



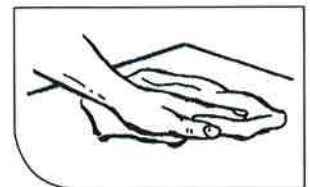
Handling 3M™ VHB™ Acrylic Foam Tapes

Surface Preparation and Tape Application

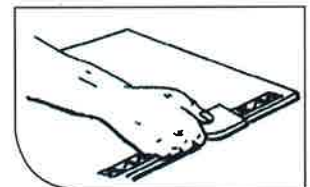
- 1** Clean both surfaces to be bonded using 3M™ VHB™ Surface Cleaner with 3M™ VHB™ Applicator Pads. Wipe in a single direction to ensure contaminants are completely cleared and not smeared.
- 2** Apply tape on clean, dry surfaces. Avoid finger contact with the adhesive surface.
- 3** Apply pressure 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.



Step A: Solvent wipe



Step B: Wipe dry



Step C: Apply tape to surface



Step D: Roll finished joint

Remember

- Always store 3M™ 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 3M VHB Tape on applications where appropriate testing has taken place.
- Suggested coverage – 60cm² of 3M 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.

For further information and advice visit www.3M.co.uk/adhesives or contact 0870 60 800 50

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