

Metamark double sided tapes are engineered to ensure the highest performance across a wide range of applications. The product is manufactured in the UK. These double sided tapes provide an alternative to mechanical fixings, offering quick, clean and easy installation.

### Surface Preparation

- Surfaces must be clean, dry, and free of contamination.
- Do not touch or contaminate the adhesive.
- Use a lint free cloth and IPA in up to 50% dilution
- Other cleaning agents must be checked thoroughly before being used and the safe use of solvents must always be taken into consideration.

### Application Method

- Apply pressure with a roller.
- The initial application pressure is critical to the ultimate performance of the adhesive tape. The target application pressure is 10-15N/cm<sup>2</sup>.
- Adhesive cure time is 24 to 72 hours, depending upon the substrates, application pressure and the application environment.
- Avoid leverage of the bonded components during assembly and until the adhesive has cured.

### Primers and Adhesive Activators

- An adhesive primer or activator is recommended for use on hard-to-adhere to surfaces and particularly important for use with UHB tapes requiring a structural bond.
  - Aluminium
  - Powder coated substrates
  - Polished and unpolished stainless steel
  - Painted, zinc plated and chrome plated steel
  - Plastics: polyamide, polycarbonate, ABS etc
- Always follow manufacturers guidelines for use of primers and activators, and dry times.
- Porous surfaces should be primed.

### Application substrates

- Good adhesion substrates include smooth, high energy surfaces; many metals, ABS polycarbonate, PMMA, hard PVC, and glass.
- Foam core tapes perform better for rough surfaces.
- Guidance should be sought for low energy or highly plasticised plastics, polyethylene, polypropylene, rubbers, powder coats, silicones, polyurethane, Teflon, varnishes.

### Secondary Mechanical Fixture

- Due to factors out of our control, we would always recommend adding mechanical fixtures on certain projects, including Powder Coated or Painted Aluminium and Di-bond.

### Application Temperature

- Recommended application temperature is +15°C to +30°C.
- Low temperature may compromise the ultimate bond strength.

### Storage

- Storage at 10-20°C and 50% R.H and out of direct sunlight.
- Extremes and fluctuations in storage temperature and humidity should be avoided.

### Limitation of Liability

Please refer to our Terms and Conditions of Sale and Warranty.

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For further technical support email [technical@metamark.co.uk](mailto:technical@metamark.co.uk) or call +44 (0)1483 571111

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