

Code	Description	Size	Colour
56663	Gator VHB Double Sided Foam Tape	15mm x 1.00mm x 33m	Grey
56664	Gator VHB Double Sided Foam Tape	30mm x 1.00mm x 33m	Grey

1. Description

Gator VHB Double Sided Foam Tape has superior adhesion to most surfaces. With excellent weather and UV resistance it is great for using in automotive, electronic and construction applications.

2. Characteristics

- Super Strong
- ROHS Compliant
- Excellent Shock Absorption
- Excellent Solvent & Chemical Resistance
- UV & Weather Resistance
- Very Good Low Temperature Application

3. Technical Data

Type:	Acrylic Adhesive
Form:	Foamed Modified Acrylic Technology
Thickness:	1.00 mm (tolerance $\pm 10\%$)
Density:	Medium 750 kg/m ³
VHB Curing Time Guide:	20min – 50% 1 hour – 75% 1 day – 90% 3 day – 100%
Adhesion to Steel: <i>90° Peel Adhesion Power Test - bond at room temperature & test after 2 hours.</i>	20 min (RT) 2900 gf/10mm 24 hrs (RT) 3100 gf/10mm 250hrs 80°C 3000 gf/10mm 250hrs -20°C 2700 gf/10mm Speed: 300+/- 10mm/min Tape Width: 10mm Backing: 25 micron polyester film
Share Static: <i>Measured at various temperatures & gram loadings on stainless steel. 3.22 cm² overlap. Holding a load for 7 days</i>	Temperature Load Result 93°C 500g OK 120°C 250g OK
Dynamic Shear: <i>Measurement of the bonding load at room temperature - after 30 minutes. Speed: 200+/- 10mm/min Tape Width: 10mm x 10mm Backing: 75 micron polyester film</i>	RT 20 mins 8.5 kgf/cm ² RT 24 hrs 8.7 kgf/cm ² RT 48 hrs 9.0 kgf/cm ² RT X 100% RH 250 hrs 8.9 kgf/cm ² 80°C 250 hrs 8.9 kgf/cm ² -20°C 250 hrs 8.3 kgf/cm ²
Temperature Resistance: <i>Temperature measurement bonding tape at room temperature & for 1 hour with a weight - 500g & in an oven. Increase of temperature 3°C every 5 min & record falling temperature. Substrate: Stainless Steel Tape Width: 20mm x 20mm Backing: 75 micron polyester tape</i>	Test Rate = 120°C Range: - 40°C to + 120°C & 149°C (for short periods) Note: All installation instructions must be followed to ensure correct tape to surface bond.

4. Applications

TYPICAL APPLICATIONS

- A Multi-purpose VHB product with excellent adhesion to a wide variety of surfaces, especially HSE substrates such as metal, glass, many plastic (polycarbonate, ABS, rigid PVC & acrylic) & composites.
- Suited for use in many interior & exterior industrial applications.
- Used in many industrial application to replace or work in conjunction with rivets, screws, spot welds & liquid adhesives.
- Excellent bonding to clean aluminium & steel surfaces, glass & a wide variety of plastic substrates - (such as acrylic & polycarbonate).
- The conformable adhesive foam structure is excellent for mismatched substrates.
- For bonding automotive & decorative trim, bonding panels to metal frames & onto glass substrates.
- Adhesion to HSE (High surface energy substrates) - High
- Adhesion to LSE (Low surface energy substrates) - Medium

5. Packaging

Roll (33 meters)

6. Shelf Life

12 months if stored in cool, dry place in original condition, unopened cartridges. Store in cool, dry conditions out of direct sunlight. Avoid high humidity storage locations. Store between 12°C to 25°C.

7. Application Instructions

Surfaces

Preparation:

Ensure that the adhesive product & substrate are allowed to acclimatise to the environment before bonding. Clean and dry and free from dust and loose or flaking material. A good surface preparation will ensure better adhesion. A wipe with Soudal 696 Surface Activator or Gorilla Solvent Cleaner is recommended to remove surface contaminants.

BOND TO:

← EASY → → HARD ←

HIGH SURFACE ENERGY (HSE)	MEDIUM SURFACE ENERGY (MSE)	LOW SURFACE ENERGY (LSE)
Stainless Steel	Acrylic	Polyethylene
Aluminium	Rigid PVC	Polypropylene
Glass	Polycarbonate	Silicone
Anodized Aluminium	ABS	Acetate
Zinc	Polyester	Teflon
Cooper	Nylon	Tedlar
Lead	Kapton	Polystyrene
Painted Metal (not powder coated)	Epoxy & PU Paint	EVA
	Powder Coated Metal	
NOTE: The higher the surface energy, the greater the strength of adhesion.		

Application

Method:

Press firmly the Gator VHB Double Sided Foam Tape onto cleaned surface to the required length, remove the protective backing film and press the prepared substrate to it. Ensure that there is complete contact and avoid air bubbles.

Application temperature: Above 15°C and below 25°C

Soudal recommends the customer tests that the suitability of the product for its desired purpose.

Application Limitations

- Due to the wide variety of possible uses & applications, customers should independently determine the suitability of these products for their specific purpose, prior to use.
- The suitability of this product, for each intended use, must be determined by the purchaser prior to acceptance

8. Manufactures Certification

- KS ISO 14001: 2009/ISO - 14001: 2004
- KSQ ISO 9001: 2009/ISO - 9001: 2008

9. Health and Safety Recommendation

- Apply the usual industrial hygiene.
- Pre-testing for adhesion is intended to eliminate potential field problems. This testing will aid in determining the proper surface preparation method.
- For more detailed information, please refer to the SDS.

Remark

*The directives and data contained in this documentation is provided in good faith and accurately reflect Soudal's knowledge when its products are properly stored, handled and applied under normal conditions in accordance with Soudal's recommendations. In practice, the diversity of the materials, substrates, environments, site conditions, product storage, handling and application are such that no warranty can be given in respect to the merchantability or fit for purpose, of any product. All users must determine the product suitability for their purposes through testing. This technical data sheet and product properties may change without notice so users, suppliers and retailers of Soudal products should always check that the data sheets they have are the latest. To the maximum extent permitted by law, Soudal disclaims all warranties in relation to either the manufacture, storage and end use of the product. All orders are accepted subject to our current terms of trade. **If any clarification is required, please contact Soudal Technical Services or email info@soudal.co.nz.***

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