

How to apply 3M™ VHB™ Tapes

1.



Surface cleaning

- Put on suitable gloves. Follow the instructions in the material safety data sheet for the cleaner that you use.
- Use clean, non-perfumed cleaning cloths without plasticizers.
- Use cleaning agents that are suitable for the type of soiling and the surface such as 3M™ VHB Surface Preparation Cleaner (no greasing household cleaners).
- Repeat cleaning procedure until the surface is clean and free from grease. Change the cloth while cleaning.
- Use 3M™ Silane Glass Treatment to clean and treat glass surfaces (please follow the specific instructions for use).

2.



Applying 3M VHB Tapes

- Apply the tape onto the surface to be bonded. Pull the tape tight, but do not overstretch. Try to avoid air bubbles.
- Do not apply the section at the start of the VHB adhesive tape which has been touched (let this piece protrude and cut it off).
- Immediately press it down firmly or roll over it with a pressure of approx. 20 N/cm².

3.



Cutting mitered edges

- Always cut vertically through both tapes.
- Use an angle of 50°/40° (not 45°/45°) in order to achieve a proper seal.





4. Cut protruding tape edges and firmly press/roll over



5. Liner removal and application of the mating part

- Remove the liner in one piece. This is especially important when using transparent adhesive tapes as otherwise „stop marks“ will result.
- Do not touch the adhesive surface.
- Apply the second mating part quickly after liner removal in order to prevent the open adhesive surface from becoming soiled.



6. Applying the second part to be bonded

- Apply pressure (approx. 20 N/cm²). Try to avoid air bubbles.
- **Important note:** Ensure you position the part correctly: once applied, it cannot be removed due to the high adhesive force
- Final strength is achieved after 72 hours at 20 °C. The curing process can be accelerated by heat (e.g. final strength after one hour at 65 °C)

Important Notice: The values presented above are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. Please make sure that all construction and building regulations are complied with when using these adhesive tapes. All questions of warranty and liability relating to these products are governed by the terms and conditions of sale, subject, where applicable, to the prevailing law.

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