

# PSA Tape Application Guide

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Along with selecting the right adhesive, an understanding of application temperature, pressure, and proper surface preparation are essential to achieve a reliable bond. This guide outlines how some of our more popular tapes perform when bonded to many common foams and other materials. It also provides tips and guidelines to help ensure the best performance of our tapes.

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## APPLICATION GUIDE - DOUBLE COATED TAPES

Product	M1206	M1207	M1212	M1213	M1272	M1276	M1511 M1516	M1521 M1522	M1523	SSA1593	T1538	T1521
Polyether	Best	Good	Better	Best		Best	Best	Best	Best	Best	Best	Good
Polyester	Best	Better	Best	Best	Good	Best	Best	Best	Best	Best	Best	Better
Low Perm							Best		Best			
Neoprene Sponge	Good	Better	Better	Better		Good		Best		Better	Best	Better
EPDM Sponge	Good	Better	Better	Better		Good	Better	Best	Better	Better	Best	Better
MLC/Sponge	Better	Best	Best	Best		Better		Best		Better	Best	Better
Polyethylene Foam	Good	Best	Better	Better	Good	Good		Best		Best	Best	Better
Cork/Rubber	Good	Better	Better	Best		Good		Best		Better	Best	Better
Felt	Better	Best	Better	Best	Good	Better	Good	Best	Good	Best	Best	Best
Sheet Rubber			Good	Best				Better		Better	Better	

## APPLICATION GUIDE - UNSUPPORTED TRANSFER TAPES

Product	TF1111 TF1113	TF1115	TF1123 TF1125	TF1142	TF1182	TF1552 TF1553	TF1555	TF1572 - TF1574
Polyether		Good	Best	Best		Best	Best	Good
Polyester	Good	Good	Best	Best	Good	Best	Best	Best
Standard Neoprene Sponge Blends	Better	Better	Best	Better	Better	Better	Better	Best
EPDM Sponge	Good	Better	Best	Good	Good	Better	Best	Best
MLC/Sponge	Best	Best	Better	Best	Best	Good	Better	Best
Polyethylene Foam	Best	Best	Best	Best	Best			Good
Bun - Plank PE	Good	Better	Better		Good			Better
Felt	Best	Best	Best	Better	Better	Good	Better	Best
High Density Urethane	Good	Best	Best		Good	Best	Best	Best
Sheet Rubber		Good	Best				Better	Good
IV 1	Good	Better			Good	Better	Better	Best
IV 2		Good	Better			Better	Better	Best
IV 3							Good	

Many adhesives produce a foam or material tearing bond when removed soon after application. Chemical degradation or changes, out gassing from the foam and other factors may change this performance as the bond ages and initial results may not be the same as the performance of aged parts. The fabricator must consider the needs of the application, and understand the expectations of the end-user in order to choose the right adhesive. The above tables are provided only as a guide to assist the converter in adhesive selection, and should not replace the careful testing required for every application by the fabricator and end user. It is not a warranty of any kind, either expressed or implied. CCT makes available adhesives in various coating weights to accommodate the cell structure and the porosity of the materials being bonded. The above table assumes the fabricator has optimized the laminating process, and is using consistent quality materials. CCT recommends the use of heat assistance when laminating to most foams and materials to achieve an optimal bond, especially with any urethane foam.

## **Application Temperature**

Application with heat during lamination helps with adhesive flow and surface wet-out to improve the bond. Lower temperatures might lead to insufficient wetting of the adhesive on the substrate. Extremely high temperatures might cause the tape to stretch when being applied, which could create additional stress in the final application. The recommended application temperature range is 50°F – 100°F.

## **Surface Preparation**

Be sure the application surface is clean, dry and free of grease, dirt or other contaminants. Clean the surface with a lint-free cloth and any suitable cleaner (water, solvents, etc.) and allow it to thoroughly dry. Suitable solvents for use include toluene, alcohols, esters, and ketones. Always test the substrate to be sure it is able to withstand the cleaner prior to application. When using a solvent, follow the manufacturer's recommendations and precautions.

## **Surface Pressure**

Pressure sensitive tapes need surface contact pressure to achieve a strong bond between the tape and substrate. In some cases, lower pressure can be used to achieve 100% contact. Conversely, excessive pressure can result in tape compression and/or stretch.

A general guide would be, light pressure of a few psi. Use more pressure for a rough surface versus a smooth surface. Bond strength is dependent upon a number of factors including specific adhesion, the amount of pressure, surface contact, and residence time.

## **Storage Conditions**

Pressure sensitive tapes must be properly stored to maintain bonding characteristics. Extreme high and low temperatures can lead to degradation of the adhesive or backing materials. Store rolls in the original packaging in a controlled environment (72°F / 22° C and 50% RH) out of direct of sunlight.

## **Tips**

Only remove the liner when ready to make the final lamination. Do not allow adhesive to remain exposed to air for extended periods of time as dust, moisture, dry heat and other ambient conditions can reduce its effectiveness.

Do not put excessive pressure on the bond line until the part is properly placed. Apply adequate pressure to the entire bond line to ensure proper adhesion.

There are some substrates that are generally easier to bond to than others. These are the materials with higher surface energy. It is important to know that coatings on the surfaces or fillers in the substrates might influence adhesion characteristics. A painted aluminum or plasticized PVC (polyvinyl chloride) might display completely different bonding characteristics as compared to pure, unaltered materials.

Consider using a primer or adhesion promoter to alter the surface characteristics of substrates to enhance bonding. Consult the product's usage recommendations to be sure that adhesive systems and primers are cooperative in nature. Corona or flame treatments can also be applied.



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