

# Attila 7040B

## Black Acrylic Foam Tape for LSE-Substrates

Created: 2009-03-04  
Updated: 2018-01-04

### GENERAL INFORMATION

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Attila 7040B represents a new generation tape made for Low Surface Energy (LSE) materials. This tape is softer than normal LSE-acrylic foam tapes.

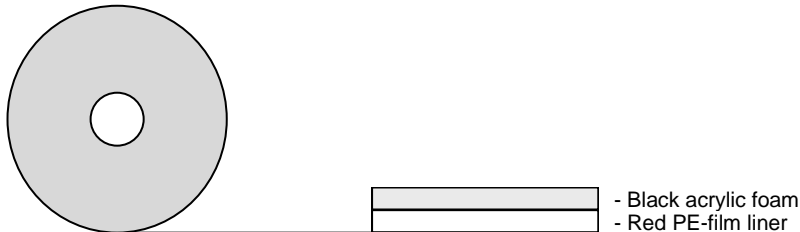
- 0,80mm thick
- Acrylic adhesive
- Temperature resistant up to 120°C
- Excellent for LSE-surfaces

Attila 7040B can be die-cut for custom made parts and is available in all dimensions but standard widths are:

- 9mm x 33m
- 12mm x 33m
- 19mm x 33m
- 25mm x 33m
- 50mm x 33m

### CONSTRUCTION

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### APPLICATIONS

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Attila 7040B is used for many kinds of bonding applications. Due to a high holding force power the tape can replace bonding solutions such as screws, rivets, nails and fluid adhesives. The Attila 7-series is suitable for bonding of very difficult surfaces with low surface energy, for example powder coated substrates, PTFE materials, and plastics such as PP.

### USER GUIDELINES

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To obtain optimal adhesion the surfaces must be clean and dry. Most frequent cleaning solvent is isopropyl/water (50:50 mixture) alcohol. Use safety instructions before using cleaners. Sometimes depending on surface a primer can be used to obtain a higher bonding force. Ideal temperature for tape application is between 21°C and 38°C. All Attila tapes require a dwell time of 72 hours for achieving 100% bonding strength.

## PRODUCT DATA

### Physical Data:

Adhesive:	Acrylic
Carrier:	-
Thickness:	Tape: 0,80mm Liner: 0,13mm Total: 0,93mm
Liner:	Red PE-film
Colour:	Black
Shelf life*:	24 months
Storage:	Good storage conditions are in room temperature. Not recommended for direct exposure to sunlight or ultraviolet light.

\* From date of dispatch by ATC Tape Converting AB

### Performance Data:

Tensile Strength: Width 10mm, Length 80mm, Jaw Speed 300mm/min (ASTM D3759)	0,7 Kg/10mm
Elongation:	1 050 %
180° Peel Adhesion: To silicone treated painted panel with Jaw Speed 300mm/min (ASTM D3330)	>1,8 Kg/10mm
180° Peel Adhesion: To Stainless steel with Jaw Speed 300mm/min (ASTM D3330)	>2,2 Kg/10mm
Shear Adhesion: (ASTM D1002)	8,0 Kg/cm <sup>2</sup>
Heat resistance:	-30°C to +120°C

## TEST METHODS

### 1. Thickness

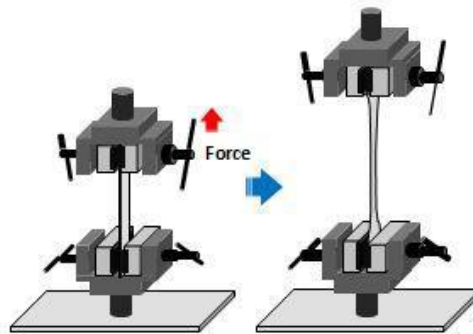
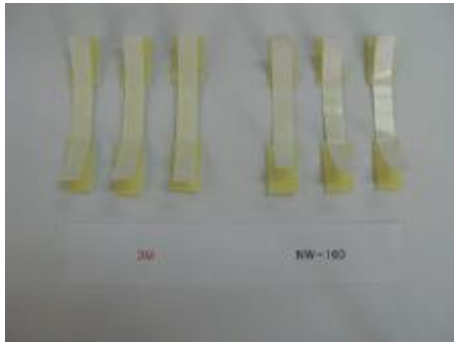
- 1-1. Tool: Dial thickness gauge  
 1-2. Standard Reference: ASTM D3652  
 1-3 Contents: 1) Prepare substrate (acrylic foam).  
 2) Press lever (1 in figure below). There is space at between tip (2).  
 3) Release lever and read thickness (4).



