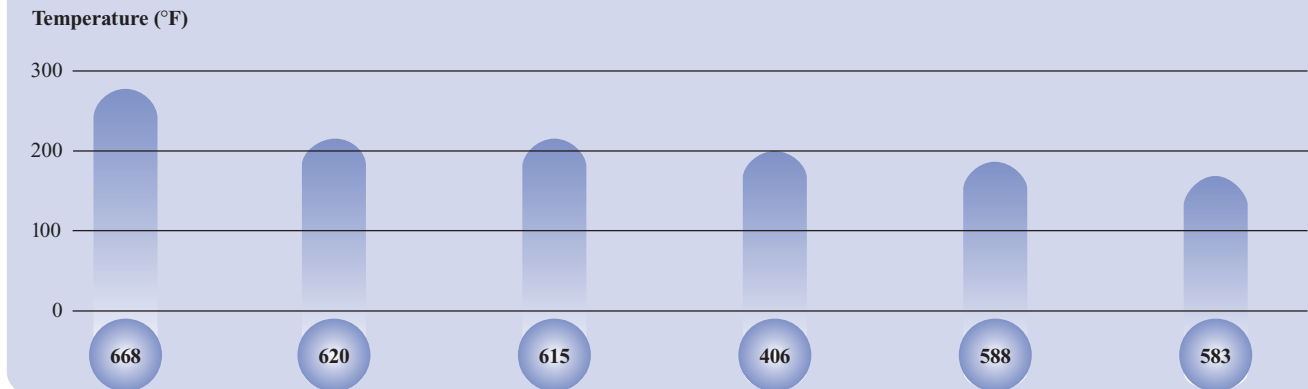


\*Check chart for substrates used in measuring strength.

## Bond/Cure Time



## 2 Lb. Deadload Heat Resistance



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