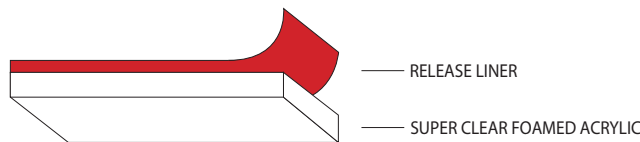


DESCRIPTION

Tapespec 1906 UHB is a Clear Solid Acrylic Double Sided tape which has excellent high bond strength. Used as a permanent adhesive system for both interior and exterior applications. Good absorptivity for impact and shock. Resistance to most solvents, temperature extremes and UV light.

TAPE STRUCTURE



FEATURES & BENEFITS

- Designed for applications which require excellent clarity or near invisible finish lines are required.
- A multi-purpose adhesive used predominantly to bond HSE (high surface energy materials) such as glass, metals, acrylic and polycarbonate plastic substrates.
- Used in many industrial application to replace or work in conjunction with rivets, screws, spot welds & liquid adhesives.

APPLICATION GUIDE

- Good life durability as a gap filler double sided tape system.
- Adhesion to HSE (High surface energy substrates) - High
- Adhesion to LSE (Low surface energy substrates) - Low

NOTE: Testing is always recommended on all surfaces for suitability. A primer system maybe required for bonding to LSE substrates. Rolls can slit to various width sizes to suit the application. Suitable for die cutting applications - contact tapespec for further details.

TECHNICAL INFORMATION

Carrier	Foam Acrylic - Solid Form									
Adhesive	Acrylic Adhesive									
Colour	Transparent - Excellent clarity									
Release Liner	Red PE Film Liner									
Thickness	1.0 mm (tolerance + / - 10%)									
Density	Firm - 1000 Kg/m ³									
UHB Curing Time Guide	20 mins - 50% 1 hour - 75% 1 day - 90% 3 days - 100%									
Adhesion to steel 180° Peel Adhesion Power Test - bond at room temperature & test after 2 hours.	Normal 1400 gf/10mm High Temp 1600 gf/10mm Initial 1100 gf/10mm Low Temp 900 gf/10mm Speed: 300+/- 10mm/min Tape Width: 10mm Backing: 25 micron polyester film									
Static Shear Measured at various temperatures & gram loadings on stainless steel. 3.22 cm ² overlap. Holding a load for 7 days	<table border="1"> <thead> <tr> <th>Temperature</th> <th>Load</th> <th>Result</th> </tr> </thead> <tbody> <tr> <td>23°C</td> <td>1000g</td> <td>OK</td> </tr> <tr> <td>93°C</td> <td>500g</td> <td>OK</td> </tr> </tbody> </table>	Temperature	Load	Result	23°C	1000g	OK	93°C	500g	OK
Temperature	Load	Result								
23°C	1000g	OK								
93°C	500g	OK								
Dynamic Shear Measurement of the bonding load at room temperature - after 2 hours. Speed: 200+/- 10mm/min Tape Width: 10mm x 10mm Backing: 75 micron polyester film	Normal 5.8 kgf/cm ² High Temp 6.2 kgf/cm ² Initial 5.3 kgf/cm ² Low Temp 5.1 kgf/cm ²									
Temperature Resistance Temperature measurement -bonding tape at room temperature & for 1 hour with a weight - 500g & in an oven. Increase of temperature 3°C every 5 min & record falling temperature. Substrate: Stainless Steel Tape Width: 20mm x 20mm Backing: 75 micron polyester tape	Test Rate = 120°C Range: - 40°C to + 120°C & 149°C (for short periods) Note: All installation instructions must be followed to ensure correct tape to surface bond.									
Storage Temperature	12°C to 25°C - not in direct sunlight.									
Shelf Life	12 Months - from date of manufacture.									
Roll Size	33 meter length (widths slit to order)									

SURFACE SUBSTRATE CONDITION & PREPARATION

The surfaces to be bonded must be dry & free from any contamination including dust, oils, & fats, oxidisation, release agents & any other known contamination.

The correct choice of surface cleaner depends on the surface properties. Essentially non-greasy cleaners are recommended including isopropanol alcohol (mixed 50/50 with clean water) & acetone. Cleaning cloths must be clean, grease & fat free with no loose fibres or cloth particles.

The bond strength is dependent upon the contact pressure of the adhesive to substrate. To assist this process all adhesive tapes require firm hand or roller pressure.

BONDING APPLICATION TEMPERATURE

We recommend that the product, substrate & environment should be between +15°C & 25°C.

Ensure that the adhesive product & substrates are allowed time to adjust to the environment temperature before bonding.

For product storage we recommend that products are stored in their original packaging under dry conditions, ideally at room temperature but not warmer than +30°C. High relative humidity & direct sunlight must be avoided at all costs.

For more detailed handling instructions please refer to our comprehensive application guide.

PRODUCT USE

The information in this guide is based upon our knowledge & practical experience. This data is intended only as a source of information given without guarantee & does not constitute a warranty. Due to the wide variety of possible uses & applications, customers should independently determine the suitability of these products for their specific purpose, prior to use. Trial samples are provided free of charge & without obligation. For detailed surface preparation & application information please refer to our detailed Surface Condition & Preparation Guide.

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STICK WITH QUALITY