

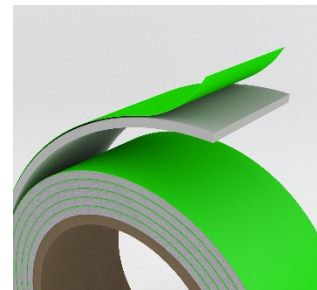
## Description

This tape consists of a high-performance acrylic adhesive with high shear strength, high temperature resistance and excellent UV stability.

## Liner

PE-film (130 micron, red with ORAFOL logo)  
Other types on request

Liner code: 76



## Tape construction

Single-layer

## Adhesive

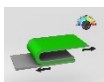

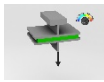
Acrylic adhesive "UHB04" (grey)

## Area of use

This tape is suitable for a wide range of commercial and industrial applications, including in automotive, solar, electronic, sign and display industries. Developed originally for the automotive industry, it offers excellent adhesion to plastics and painted steel.

The viscoelastic properties of UHB® (UHB® = Ultra-High-Bond) tapes allow them to compensate for material stresses caused by differing thermal expansion coefficients of the bonded materials. Additionally, the ability to flow into uneven surfaces allows an excellent "wet out" of the substrate and leads to extremely good bonding values.

## Technical Data\*

<b>Thickness</b> (adhesive)		2000 micron (±15%)
<b>Density</b>		800 kg/ m <sup>3</sup>
<b>Temperature resistance</b> (short-term)		-40° C to +200 °C
	(long-term)	-40° C to +150 °C
<b>Adhesion</b> after 24h (based on ASTM D3330, stainless steel)		51 N/25 mm (204 N/100 mm)
<b>Shear strength</b> after 24h (based on ASTM D1002, stainless steel)		0,64 N/mm <sup>2</sup> (64 N/cm <sup>2</sup> )
<b>Tensile adhesion (T-pull)</b> after 24h (based on ASTM D897, aluminium)		0,65 N/mm <sup>2</sup> (65 N/cm <sup>2</sup> )
<b>Shelf life</b> **		2 years
<b>Application temperature</b>		> +15 °C

\* average    \*\* in original packaging, at 20°C and 50% relative humidity

## Application instructions

At ORAFOL we are interested in the successful application of our pressure-sensitive adhesives by our customers. The following notes are intended to provide suitable support for customer-specific application tests. In all cases, in case of uncertainties, please contact your ORAFOL representative. ([www.ORAFOL.com](http://www.ORAFOL.com))

<b>Preparation / cleaning</b>	To achieve optimum adhesion, all surfaces must be free of loose materials, e.g. dust or other particles. It is important to remove any oil, grease or aqueous films. For example, the "ORAFOL Cleaner" (a mixture of isopropanol and water) can be used, with the use of lint-free disposable towels if possible. After cleaning, the surface energy can be measured with Dyne Test Pens. More persistent contaminants may require the use of stronger / alternative cleaners such as heptane or other solvents.
<b>Surface pretreatment</b>	Some materials do not provide an adequate surface for adhesion even after proper cleaning and require surface pretreatment. This can be done via physical methods (roughening or flaming the surface) or by chemical methods (e.g. pickling).
<b>Adhesion promoters (primers)</b>	By using the adhesion promoter ORABOND® UHBPrimerA (or B with UV indicator), better adhesion, stronger initial bond strength and better adhesion below 15 °C can be achieved, especially for high-shear ORABOND® acrylic adhesives. IMPORTANT: Only use adhesion promoter on the adhesive areas! For this purpose, the corresponding area can be demarcated with masking tape (for example ORATAPE® MT95). For glass bonding in outdoor applications, we recommend using the silane-based UHBPrimerG.
<b>Contact pressure</b>	Pressure-sensitive adhesives develop their specified adhesive forces from a defined contact pressure. The amount of pressure depends on the desired initial tack, the adhesive used, and its width and thickness. For a 10 mm wide ORABOND® tape, roll weights between 2 and 7 kg at 10 mm/s are used. The pressure can be checked with chalk pencils or a transparent mating part.
<b>Temperature</b>	An average room temperature of approx. 21 °C / 70 °F is recommended for bonding. Special low-temperature UHB® grades and the use of the ORABOND® UHBPrimerA / B can be helpful for colder conditions and substrates. Condensation on the surface should be avoided at all costs.
<b>Time</b>	Depending on the design and temperature, ORABOND® UHB® pressure sensitive adhesives require some time to achieve full adhesion, ranging from 24-72 hours at 21 °C / 70 °F. Preheating surfaces and using the UHBPrimerA / B reduce the time to full adhesion.
<b>Tape loading and design parameters</b>	The following design parameters apply to our ORABOND® UHB® Acrylic Foam Adhesive Tapes: For static loadings, peel and splitting forces must be avoided. For tensile or tensile shear loadings: 60 cm <sup>2</sup> adhesive tape per 1 kg static load. UHB® systems can compensate for 300% of their thickness with thermal expansion. For joint gap tolerances, these systems can compensate for 50% of the tape thickness per metre, provided these tolerances are not in the form of steps or edges.

## IMPORTANT NOTICE

All ORABOND® products are subject to careful quality control throughout the manufacturing process and are warranted to be of merchantable quality and free from manufacturing defects. Published information concerning ORABOND® products is based upon research, which the Company believes to be reliable although such information does not constitute a warranty. Because of the variety of uses of ORABOND® products and the continuing development of new applications, the purchaser should carefully consider the suitability and performance of the product for each intended use, and the purchaser shall assume all risks regarding such use. All specifications are subject to change without prior notice.

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