

# TAPE APPLICATION GUIDE

## ADHESIVE SYSTEMS

<b>Surface Preparation:</b>	It is very important that the surface the tape is being adhered to is free from all contamination such as dirt, dust, grease and oil. A combination of 50/50 alcohol and water solution is usually adequate for removing most contamination. The wiper / cloth should be changed frequently (white cloth recommended). Heavy accumulation may require more aggressive cleaning techniques.
<b>Adhesion Promoters:</b>	Some very difficult surfaces may require the use of adhesion promoters to aid in proper bonding. This would be true for low surface energy materials and very porous surfaces. Promoters should be applied per manufacturer's instructions and must be allowed to fully dry prior to tape application. For porous concrete surfaces you may want to try a Dap Weldwood type product for aiding in bonding. Refer to manufacturer's instructions and MSDS sheet for proper handling.
<b>Temperature:</b>	Temperature is a critical factor in adhesive bonding often over-looked. All our tape products are intended for application in temperatures of not less than 50F (10C) and not more than listed on their data sheets. In general the closer to room temperature the better the bonding.
<b>Pressure:</b>	Tape products should be smoothed down with 15 psi of pressure or more. This will aid in adhesive "wet out" and result in better bonding.
<b>Time:</b>	After application the tape bond will continue to grow with the surface. The ambient temperature will affect this bonding time (the colder the slower), but as a general rule good bonding will not be fully achieved for 24 - 48 hours after the application. Full bond strength will be reached at 72 hours (70F).
<b>Test:</b>	As with most products we highly recommend that you test a small sample of product in it's intended use prior to complete installation. Some applications prove to be more difficult and require additional steps to achieve the desired results