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CAW Z20	
Uniclass L6739:P99	
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### PRODUCT INFORMATION

#### Description

illbruck TP150 High Performance Bonding Tape (formerly Alfas HPBT) is a specialised adhesive foam bonding tape manufactured from a high strength, closed cell polyethylene foam coated on both faces with a high performance solvent acrylic UV resistant pressure sensitive adhesive which is protected before use by a filmic release liner.

#### Usage/Purpose

The product is designed to bond lightweight components to surfaces where only the self weight of the component needs to be supported. Both contact surfaces must be flat, smooth and non-porous (e.g. glass, ceramics, metal, plastic). Applications would include door panel bonding, signage and Georgian bar installations.

#### Limitations

illbruck TN150 is not suitable for structural bonding applications. Some substrates may need priming to aid adhesion. In all cases, the user is advised to conduct indicative testing to determine the suitability of the product for the particular application. Initial tack and the rate of bond strength formation are temperature dependent. For external applications black tapes are recommended to provide maximum resistance to UV light and to reduce the visibility of staining from rain washed dirt ingress and weathering.

#### Selection

The table on the reverse of this page should be used as a guide to selecting the correct product. However, in all cases, the user is advised to conduct indicative testing to determine the suitability of the product for the intended application. Please contact our technical sales department for further advice and to request samples.

#### Colour

Black and white

#### Packaging

The product is supplied in standard length rolls, packed into cartons and interleaved for easy removal. Boxed quantities variable dependent on size. Contact Tremco illbruck Customer Service Department for details.

#### Availability

Direct from Tremco illbruck (see back of leaflet for address and telephone details) or via local and national distributors.

### USAGE GUIDELINES

#### Surface Preparation

- Surfaces to be bonded must be clean, dry and free from contamination such as finger marks, grease, oil and silicone lubricants.

#### Application

- It is recommended that the product is conditioned and applied at room temperature ( $\geq 20$  °C). Unwind the roll to expose the adhesive surface and place on to one of the surfaces to be bonded taking care not to stretch the tape.
- Remove the protective release liner and carefully apply the other component. Where component positioning is critical, remove only the start of the release liner, position and hold the component onto the tape and pull out the remaining liner. Apply firm pressure to the component to consolidate the adhesive bond. Maximum adhesion will be achieved after approx 24-48 hours.
- Consult separate published instructions.

#### Glazing Bar Bonding

- illbruck TN150 may be applied across the full width of the bar. With wider bars (20 mm and above) it is recommended to use two narrow strips of tape applied along the length of the bar. This helps reduce air entrapment and the compression force required to consolidate the bond.
- Presence of co-extruded gaskets has to be considered and tape thickness should allow for full contact with minimal compression of the gasket (Fig. 1).
- Tape thickness should be such that good contact with the glass is made along the full length of the bar (this should be checked after assembly).

#### Weathersealing: Glazing Bead Application and Sealing

- If illbruck TN150 is to be used as a weatherseal the tape must be compressed by 30 % of the original thickness.
- The system must provide mechanical means to ensure this level of compression along the entire length of the bead.
- Due to the difficulty in achieving the required level of compression in any glazing seal it is recommended that the windows are externally beaded and drained.
- Where this is not possible the tape should be capped with a compatible silicone or paintable sealant.

#### Bar Design Considerations

- Special consideration is required to ensure the beading and bars are flat and straight to allow even compression of the tape.
- The gap between substrates must be constant, if not, lifting of the tape may occur and allow dirt ingress.

## TECHNICAL DATA

Thickness	1 mm	2 mm
Colour	Black & White	Black & White
Foam Type	PE	PE
Foam Density (kg m <sup>-3</sup> )	64	48
Hardness Shore OO	67	60
Static Shear (kg/625 mm <sup>2</sup> at 60°C)	>120 hours	>120 hours
Static Shear (100 g/625 mm <sup>2</sup> at 60°C)	No Failure	No Failure
90° Peel (100 mm/min N/25 mm)	47 - Foam Tear	36 - Foam Tear
Loop Tack (300 mm/min N/25 mm)	29	31
Dynamic Tensile Adhesion (12.5 mm/min N/625 mm <sup>2</sup> )	309	518
Lap Shear Adhesion (12.5 mm/min N/625 mm <sup>2</sup> )	352	423
Service Temperature Range (°C)	-20 to +80	-20 to +80

A standard cutting tolerance of ±0.5 mm applies to all widths up to 10 mm and ±1 mm for all widths greater than 10 mm.

- Allowance should be made for expansion, avoiding tight joints between glazing bars and beads (which may prevent compression of the tape Fig. 2).
- Timber should be sealed on all surfaces and intersections sealed with flexible joint filler.

### Storage

Store rolls horizontally and in original carton between +5 °C and +25 °C in dry conditions and away from direct sunlight.

### Shelf Life

12 months when stored as recommended in original unopened packaging.

### Health and Safety Precautions

Product Safety Data Sheets must be read and understood before use.

### Technical Service

Tremco illbruck has a team of experienced Technical Sales Representatives who provide assistance in the selection and specification of products. For more detailed information, service and advice, please call Customer Services on 01942 251400.

### Guarantee / Warranty

Tremco illbruck products are manufactured to rigid standards of quality. Any product which has been applied (a) in accordance with Tremco illbruck written instructions and (b) in any application recommended by Tremco illbruck, but which is proved to be defective, will be replaced free of charge.

No liability can be accepted for the information provided in this leaflet although it is published in good faith and believed to be correct. Tremco illbruck Limited reserves the right to alter product specifications without prior notice, in line with Company policy of continuous development and improvement.

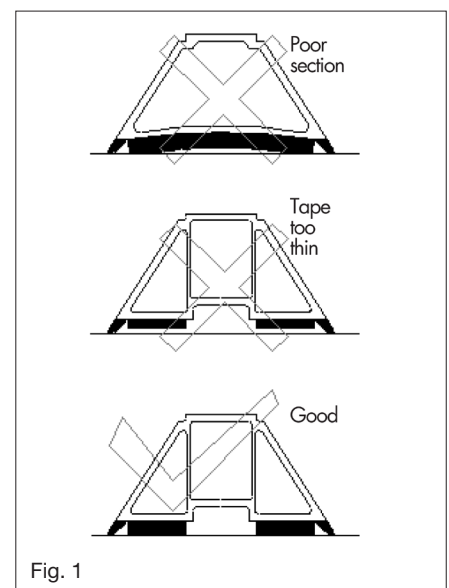


Fig. 1

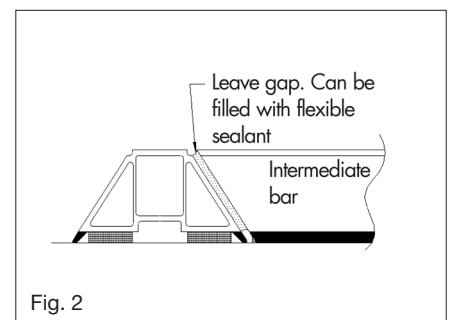


Fig. 2