

TECHNICAL BULLETIN

DOUBLE-COATED FOAM TAPE SYSTEM

PRODUCT:	HYBRID FOAM TAPE - HF SERIES		
PRIMARY USE:	Use to seal window glass into wood, aluminum or plastic frames, mounting panels, signage and cushioning applications. The foam serves to seal against air, moisture, light, and dust penetration. Foam fills any irregularities in the frame and provides cushioning, absorbs vibration and shock, insulates in thermal and sound deadening applications.		
DESCRIPTION:	<p>A cross-linked, closed-cell polyethylene foam coated on both sides with a high performance acrylic adhesive system on the liner side (for glass bonding) and an aggressive rubber-based adhesive system on the exposed side (for bonding to lineals, plastics, vinyl, aluminum and wood).</p> <p>HFV-295: 1/16" thick white polyethylene foam. HFB-295 1/16" thick black polyethylene foam. HFW-395: 3/32" thick white polyethylene foam. HFW-495: 1/8" thick white polyethylene foam.</p>		
LINER:	5-mil high density blue plastic liner.		
TYPICAL PHYSICAL PROPERTIES:	Thickness	295 nominal 1/16"	63 mils
		395 nominal 3/32"	93 mils
		495 nominal 1/8"	125 mils
		Release Liner (nominal)	5 mils
	Peel Adhesion	PSTC #101 backed with 1 mil polyester	
		Exposed side	5.0 lbs/in.
	Shear Adhesion	NOTE: Peel tests are performed as per PSTC #101, which states one minute maximum dwell time. In general, for acrylic adhesives, longer residence time yields much higher peel values.	
		PSTC #107; Modified, 500 gm/sq. in. @ 73° F room temperature. No dwell to stainless steel.	
Exposed Side		7+ Days, no creep	
Liner Side	7+ Days, no creep		

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PRODUCT FEATURES:	<ul style="list-style-type: none">. Acrylic adhesive system on glass side exhibiting good UV resistance.. Aggressive rubber based adhesive on lineal side.. Excellent quick stick.. Moderate shear strength.. Exceeds all requirements of AAMA 810.1-92 for expanded cellular glazing tape.
SERVICE TEMPERATURE:	30° F to 160° F. NOTE: This information is provided as a means to help characterize the adhesive's temperature resistance. Note that this data is based on limited testing and under no load. The practical service temperature of this or any adhesive system is dependent on many variables including the substrates being bonded, environmental conditions, and the loading and method of application. The purchaser is responsible for determining the suitability of this or any product for their particular purpose and process. The recommended application temperature is 68°F to 100°F.
NOTES:	Surfaces to be bonded to should be dry, clean, and free from grease and oil. These products should not be laminated to any material that contains migrating plasticizers.
SHELF LIFE:	One year from date of shipment when stored under cool, dry conditions.

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Typical Physical Properties:	The following test results were run in accordance with AAMA 800-92, "Voluntary specifications and Test Methods Sealants", section 1.6 810.1-92 Expanded Cellular Glazing tape, Type 1+.	
Observed	Result	Requirements
2.9.3 Low Temperature Flexibility	No Cracking	No Cracking
2.14 Compression/Deflection Test A Test B	6.8 PSI 5.7 PSI	5 PSI minimum 4 PSI minimum
2.15 Compression Set	2.8%	6% maximum
2.16 Water Absorption	2.2%	7% maximum
2.17 Water Penetration	<1.0%	15% maximum loss
2.18 Tensile Adhesion (Average of 3 tests) a. 32° b. 77° c. 120°	233% w/56.9 PSI 245% w/44.2 PSI 34% w/33.9 PSI	30% elongation minimum and 25 PSI minimum.
2.19 Peel Adhesion (Average of 3 tests) a. 120° b. 32°	Aluminum 5.3 lb/in. width 7.0lb/in. width	Glass 4.5lb/in. width 7.4lb/in.width

Test results indicate that the sample of Expanded Cellular Glazing Tape, Series HF, complies with the performance requirements of AAMA 810.1-92 for Expanded Cellular Tape, Type 1.

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