



Specialty Tape Division

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Surface Preparation

It is essential, as with all pressure-sensitive tapes, that the surface to which the tape is applied be clean, dry, and free of grease or oil.

Temperatures

Min Application Temp	50° F	10° C
Max Continuous Operating Temp	200° F	93° C
Max Intermittent Operating Temp	250° F	121° C

Storage and Shelf Life

One year when stored at 70°F (21°C) 50% RH out of direct sunlight.

Limited Warranty

All statements, technical information and recommendations concerning products sold or samples provided by AVERY DENNISON are based upon tests believed to be reliable but do not constitute a guarantee or warranty. All products are sold and samples of products provided with the understanding that PURCHASER has independently determined the suitability of such products for its purposes. AVERY DENNISON warrants the products to be free from defects in material and workmanship. Should any failure to conform to this warranty appear within one year* after the initial date of shipment, AVERY DENNISON shall, upon notification thereof and substantiation that the products have been stored and applied in accordance with AVERY DENNISON's standards, correct such defects by suitable repair or replacement without charge at AVERY DENNISON's plant or at the location of the products (at AVERY DENNISON's election) provided, however, if AVERY DENNISON determines that the repair or replacement is not commercially practical, AVERY DENNISON shall issue credit in favor of PURCHASER in an amount not to exceed the purchase price of the products.

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PRODUCT DESCRIPTION

Applications

Specifically designed for bonding automotive mirrors to mirror housings where good adhesion, heat resistance, environmental resistance gap filling and shatter resistance are important.

Features

Very aggressive acrylic adhesive for strong, permanent bond
Double-coated construction
Foam carrier for excellent line-to-line fit

Benefits

Excellent bond to almost any surface
Good heat, humidity and solvent resistance
Good for filling and bonding rigid materials
Adhesive is industry proven for bonding automotive OEM mirrors

PRODUCT DATA

Product Construction

Test Methods: PSTC-33

		<u>US Mils</u>	<u>MM's</u>
Unwind Adhesive	Acrylic	1.8	0.05
Carrier	Black PE Foam	31.0	0.79
Liner Adhesive	Acrylic	1.8	0.05
Liner	60# Densified Kraft	3.6	0.09
	Total Construction	38.2	0.97

Adhesive Properties

Peel Adhesion

Test Method(s): PSTC-3, ASTM D-3330, STD-10

2 mil PET 180° 12" / min Initial

<u>Substrate</u>	<u>Test Side</u>	<u>Lbf / in</u>	<u>US Oz / in</u>	<u>N / Meter</u>
SS	Liner	6.7	107	1171
	Unwind	6.7	107	1171
ABS	Liner	7.1	114	1247
	Unwind	7.1	114	1247

Polycarbonate

Liner	7.1	114	1247
Unwind	7.1	114	1247

Painted Metal

Liner	6.7	107	1171
Unwind	6.7	107	1171

Loop Tack

Test Method(s): PSTC-5, STD-7

2 mil PET 20" / min Initial

<u>Substrate</u>	<u>Test Side</u>	<u>Lbf / in</u>	<u>US Oz / in</u>	<u>N / Meter</u>
SS	Liner	3.5	56	613
	Unwind	2.4	38	420

Peel Adhesion

Test Method(s): PSTC-3, ASTM D-3330, STD-10

Foil 90° 12" / min Initial

<u>Substrate</u>	<u>Test Side</u>	<u>Lbf / in</u>	<u>US Oz / in</u>	<u>N / Meter</u>
ABS	Liner	2.8	44	482
	Unwind	3.8	61	664

Foil 90° 12" / min 10 Days @ 38°C / 95% RH

<u>Substrate</u>	<u>Test Side</u>	<u>Lbf / in</u>	<u>US Oz / in</u>	<u>N / Meter</u>
ABS	Liner	12.1	193	2110
	Unwind	6.2	99	1080

Foil 90° 12" / min 10 days @ 150°F

<u>Substrate</u>	<u>Test Side</u>	<u>Lbf / in</u>	<u>US Oz / in</u>	<u>N / Meter</u>
ABS	Liner	12.0	191	2094
	Unwind	12.2	195	2136

Foil 90° 12" / min 10 days @ 175°F

<u>Substrate</u>	<u>Test Side</u>	<u>Lbf / in</u>	<u>US Oz / in</u>	<u>N / Meter</u>
ABS	Liner	12.1	194	2122
	Unwind	12.8	204	2234

Static Shear

Test Method(s): PSTC-7, ASTM D 3654, STD-9
2 mil PET 72°F / 22°C @ Initial 1" sq (6.5 cm2) 1000 g

<u>Substrate</u>	<u>Test Side</u>	<u>Min to Fail</u>
SS	Liner	> 10,000
	Unwind	> 10,000