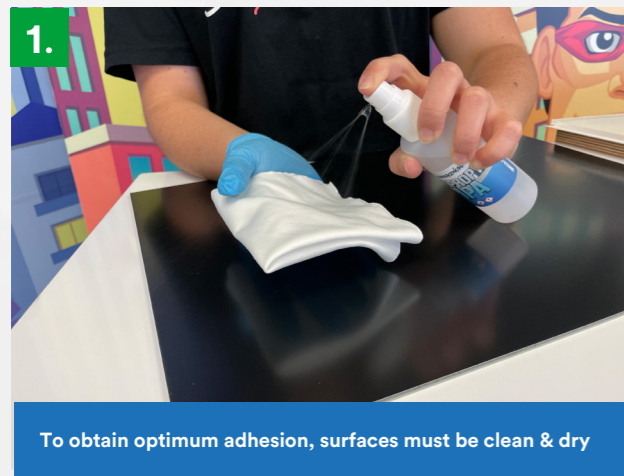


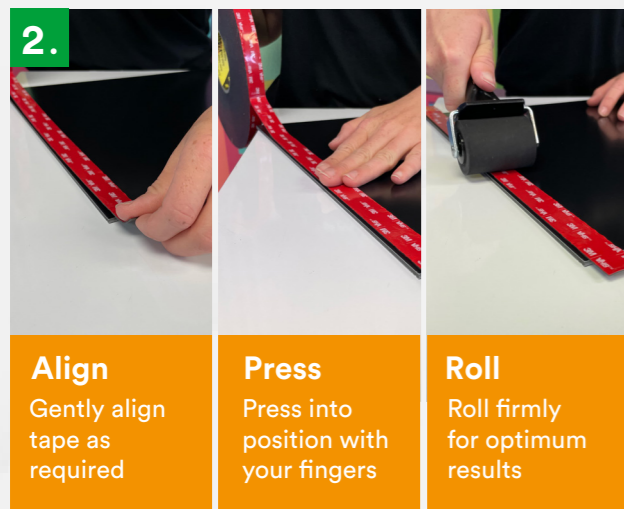
# How to apply EPIC & 3M™ Self Adhesive Tapes



To obtain optimum adhesion, surfaces must be clean & dry

## Surface cleaning

- Use clean, non-perfumed cleaning cloths without plasticizers, wiping in one direction
- Use cleaning agents that are suitable for the type of soiling and the surface such as Surfacework Isopropyl IPA (no regreasing household cleaners)
- Put on suitable gloves (follow the instructions on the material safety data sheet for the cleaner that you are using)
- Repeat cleaning procedure until the surface is clean and free from grease, changing the cloth if necessary



### Align

Gently align tape as required

### Press

Press into position with your fingers

### Roll

Roll firmly for optimum results

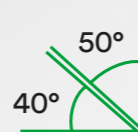
## Applying Tapes

- Apply the tape onto the surface to be bonded. Pull the tape tight, but do not overstretch. Try to avoid air bubbles
- Do not apply the section at the start of the VHB adhesive tape which has been touched (let this piece protrude and cut it off)
- Optimum application temperature is between 15°C and 25°C
- Bond strength is dependent upon the amount of adhesive-to-surface contact developed
- Firm application pressure develops better adhesive contact and helps improve bond strength



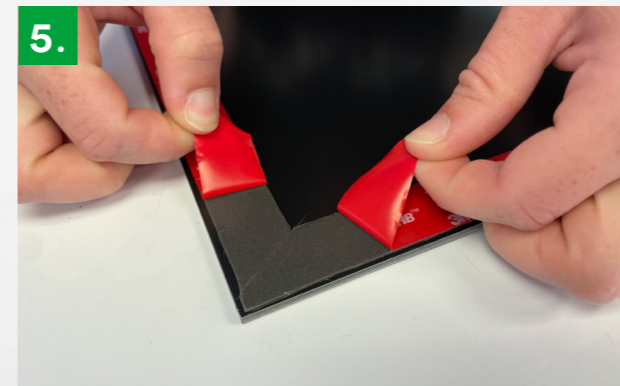
## Cutting mitred edges

- Where edges overlap, they need to be mitred
- Always cut vertically through both tapes
- Use an angle of 50°/40° (not 45°/45°) in order to achieve a proper seal



## Cut protruding tape edges and firmly press/roll over

- After application, the bond strength will increase as the adhesive flows onto the surface
- At room temperature, approximately 50% of the ultimate strength will be achieved after 20 minutes, 90% after 24 hours and 100% after 72 hours
- In some cases, bond strength can be increased and ultimate bond strength can be achieved more quickly by exposure to elevated temperatures (eg. 66°C for 1 hour)



## Liner removal and application of the mating part

- Remove the liner in one piece - this is especially important when using transparent adhesive tapes as otherwise it will cause 'stop marks'
- Do not touch the adhesive surface
- Apply the second mating part quickly after liner removal in order to prevent the open adhesive surface from becoming contaminated



## Applying the substrate to the tape

- Apply steady pressure and avoid bubbles
- **Important note:** Ensure you position the part correctly: once applied, it cannot be removed due to the high adhesive force
- Final strength is achieved after 72 hours at 20 °C. The curing process can be accelerated by heat (e.g. final strength after one hour at 65 °C)

Let us suggest the best tape for you...

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TO ANYTHING**

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