All values above are average values and are not to be specific. To be sure about finished result we recommend that you do testing and use the product to determinate the function of the tape for your application. ATC Adhesive Tape Converting AB does NOT take any responsibility or liability direct or consequential for any loss or damage caused by using our product.

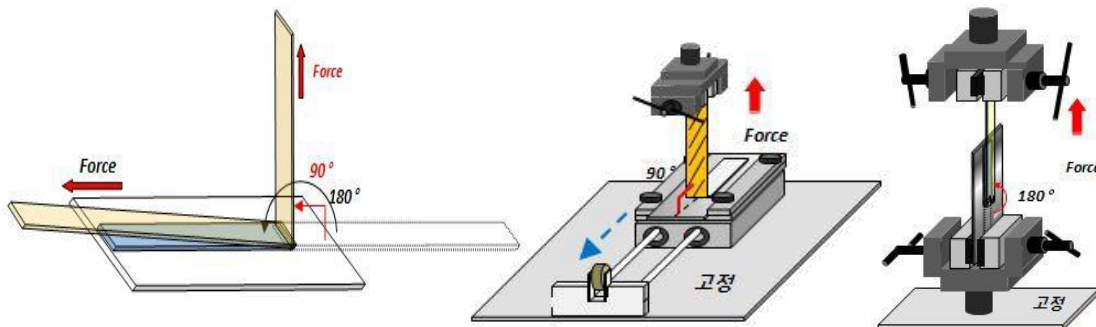
## 2. Tensile Strength and Elongation

- 2-1. Tool: Tensile Tester  
 2-2 Standard Reference: ASTM D3759  
 2-3 Contents:
- 1) Prepare tape as proper size (80mm X 10mm).
  - 2) Tapping both ends with masking tape, width is 25mm, and grab with the clamp of tester.
  - 3) Extend until break foam tape (speed is 300mm/min), and read tensile strength and elongation.



## 3. 90, 180° Peel Adhesion Strength

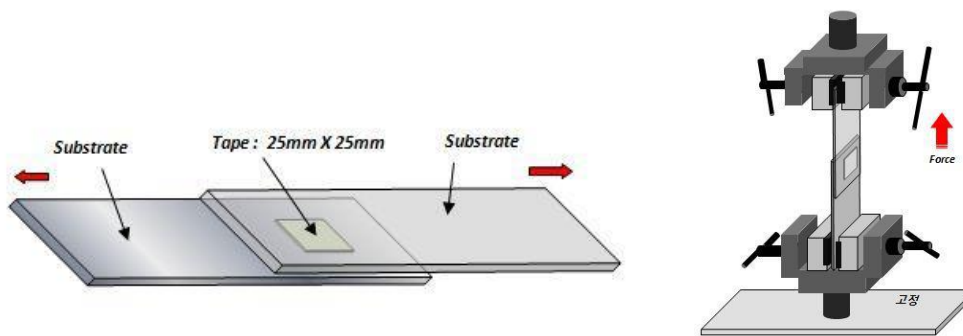
- 4-1. Tool: Tensile Tester  
 4-2. Standard Reference: ASTM D3330  
 4-3. Contents:
- 1) Prepare the tape, width 10mm x length 24cm, and apply on substrate.
  - 2) Press tape one time with 2kg Roller and 300mm/min speed.
  - 3) After 24 hour from application of the tape measure the adhesive strength with 300mm/min speed



## 4. Shear Adhesion

- 4-1. Tool: Tensile Tester  
 4-2. Standard Reference: ASTM D1002  
 4-3. Contents:
- 1) Prepare sample as 25mm x 25mm.
  - 2) Apply tape on both substrates (SUS-SUS, ABS-ABS, PE-PE).
  - 3) Press one minute with 5kg weight.

4) Measure shear adhesion strength with 300mm/min speed.

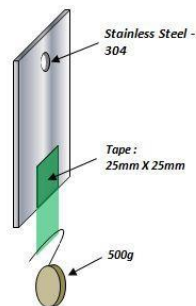


### 5. H. C. R (Heat Creep Resistance)

5-1. Standard Reference: ASTM D3654

5-2. Contents:

- 1) Prepare the substrate material (SUS) in the required size, 25mm x 25mm.
- 2) Press the tape two times with 2kg Roller and 300mm/min speed. Keep 30min in room temperature.
- 3) Measure temperature and creep distance with 500g weight and increasing temperature as increasing 10°C per 20min.



## CONTACT INFORMATION

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