

# PRODUCT INFORMATION

## CACTUS NO. HA248 Double-coated adhesive tape



### Features/characteristics

1. Adhesive : Open Side: heat-activated adhesive (solvent based resin)  
Close Side: high performance acrylic adhesive (solvent based resin)
2. Carrier : White tissue, basic weight - 13 g/m<sup>2</sup>.
3. Liner : #60 (90 g/m<sup>2</sup>) Supercalendered Kraft paper.
4. Open side glue with pressure heat activated at temperature 266°F, which by thermal bonding forms a durable, long lasting bond to most rubber, EPDM, PU, and PVC-based plastic materials.
5. Acrylic adhesive on close side provides high adhesion and shear strength to many finished surfaces.

### Technical data

- 1 Thickness : 6.3 mil (0.16 ± 0.01 mm)
- 2 **Close side (Acrylic)**
  - 2.1 Tack : J. Dow No. 7
  - 2.2 Loop Tack : FINAT 9 63.49 oz/in (1.8 kg / 25mm)
  - 2.3 Peel Adhesion : PSTC - 3 56.43 oz/in (1.6 kg / 25mm)
  - 2.4 Shear Strength : PSTC - 7 over 24 hrs with 2.2 lbs loading on 1" x 1"
  - 2.5 Service Temperature Range : -40 °F ~ 248 °F

### 3 **Open side (heat activated)**

#### 3.1 Operation

	Temperature (°F)	Pressure (psi)	Time (sec)
Pre-lamination	77	2 – 6	2 – 3
Bonding	212	2 – 6	60
	230	2 – 6	50
	248	2 – 6	40
	266	2 – 6	30
	284	2 – 6	10
	302	2 – 6	5
	320	2 – 6	5

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### 3.2 Adhesion to different materials:

Material	Adhesion	Material	Adhesion
PC	8.8	PVC	7.3
ABS	8.8	Stainless steel	7.0
HIPS	8.4	EPDM	6.38 (carrier broken)
PET	7.9	PP	4.8
AL	7.9	HDPE	3.3

※Temperature: 266 °F, Pressure: 3 psi, Time: 30 sec, unit: lb/in width

### 3.3 Service Temperature Range : -4 °F ~ 284 °F

## Applications

1. Bonding of extruded plastic and rubber profiles in a variety of outdoors or indoors industrial applications.
2. Weather strip attachment.
3. Gasket bonding prior to mechanical fastening.

### Remark

All information and recommendations are given by us in good faith, on the basis of practical experience, but without warranty. It's essential that the user should evaluate the product for a period of time to determine whether it is fit for a particular purpose and suitable for the user's method of application.