Phoenix Tapes®
Simbolul Calității

Street Drumul Gilaului no. 5N
District 4, Bucharest
E-mail: office@phoenixtapes.ro
Phone: +4 021.335.1172
Mobile: +4 0729.012.783

TECHNICAL DATA SHEET F813

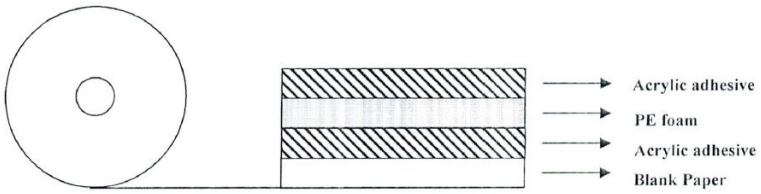
APPLICATION TECHNIQUES

1. Appropriate pressure helps develop better adhesive contact and improves bond strength.
2. To obtain optimum adhesion, the bonding surface must be clean, dry and well unified. Some typical cleaning solvents are isopropyl alcohol or heptane.
3. Ideal tape application temperature is 21°C - 38°C (70°F - 100°F). It is not suggested apply the tape at temperatures below 10°C (50°F). However, once properly applied, low temperature holding is generally satisfactory.

PRODUCT DESCRIPTION

Is a high foaming double-sided tape, constructed with white PE foam carrier and solvent acrylic adhesive. Whith good weather ability, buffering ability, tightness and superiority adhesion, it can be applied in various kinds of applications.

PRODUCT CONSTRUCTION



SUITABLE APPLICATIONS:

➢ Can be applied in various kinds of applications, such as automotive interior attachment, office chair handles and seat pads, name plate, promotional boards, mirrors, furniture decorations, electronic components, displays, shelf wobblers, cover plates, hooks, consoles, etc. Also it can make up for the irregular surface material.

Physical Characteristics (not for specification purpose)

Material Instruction		Standard	Physical Performance
ADHESIVE TYPE:	solvent acrylic	ADHESION TO STEEL: GB/T2792-2014(dwell time 20 min)	≥13N/24mm or It's damaged on the steel plate
CARRIER :	PE foam 67 kg/m³	STATIC SHEARING (HOLDING POWER) BG/T4851-2014(24X24mm)	1000g, 5.76 cm², 1440 min+
Adhesive / Liner thickness 3000/120 micron			≤ 50 mm
RELEASE LINER	Blank Paper	SOLVENT RESISTANCE	good
TAPE COLOR	White	TEMP. RESISTANCE	-30°C → 80°C
SHELF LIFE	24 months after shipment Storage Condition: 21°C (70°F) & 50% relative humidity		

ADHESION PROMOTER

Adhesion promoter 3M VHB TAPE UNIVERSAL PRIMER UV, 236 ml confers better adhesion, stronger initial bond and better adhesion below 10°C.

This is especially useful due to the fact that pressure sensitive acrylic adhesives require some time to achieve full adhesion, ranging from 24 to 72 hours.

AVAILABILITY

- **Widths:** 6 mm, 9 mm, 12 mm, 25 mm, 50 mm,100 mm (other widths available)
- **Lengths:** 25 M

NOTE:

All data contained in this document are average values, they should not be used for specification purpose. All statements, technical information and recommendations contained are base upon tests that we believe are reliable, but we are strongly recommend clients should do their own tests and decide whether the product is fit for a particular purpose or the method of application.

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Site: www.phoenixtapes.ro