



tapes  
gloves  
work protection

## technical data sheet

d/s 1.0mm th permanent high bond tape



### technical data

carrier solid foam acrylic adhesive	minimum application temperature 15°C
liner red polyethylene	thickness (adhesive and carrier) 1.1mm
adhesive acrylic acrylic	temperature resistance -40°C to +120°C
adhesion to steel 69.5N/25m	shelf life 2 years (at 20°C and 50% relative humidity)
tensile strength 489.3N/25mm	
resistance to solvents & chemicals resistant to most oils, grease, fuels, weak acids,	

**product code:** S3410

### description

S3405 is a 1.000mm thick phb (permanent high bond) crystal clear acrylic adhesive, double coated for extra initial tack. the high performance adhesive bonds to most higher surface energy substrates including metal, glass and high surface energy plastics. excellent weather and uv resistance.

### Areas of use

high clarity phb tapes are ideally suited to sign and glazing applications for permanent bonding and sealing to replace rivets, spot welds, liquid adhesives or other permanent fasteners. virtually invisible bonding to plastics, glass, painted steel, aluminium etc. used for double glazing, back lit signs, refrigeration display units and electrical cabinet windows.



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### preparation of surface

all contact surfaces should be free from dirt, grease, wax, moisture and contaminants such as release agents used on plastics, residual detergents, oil from skin and loose particles from unsealed surfaces. a typical cleaning solvent is 50/50 isopropyl alcohol/ water mixture. remove all residues with a clean, lint free wiping cloth (ensure wiping in one direction to avoid cross contamination). all surfaces must be dry before applying the tape.

### primers:

primers while not normally required can assist in the initial adhesion and improve long term bonding on certain substrates. pomona has a range of primers available for most surfaces. primers may be required for: low surface energy plastics (pp,pe), flexible pvc, powder coated / painted substrates and rubber materials (epdm and neoprene). the primer acts as a new layer for the phb tape to adhere while impeding the migration of additives in many materials.

### rough/ porous / fibred surfaces:

surfaces such as concrete, wood and particleboard require sealing with paint or varnish coatings before using the phb tape.

### conditions of use

for best results apply self adhesive tapes between 15°C and 25°C in a dry environment. application surfaces must be dry and free from dust and particles. do not apply on surfaces treated or contaminated by anti-adhesives. do not use paint containing additives which could reduce the adhesive properties. avoid contact with surfaces containing plasticizers or other chemical agents not compatible with the tape. in cases of rough or irregular surfaces, it is better to use a tape with a higher quantity of adhesive. care must be taken with reference to removability without residue and working conditions of the self adhesive tape.

### tape storage

suggested storage temperature shall range between 15°C and 25°C with maximum relative humidity of 65%. material shall be stored away from heat sources and possibly kept in the original package, avoiding light exposure as well. when temperatures are lower than suggested, it is always required to recondition the adhesive tape to normal temperatures before use.

### tape shelf life

self-adhesive tapes technical features are generally not permanent but remain at their best for a minimum of 12 months, if stored according to suggested conditions and avoiding extreme environmental conditions such as quick and sudden temperature changes, extremely high or low temperatures, high levels of humidity, etc.

the information provided is based on our experience and tape industry knowledge. it is given in goodwill but is not intended as a guarantee or warranty. all end users should ensure themselves that the product is suitable for their own particular application before using.

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