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The performance of our acrylic foam tapes is dependent on preparation. To make sure you are satisfied with our products please take notice of the following procedures.

Cleaning the surface

In most cases it is preferable to wipe the surface with a 50:50 mixture of isopropyl alcohol (IPA) and water prior to application of the tape. Some application may require extra measures:

- Degreaser or solvent-based cleaner may be required to remove heavy oil or grease from a surface and should be followed by cleaning with IPA/water.
- Abrasion can remove heavy dirt or oxidation and increases surface area. Use IPA/water to remove dust from abrasion.
- Priming a surface can improve short term and long term adhesion to some materials such as plastics and paints.
- Porous and fibered materials such as wood, particleboard, concrete, etc. need to be sealed to provide a unified surface.
- Special surface preparation may be needed for glass and glass-like materials, copper and copper containing metals, and plastics or rubber that contain components that migrate (e.g. plasticizers).

Temperature

Ideal application temperature is between 21°C and 40°C (70°F to 100°F). Pressure sensitive adhesives use viscous flow to achieve substrate contact area. Minimum suggested application temperature is 15°C.

Application to surfaces at temperatures below these suggested minimums is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally acceptable. To obtain good performance it is important to ensure that the surfaces are dry and free of condensed moisture.

Pressure

Our acrylic foam tapes are pressure sensitive, meaning that bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact and helps improve bond strength. Typically, good surface contact can be attained by applying enough pressure to insure that the tape experiences approximately 15 psi (100 kPa) pressure. Either roller or platen pressure can be used.

Time

After application, the bond strength will increase as the adhesive flows onto the surface. At room temperature approximately 50% of ultimate bond strength will be achieved after 20 minutes, 90% after 24 hours and 100% after 72 hours.

Bond strength reaches its maximum faster at higher temperatures and slower at lower temperatures.

Ultimate bond strength can be achieved more quickly (and in some cases bond strength can be increased) by exposure of the bond to elevated temperatures (e.g. 150°F (66°C) for 1 hour). This can provide better adhesive wet out onto the substrates.

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