

## HPA 1904 PET

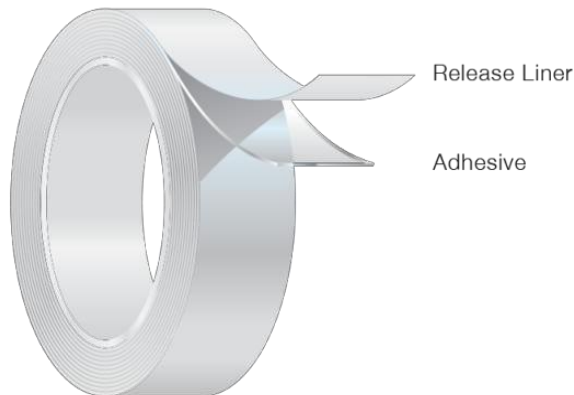
Specially designed for use on nameplates, membrane touch switch assemblies and graphic overlays. Applications requiring good "holding power" under stress and load and environmental resistance.

### FEATURES:

- Unsupported, specially formulated acrylic adhesive
- Adhesive protected by a polyester liner
- Provides good adhesion to high surface energy plastics
- Ease of die-cutting and liner removal
- UL 969 Recognition under File No. MH13584 (PGGU2 Category)
- UL 746C Recognition under File No. E328479 (QOQW2 Category)

### BENEFITS:

- Excellent balance of properties to perform in demanding applications
- Excellent high temperature peel adhesion
- Chemical, solvent, heat, humidity and UV resistance
- Thick adhesive mass for improved bonding and gap filling
- Polyester liner provides easy processing



### CONSTRUCTION:

- Liner:**  
Polyester
- Adhesive:**  
Acrylic

Adhesive Properties:		Typical Values	
Thickness	Test Method(s): PSTC-133	US Mils	MM's
Liner:		2.0	0.05
Adhesive:		4.0	0.10
Total Caliper:		6.0	0.15

PEEL ADHESION		Test Method(s): PSTC-101, ASTM D-3330, STD-10		
2 mil PET 180° 12" min				
Substrate		Lbf / In	US Oz / In	N / Meter
SS	24 hr dwell	4.4	70	770
Aluminum	24 hr dwell	3.8	61	665
Glass	24 hr dwell	4.6	74	805
Paint	24 hr dwell	3.8	61	665
ABS	24 hr dwell	4.8	77	840

LOOP TACK		Test Method(s): PSTC-16, STD-7		
2 mil PET 180° 20" / min				
Substrate		Lbf / In	US Oz / In	N / Meter
SS	Initial	7.7	123	1348

STATIC SHEAR		Test Method(s): PSTC-107, ASTM D 3654, STD-9		
2 mil PET 1" sq (6.5 cm2) 1000 g				
Substrate		Min to Fail		
SS	Initial	> 10,000		

STATIC SHEAR		Test Method(s): PSTC-107, ASTM D 3654, STD-9		
Aluminum Foil 1" sq (6.5 cm2) 1000 g				
Substrate		Min to Fail		
SS	@ 204°C / 400°F	> 5,000		

SAFT		Test Method(s): ASTM D 3654, STD-243		
Aluminum Foil 1" sq (6.5 cm2) 1000 g				
Substrate		Min to Fail	Fail Temp °F	Fail Temp °C
SS		475	403	206

TEMPERATURES	° F	° C
Min Application Temp	50 ° F	10 ° C
Max Continuous Operating Temp	400 ° F	204 ° C
Max Intermittent Operating Temp	450 ° F	232 ° C

THE LISTED VALUES ARE TYPICAL AND NOT INTENDED TO SERVE AS PRODUCT SPECIFICATIONS

#### APPLICATION TECHNIQUES

- It is essential, as with all pressure-sensitive tapes, that the surface to which the tape is applied be clean, dry, and free of grease or oil
- Bond strength is dependent upon the amount of adhesive-to-surface contact developed
- Note that different pressure, time and temperature on different (film / rigid) surface achieves different performance

#### STORAGE / SHELF LIFE

- One year when stored at 64-72°F (18-22°C) / 30-70% relative humidity, out of direct sunlight and in original packaging.