

HANDLING 3M™ VHB™ ACRYLIC FOAM TAPES

Surface Preparation and Tape Application

1

Clean both surfaces to be bonded using 3M™ VHB™ Surface Cleaner with 3M™ VHB™ Applicator Pads. Wipe in a single direction to ensure contaminants are completely cleared and not smeared.



2

Apply tape on clean, dry surfaces. Avoid finger contact with the adhesive surface.



3

Apply pressure to tape via the 3M™ VHB™ Hand Roller



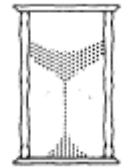
4

Remove liner, apply second substrate and exert pressure on bond area via the hand roller.



5

Allow for bond strength to build up – at room temperature approximately 50% bond strength is achieved after 20 minutes and full strength is achieved after approx 72 hours. This process will take longer in cold temperatures.



Remember

- Always store VHB Tape in a clean, warm and dry environment
- Avoid finger contact with the adhesive surface and apply pressure to tape and bond area
- Only use VHB Tape on applications where appropriate testing has taken place
- Suggested coverage – approx 60cm² of VHB Tape required per kilo of weight supported
- Assume all surfaces are contaminated and therefore cleaning is essential
- Loose or flaking surfaces, e.g. rust, should be removed with 3M™ VHB™ Abrasive Pads prior to surface cleaning as in (1) above
- Heavy oil or grease should be removed using 3M™ Industrial Cleaner prior to surface cleaning as in (1) above
- Compatible substrates with a low surface energy or porous qualities may need to be primed before tape application. Primer may also improve the durability of bonds to glass.
- When not in use, keep rolls in a box ensuring they are separated by the paper liner.