



Technical Data

Product Description

InstaTape Adhesive Transfer provides high bond strength to most surfaces, including many low surface energy plastics such as polypropylene and powder coated paints eg. Sandwich Panel.

Features

- Excellent adhesion too difficult to bond to surfaces such as HDPE, LDPE, and PP.
- Super quick stick.
- Higher adhesion from a thinner tape.
- Excellent solvent resistance.
- High temperature performance.

Construction	Adhesive Type/ Thickness	Liner Color, Type, Print	Liner Caliper
InstaTape	0.005" (0.13 mm)	Natural, 60# Glassine	0.0032" (0.08 mm)

Note: The calliper listed is based on a calculation from manufacturing controlled adhesive coat weights using a density of 1.071 g/cc.

Typical Physical Properties and Performance Characteristics

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Product Number	InstaTape 0.13 mm (5.0 mil)
Adhesion to Polypropylene ASTM D3330 – 180 degree 2 mil al foil	Oz/in (N/25 mm) Faceside / Backside
- 30 seconds RT	160 (45) / 150 (42)
- 15 minutes RT	165 (46) / 155 (43)
- 72 hours RT	165 (46) / 165 (46)



Adhesion to other surfacesASTM D3330 – 180 degree,
2 mil al foil, 72 hour RTOz/in
(N/25 mm)
Faceside / Backside

ABS	165 (46) / 165 (46)
Stainless Steel	160 (45) / 160 (45)
Polycarbonate	165 (46) / 165 (46)
LDPE	95 (26) / 90 (25)
HDPE	80 (22) / 80 (22)

Shear Strength - ASTM D3654
Modified – (.5 inch² sample size)

1000 grams at 72°F (22°C)	>10,000 minutes
500 grams at 158°F (70°F)	>10,000 minutes

Relative High Temperature
Operating Ranges:

Long Term (days, weeks)	200°F (93°C)
Short Term (minutes, hours)	350°F (177°C)
Relative Solvent Resistance:	Very Good

**Application
Techniques**

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application will assist the adhesive in developing intimate contact with the bonding surface. To accelerate the adhesion process, additional heat, up to 130°F (54°C), may be used.

To obtain optimum adhesion, the bonding surfaces must be clean, dry, and well unified. Some typical surface cleaning solvents are isopropyl alcohol or heptane.*

Ideal tape application temperature range is 70°F to 100°F (21°C to 38°C).

Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. Surface preheating under these circumstances is necessary.

However, once properly applied, low temperature holding is generally satisfactory.

*When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturers' precautions and directions for use.

These cleaning recommendations may not be compliant with the rules of certain Air Quality.



Environmental Performance

Humidity Resistance: High humidity has minimal effect on adhesive performance. No significant reduction in bond strength is observed after exposure for 7 days at 90°F (32°C) and 90% relative humidity.

UV Resistance: When properly applied, adhesion is not adversely affected by exposure.

Water Resistance: Immersion in water has no appreciable effect on the bond strength. After 100 hours at room temperature, the high bond strength is maintained.

Temperature Cycling Resistance: High bond strength is maintained after cycling four times through:
8 hours at 194°F (90°C)
16 hours at -40°F (-40°C)
8 hours at 100.4°F (38°C/100% RH)
16 hours at -40°F (-40°C)

Chemical Resistance: When properly applied, InstaTape will hold securely after exposure to numerous chemicals including oil, mild acids, and alkalis.

Storage Store in original cartons at 70°F (21°C) and 50% relative humidity.

Shelf Life If stored under proper conditions, product retains its performance and properties for two years from date of manufacture.

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