

AT Series

AT234 Very High Bond Acrylic Tape

AT SERIES
Very High Bond Acrylic Tape

CRL
PROFESSIONAL QUALITY
JUNE 2010

PRODUCT DATA SHEET

AT234 is a pressure sensitive, gray, foamed core, acrylic tape system designed to provide a superior bond between a wide variety of substrates. The tape possesses a uniform high-tack acrylic adhesive on both surfaces and will bond to most clean, dry, oil-free substrates. The tape is formulated to withstand a wide range of weathering and temperature conditions without losing adhesion.

AT234 can be used in a variety of applications including window muntin bar attachment, automotive trim attachment, signs, graphics, furniture, appliances, and many other manufacturing and construction applications to replace mechanical fasteners and welds. AT234 offers numerous advantages including increased compressibility, a waterproof bond, ease of application, the ability to withstand thermal movement, and sound deadening properties.

ADVANTAGES

- Gray appearance
- Compressibility with foamed core
- Pressure sensitive bonding
- Stain resistant after aged contact
- Moisture resistant
- Excellent weathering properties
- Reduces and dampens vibration and shock
- Adhesion at sub-zero temperatures
- Hardening or brittle resistant with age
- Flexible, moldable, compressible - conforms to intricate shapes

TECHNICAL DATA

Tape Color		Gray
Tape Thickness		0.045 in. 1.143 mm
Tape Width		0.25 - 18 in. 6.35 - 457.2 mm
Tensile Strength	ASTM D412 Die C	135 psi 0.0949 kg/mm ²
Elongation	ASTM D412 Die C	900%
Peel Adhesion	ASTM D3330	10 pli 1.751 NLMM
Cleavage Peel Strength	ASTM D1062	20 psi 0.0141 kg/mm ²
Dynamic Shear Strength	ASTM D3163	60 psi 0.0422 kg/mm
Shelf Life		2 years minimum
Installation Temperature		50°F - 100°F 10°C - 38°C
Constant Temperature Limit		-30°F - 200°F -34°C - 93°C

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ACRYLIC TAPE AND ADHESION PROMOTER APPLICATION GUIDE

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1. Substrate Evaluation

Acrylic adhesive is suitable for bonding a variety of substrates, including many plastics, composites, sealed wood and metals. Low energy surface materials such as polyethylene, polypropylene, silicone can be a problem bonding. Thorough evaluation is recommended when bonding to any questionable surface. An adhesion promoter (primer) for use with pressure sensitive acrylic adhesives may be necessary to facilitate proper bonding and is available from C.R. Laurence Co..

2. Preparation of Substrate

The substrate to be bonded should be cleaned with an appropriate solvent, preferably IPA (Isopropanol) 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). Other solvents such as hexane, heptane or methanol may be suitable for cleaning various substrates after thorough evaluation. The substrate must be thoroughly dry through evaporation of the solvent with radiant heat, hot air dryers or with time before bonding acrylic adhesive backed parts. Insure optimum substrate temperature, never below 60°F (15°C) at application time. Assure application temperature of 50°F to 100°F (10°C to 38°C).

3. Adhesion Promoter Application - If Necessary

Apply the Adhesion Promoter to the substrate(s) either with a lint-free applicator or foam brush. Apply the Adhesion Promoter in a "Wet" laydown thickness range of 1-8 mils. Allow the Adhesion Promoter to dry approximately (five) minutes. Don't touch the Adhesion Promoter.

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 application pressure of 15 pounds per inch of tape width to achieve to substrate contact and maximum bond strength.

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