

CI/SfB	(31)	Ln6
CAW P10		
Uniclass L6631:P91		

### Description

TN021 is made from a composition of viscoelastic acrylic copolymers and monomers with glass microsphere fillers which is then extruded and cured using UV light. The product is naturally tacky and is capable of forming structural bonds with many non-porous materials, in many cases eliminating the need for mechanical fasteners. Certain grades have an additional acrylic adhesive coating to enhance adhesion to low energy surfaces.

### 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

White, dark grey and clear

### Packaging

Boxed quantities variable dependent on size. Contact tremco illbruck Customer Service Department for details.

### Substrate Design Considerations

- Special consideration is required to ensure the substrates 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.
- Allowance should be made for substrate expansion, for example, avoiding tight joints between glazing bars.
- Timber should be sealed on all surfaces. Intersections in glazing bars may be sealed with flexible joint filler if required. With wider substrates and glazing bars (20mm and above) it is recommended to use two narrow strips of tape applied along the length of the substrate / bar. This helps reduce air entrapment and the compression force required to consolidate the bond.
- Presence of co-extruded gaskets on glazing bars has to be considered, and tape thickness should allow for full contact with minimal compression of the gasket.
- 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).

### Surface Preparation

- Prime porous substrates such as plaster, timber and concrete. Remove oxidation from metal surfaces such as mill finish aluminium, copper and brass by abrasion.
- Lightly abrade very smooth non-porous surfaces to form a key. Surfaces to be bonded must be absolutely clean, dry and free from contamination such as dust, grease, oil and silicone lubricants
- The use of alcohol based cleaning solvents such as Isopropanol are recommended. These must be applied with a clean cloth or tissue.



**TN021**

## Foamed Acrylic Tape

### Usage / Purpose

TN021 is ideal for use in:

- Manufacture of resin bonded laminated glass
- Sign manufacture
- Georgian bar bonding
- Door panel manufacture
- Commercial vehicle body manufacture
- Manufacture of architectural cladding panels
- General metal fabrication

### Key Benefits

- Instant bond equivalent in strength to mechanical fixings
- Non-mechanical bonding – can support reduction in gauge thickness
- Achieves a constant, factory-controlled bond film thickness

## Technical Information

Property	Units / Test Method	Product Code																	
		C040	C064	C080	C110	025C	050C	100C	150C	200C	040W	064W	080W	110W	200W	040G	080G	110G	150G
Colour		White	White	White	White	Clear	Clear	Clear	Clear	Clear	White	White	White	White	White	Dark Grey	Dark Grey	Dark Grey	Dark Grey
Thickness	mm	0.40	0.64	0.80	1.10	0.25	0.50	1.00	1.50	2.00	0.40	0.64	0.80	1.10	2.00	0.40	0.80	1.10	1.50
Foam Density	kg/m <sup>3</sup>	850	850	850	850	850	850	850	850	850	850	850	850	850	850	770	770	770	770
Standard Release Liner		Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film	Red PE Film
180° Peel Adhesion	ASTM D-3330 g/cm	3200	3600	4100	4500	1600	2100	2700	3200	3300	3500	4100	4000	4500	3500*	3900	3900	3900	3900
Tensile Adhesion	ASTM D-897 g/cm <sup>2</sup>	11300	11300	10700	9900	10100	7030	7030	6970	7000	11000	10500	11000	9900	6550~	5500	5500	5500	5500
Dynamic Shear	ASTM D-1002 g/cm <sup>2</sup>	7100	7100	6800	5700	14500	4900	4900	4500	4000	8000	7200	6700	5700	4800#	5500	5500	5500	5500
Temperature Resistance Short Periods	°C	150	150	150	150	260	200	200	200	200	200	200	200	200	200	160	160	160	160
Temperature Resistance Continuous	°C	93	93	93	93	150	150	150	150	150	149	149	149	149	150	100	100	100	100
Low Temperature Resistance	°C	-30	-30	-30	-30	-30	-30	-30	-30	-30	-30	-30	-30	-30	-30	-40	-40	-40	-40
UV Resistance		Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
Storage		Store in dry shaded conditions between +5°C and +25°C.																	
Shelf Life		12 months when stored as recommended in original unopened packaging.																	

\* 90° peel adhesion at room temperature to stainless steel ~To aluminium at room temperature #To stainless steel at room temperature`  
All figures shown are averages and are subject to tolerances. If physical property and/or dimensional properties are of particular concern please consult the sales office. Note : Products prefixed 'C' are coated with acrylic adhesive to enhance adhesion to low energy surfaces

## Application

- The recommended application temperature is +20°C. The minimum application temperature is +10°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 (100KPa) to the component to consolidate the adhesive bond. Maximum adhesion will be achieved after approx 72 hours. Avoid stressing the bond in the first 24 hours.

## Please Note

Do not use in applications where the tape will be constantly submerged in liquid. For external applications dark grey tapes are recommended to reduce the visibility of staining from rain washed dirt ingress and weathering.

## Health & Safety Precautions

Safety data sheet 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 01952 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.



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