



## Two- sided Molding Tape

Temperature range - -30°F- 200°F (-34°C - 93°C)

Shear strength – 60psi

Tensile strength – 150psi

Tape length – 20ft, Tape width , ½”, 7/8”

Thickness – ¼”, ½” = .030 7/8” = .040

### Introduction:

Crystal clear, two-sided, solid core acrylic tape. Bonds to all primed or painted substrates. Bonds to all plastic surfaces, may need the use of adhesion promoter on Polyethylene, TPO, Polypropylene. Typical application can be used in a variety of applications including auto trim attachment, signs, graphics, skin to frame assembly, furniture, appliances, and many other manufacturing and construction applications to replace mechanical fasteners and welds.

### Application Procedure:

#### **1. Substrate**

Acrylic adhesive is suitable for bonding a variety of substrates, including many plastics composites, sealed wood and metals. Low energy surface materials such as TPO, polyethylene, polypropylene, can be a problem bonding. It is recommended to use bumper adhesion promoter (8016) on all plastic.

#### **2. Preparation of Substrate**

The substrate to be bonded should be cleaned with an appropriate solvent, preferably alcohol, no more that 15 minutes prior to bonding of acrylic adhesive backed part. To ensure removal of all contaminants without leaving any residue, use a clean, lint-free wiping cloth or disposable wipe (never recycled rags). The substrate must be thoroughly dry through evaporation of the solvent. Application temperature of 50°F to 100°F (10°C to 38°C).

#### **3. Apply adhesion promoter to clean rag and wipe on back surface, allow to flash 5-10 minutes**

#### **4. Application of Adhesive Backed Part to the Substrate**

Remove the protective release liner from the acrylic tape immediately prior to applying the part to be bonded, being careful not to contaminate the acrylic adhesive. Apply within 15 minutes after the adhesion promoter has been applied. Apply the part to be bonded without entrapping air between the tape and the substrate with a recommended minimum application pressure of 15 pounds per inch of tape width to achieve adhesive to substrate contact and maximum bond strength

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