

## Best Practices for Storing and Applying Pressure Sensitive Adhesive Tapes

### Applying the PSA:

It is essential with all Pressure Sensitive Adhesives (PSA) that the bonding surface be clean, dry and free of lint, grease and oil contaminations. Surfaces that have been exposed to the elements or some form of prior use, should be wiped down with an evaporative solvent such as MEK (methyl ethyl ketone). After the surface has been cleaned and dried, follow by wiping the area again with isopropyl alcohol. Other cleaning products include esters (ethyl acetate or acetone) and naphtha-based products. It may be necessary to improve the surface energy by using primers, flame treatment, corona treatment, etc.

Generally PSA's require a minimum of 15 psi to secure most bonds whether via hand apply, hand roll down, squeegee, roll/nip laminator, etc. The minimum application temperature is >50° F and they will continue to wet-out or build in adhesion for up to 72 hours, especially acrylic and silicone pressure sensitive adhesive systems. Heat lamination improves surface contact area and decreases wet-out time.

### Storing the PSA:

For pressure sensitive tapes to retain their properties while in storage, the following conditions should be complied with:

- 68-72° F
- 50% relative humidity
- Rolls stored flat in their original packaging
- Stored away from direct sources of UV, such as lights and sunlight.

Unless otherwise indicated on the package, products are typically guaranteed for 12 months under the above mentioned conditions.