



# Die-Cuttable Tape Series DC 2000

Technical Data Sheet May 2007

**General Description** 3M™ Die-Cuttable Tape Series DC2000 is a black foam tape designed for the attachment of nameplates, badges and emblems to the exterior of vehicles. This tape is designed to process easily in all die-cutting operations, including high-speed rotary operations. 3M Series DC2000 tape exhibits high resistance to pluck and torque (twisting) forces normally associated with the attachment of nameplates and emblems.

3M Series DC2000 tape offers the following key features:

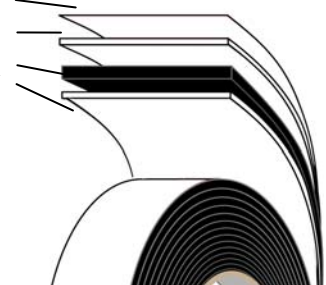
- Excellent adhesion to paint and chrome
- Excellent torque (twist) resistance. 3M Series DC2000 tape has a firm core that resists twisting forces that may result in the detachment of individual letters.
- Excellent resistance to impact in cold weather.

Some typical applications for 3M Series DC2000 tape include:

- Nameplates, badges and emblems
- Low demand applications whose primary attachment methods are mechanical. Examples include: attachment of lightweight pillar covers, miscellaneous sealing applications and spoiler applications that require tape to perform as a gasket.

## Product Construction

Protective Liner (See Below)  
DL-2 Acrylic Adhesive  
Black Acrylic Polymer Foam  
DL-1 Acrylic Adhesive



## Liner Options

SC2  
PET

## Configuration

White, 2-side silicone-coated, High Density Polyethylene  
Clear, 2-side silicone-coated, Polyester

## 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 (RH). The optimum storage conditions are 22° C (72° F) and 50% RH.

## Physical Properties

	DC2005	DC2008	DC2011	DC2015
<b>Thickness</b>	0.51 +/- 0.075mm (0.020 +/- 0.003in.)	0.76 +/- 0.102 mm (0.030 +/- 0.004 in.)	1.14 +/- 0.12 mm (0.045 +/- 0.005 in.)	1.52 +/- 0.012 mm (0.060 +/- 0.005 in.)
<b>Density</b>	609 +/- 100 kg/m <sup>3</sup> (38 +/- 4 lb/ft <sup>3</sup> )	569 +/- 100 kg/m <sup>3</sup> (35.5 +/- 4 lb/ft <sup>3</sup> )	545 +/- 100 kg/m <sup>3</sup> (34 +/- 4 lb/ft <sup>3</sup> )	529 +/- 100 kg/m <sup>3</sup> (33 +/- 4 lb/ft <sup>3</sup> )

## Processing Compatibility

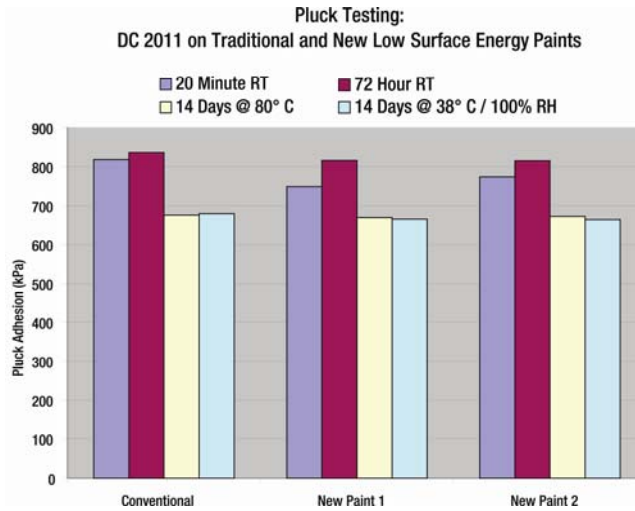
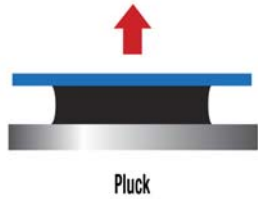
Rotary, flat bed, and laser die cutting operations.

# Technical Data Sheet

## 3M™ Die-Cuttable Tape Series DC2000

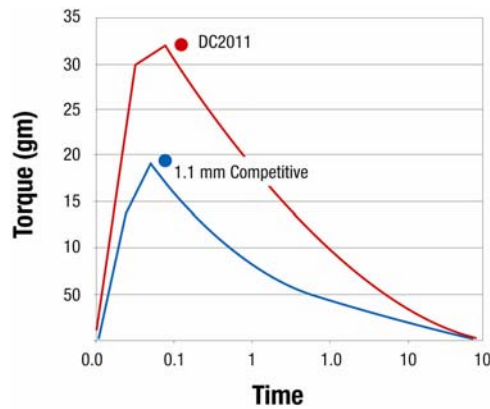
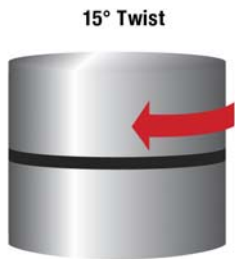
Page 2

### Pluck Testing (Typical Results)



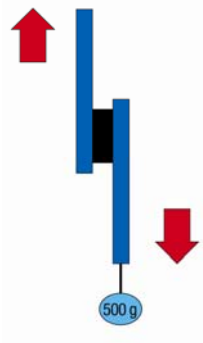
Maintains pluck adhesion on new low surface energy and scratch- and mar-resistant paint systems in addition to conventional paint systems.

### Torque Testing (Typical Results):



3M Series DC2000 tape demonstrates higher resistance to twisting forces (torque) compared to typical competitive tapes.

### Static Shear (Typical Results):



**Exceeds 100 hours at 70° C (158° F)**

Static shear tests are run with 25.4 mm (1.0 in.) wide by 25.4 mm (1 X 1 in.) long tape on chrome, 6.8 kg. (15 lb.) roll down against enamel paint. Weight is 500 grams (1.1 lb.).

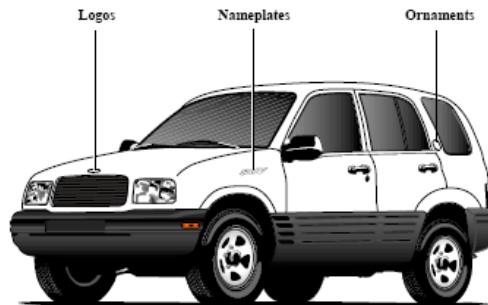
# Technical Data Sheet

## 3M™ Die-Cuttable Tape Series DC2000

Page 3

---

### Applications Diagrammic



---

**Contact Information** The information provided in this technical document is intended as a guide for this product. For more information, and help selecting a 3M product for an application, please contact a 3M technical service representative.

3M is a Trademark of 3M Company.

**Warranty and Limited Remedy:** This product will be free from defects in material and workmanship at the time of shipment. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If this product is defective, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to replace the product or refund the purchase price.

**Limitation of Liability:** Except as provided above, 3M and seller will not be liable for any loss or damage arising from or related to the use or inability to use this 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted.

**3M**

#### Automotive Division

3M Center, Building 223-1S-02  
St. Paul, MN 55144-1000  
[www.3M.com/autosolutions](http://www.3M.com/autosolutions)



ISO/TS 16949:2002  
File No. A2109

© 3M 2007  
75-3470-8835-5