

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 1891
SHEET : 1 of 4
RELEASE : August, 1984
REVISION :

NAME: ADHESIVE - TRANSFER TAPE - HIGH PERFORMANCE

1. SCOPE

This specification provides for an adhesive suitable for attaching nameplates, badges and emblems to a wide variety of surfaces including glass, painted and plated surfaces, aluminium, stainless steel and most plastics except polyethylene and polypropylene.

It is suitable for exterior usage and the Types B and C are suitable for textured or uneven surfaces. The material described in this specification is of a higher performance to that covered by HN 1555. Operating temperature range is up to 150° C continuous or up to 260° C short term.

2. GENERAL DESCRIPTION

The adhesive is a pressure sensitive, 100% Acrylic polymer, transfer tape protected with release paper. There are three thicknesses which allow for use on smooth to relatively rough surfaces, or where some surface mismatch exists.

3. REQUIREMENTS

3.1 Thickness	<u>Type A</u>	<u>Type B</u>	<u>Type C</u>
Adhesive	0.05mm (0.002")	0.13mm (0.005")	0.25mm (0.010")
Release Paper	0.10mm (0.004")	0.10mm (0.004")	0.10mm (0.004")

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THE COMPANY'S PRODUCTS THE RECIPIENT IS RESPONSIBLE TO
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3. REQUIREMENTS (Continued)3.2 SHEAR STRENGTH

Test Method. Two strips of stainless steel 100mm x 25mm are joined with the adhesive, end to end, by overlapping to 12.7mm.

The assemblies are allowed 72 hours dwell and then appropriate weights are attached to one end so that a shearing force is achieved. The assembly is placed in an oven at the appropriate temperature and the minutes to failure observed.

<u>Temperature</u>	<u>Load</u>	<u>Type A</u>	<u>Type B</u>	<u>Type C</u>
22° C	1,000 gm	10,000 (min to failure)	10,000 (min to failure)	10,000 (min to failure)
66° C	1,000 gm	10,000 (min to failure)	10,000 (min to failure)	10,000 (min to failure)
93° C	1,000 gm	10,000 (min to failure)	10,000 (min to failure)	10,000 (min to failure)
121° C	500 gm	10,000 (min to failure)	10,000 (min to failure)	10,000 (min to failure)
149° C	200 gm	10,000 (min to failure)	10,000 (min to failure)	10,000 (min to failure)
177° C	50 gm	10,000 (min to failure)	7,500 (min to failure)	5,000 (min to failure)

3.3 PEEL STRENGTH

Test Method Laminate the adhesive under test to a 200mm x 25mm strip of aluminium foil for 150mm. Remove backing paper and adhere to a similar size strip of aluminium. Bend the non-adhered sections 90° away from each other to form a "T". allow 72 hour dwell and perform 180° Peel test at 25° C.

<u>Type A</u>	<u>Type B</u>	<u>Type C</u>
25N/25mm	32N/25mm	35N/25mm

3.4 Water Resistance. When adhesive assemblies as in 3.3 are immersed in tap water at 25°C for 100 hours there shall be no reduction of adhesive strength.

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