

TECHNICAL DATA SHEET - **INDASOL** UHB17110B-HT – PAGE 1 OF 2

PRODUCT DESCRIPTION: Specifically targeting bonding of bare metals prior to powder coating processes, **INDASOL UHB17110B-HT** is a heavy duty acrylic pressure sensitive adhesive capable of operating at the high temperatures of 200°C+



INDASOL UHB17110B-HT is the double-sided, heat resistant tape you can rely on for the most demanding, performance critical tasks.

On textured or uneven surfaces, powder coating, temperatures of up to 260°C*, exposed to full sunlight or chemicals, **INDASOL UHB17110B-HT** stays strong.

APPLICATIONS:

Manufacturing:

- Use on bare metals **prior** to powder coating and oven-stoving.

Signage:

- Virtually impervious to UV, temperature, ageing or chemicals.
- Ideal for durable, long-lasting signs in the harshest environments.

Features & benefits:

- Accepts powder coat
- Can replace spot welds or mechanical fasteners
- Ultra high sheer and high cohesion – ensuring the tape (and bond) remain strong under stress
- Resists vibration, impact or shock
- Good solvent resistance
- Interior or exterior application
- Suitable for plasticised PVC but not low surface energy plastics (**use INDASOL UHB15110W**)
- 1.1mm thickness Grey/Black tape with red filmic liner

How to apply:

The surfaces to be bonded should be dry, dust and grease free and thoroughly clean. Avoid touching the exposed adhesive surface of the tape as this impairs the performance.

The adhesive used on these tapes are pressure sensitive, so always ensure sufficient pressure is applied to the tape evenly over the whole surface to ensure the best bonding results.

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1. (Optional) Abrade (roughen) the surface to provide a 'key' to which the tape can bond, increasing the bond strength by as much as 35%
2. Clean with **INDASOL Surface Cleaner IPA**
3. Prime the surface using **INDASOL PR100 Primer**
4. Independent tests at Loughborough University show that using the correct primer can increase final bond strength by up to 50%. Remove the red silicon liner.
5. Align the parts to be bonded.
6. With firm pressure, apply **INDASOL UHB17110B-HT** to one of the surfaces to be bonded.
7. Using a **INDASOL roller** will allow the double sided acrylic tape to wet out and reach ultimate bond strength more quickly.
8. Apply firm pressure to the bond with the **INDASOL roller**.
9. Ultimate bond strength will be achieved in 72 hours.

PRODUCT SPECIFICATION:

PROPERTY	SPECIFICATION
Colour	Black
Thickness	1.10mm
Carrier	Acrylic layer
Liner	Red PE film
90° Peel Adhesion according to AFERA 5001	Steel 32N/25mm
Static Shear Strength (to stainless steel)	1500g @ 23°C : 500g @ 93°C
Dynamic Shear (@200mm/min)	62N/cm ² (after 2 hrs):67N/cm ² (after 24 hrs)
Operating Temperatures	Short term (mins/hrs) 230°C Long term (days+) 120°C
Application temperature	Minimum 15°C (ideally between 21°C & 40°C)
Temperature Resistance according to ISTM D3654 Method	From -40°C to +150°C (long term) 260°C+ (short term) Area of 6.25 ² with 1kg load @ 150°C for 10,000 minutes
Solvent Resistance	Good
UV Resistance	Excellent
Standard roll dimensions	12, 19 & 25mm widths x 33m rolls

This product should be stored in ambient temperatures of around 20°C, avoiding wide temperature fluctuations and direct sunlight.

The storage environment should have a relative humidity of approx. 50%. In ideal storage conditions, the shelf life for this material should be approx. 12 months from the delivery date. Within this period, no major deterioration or alteration of the products performance characteristic will occur.

The values presented in this document have been determined by standard test methods and are average values that should not be used for specification purposes without conducting tests on materials to be bonded.