



Application and Preparation Instructions.

1. Surface Preparation

The two surfaces to be bonded need to be cleaned with a suitable solvent such as IPA/water or a similar cleaning agent to remove any surface contaminants. Acribond Prep may be required if there is oil or grease, a mould release agent, or similar present.

Both substrates should be lightly abraded with a scourer pad to remove any dirt, surface corrosion or oxidation and to increase surface bonding area, and then both surfaces need to be wiped down again with cleaning solvent to remove any loose particles, using a clean lint free cloth, and wiping across the surface in one direction.

Porous materials need to be sealed before the tape is applied.

2. Pressure

Acribond VST Tapes, like most adhesive tapes require pressure to achieve a bond between the tape and the substrate. Pressure of approximately 100kPa (15psi) is adequate in most applications and can be achieved by using either a roller or flat surface tool.

3. Time

Although one of the benefits of Acribond is its high initial adhesion, (approx 50% after 20min), with time, the adhesive continues to flow onto the surface and ultimate bond strength is not realised until after approximately 72hrs, depending upon ambient temperatures.

4. Temperature

If the temperature is comfortable for you, then it is ideal for applying the tape. Acribond is best applied between 21deg and 35deg C. This temperature range allows the adhesive to 'flow' and achieve optimal contact with the substrate. Acribond A3000 series has been developed to work well at cooler temperatures.

