

TECHNICAL DATA

- Excellent weathering properties, including moisture and sub-zero temps
- Resistant to high temperatures for bonding prior to paint processing
- Continous bond distributes stress over entire surface
- Faster, easier assembly
- Dampens noise and vibration
- Compensates for differential thermal expansion or contraction

Product Description

This product is a double-sided, acrylic-based adhesive tape, which is especially designed for the bonding of high and medium energy substrates. This tape is capable of absorbing the differing thermal expansions of two different materials, and also maintains a high impact resistance even at temperatures below 0° Celsius. This has a very high initial tack and high plasticizer resistance. The advantage of excellent conformability is that thin or textured surfaces can be bonded full surface and tension free.

Applications

Suitable for various high and medium surface energy plastics, glass, steel, aluminum, ceramics*

STANDARD ROLL SIZE	SERIAL NUMBER	THICKNESS	LENGTH
All rolls available in widths from 3/16" to 35"	PHB5115G	0.015" (+/-15%)	108'
	PHB5125G	0.025" (+/-15%)	108'
	PHB5130G	0.030" (+/-15%)	108'
	PHB5145G	0.045" (+/-15%)	108'
	PHB5160G	0.060" (+/-15%)	54'

PHYSICAL PROPERTIES	PROPERTY	UNIT OF MEASURE	TYPICAL PERFORMANCE	TEST METHOD
	Density	kg/m ³ (lb/ft ³)	840 (52) - PHB5115G	---
			900 (56) - PHB5125G	
			900 (56) - PHB5130G	
			900 (56) - PHB5145G	
			900 (56) - PHB5160G	
	Tape Color	---	Gray	---

ADHESION PROPERTIES	TEST	UNIT OF MEASURE	TYPICAL VALUE	TEST METHOD
	90° Peel Adhesion	N/10mm (lb/in)	32 (18) - PHB5115G	ASTM-D3330
			34 (19) - PHB5125G	
			38 (21) - PHB5130G	
			41 (23) - PHB5145G	
			41 (23) - PHB5160G	
	Dynamic Shear Strength	kPa (lb/in ²)	700 (101) - PHB5115G	ASTM-D-1002
			670 (96) - PHB5125G	
			650 (93) - PHB5130G	
			590 (85) - PHB5145G	
			540 (78) - PHB5160G	



PHB5100G Series High Bond Tapes

ADHESION PROPERTIES	TEST	UNIT OF MEASURE	TYPICAL PERFORMANCE	TEST METHOD
	Normal Tensile	kPa (lb/in ²)	670 (97) - PHB5115G	ASTM-D-897
			690 (100) - PHB5125G	
			650 (93) - PHB5130G	
			590 (85) - PHB5145G	
			540 (78) - PHB5160G	
	Static Shear Strength	Grams (g) - Weight that 1/2 square inch will hold for 10,000 minutes (7 days)	22°C (72°F) - 1000	ASTM-3654
			66°C (150°F) - 500	
			93°C (200°F) - 500	

ADDITIONAL PERFORMANCE CHARACTERISTICS	TYPICAL PERFORMANCE
Shelf Life	1 year
Recommended Application Temperature	50°F to 100°F (10°C to 37.8°C)
Temperature Resistance	-40°F to 212°F
Solvent Resistance	Excellent
U.V. Resistance	Excellent

NOTE: Pres-On acrylic tapes are not intended for use with heavily plasticized materials or very low surface energy plastics, such as polyethylene and polypropylene.

Application Notes

Ensure bonding surfaces are well unified, clean, dry and free of dirt and oils. Apply firm and even pressure to improve adhesive-to-surface contact. Allow proper temperature and time to enhance bond strength as adhesive flows onto the surface.

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