

**FICHES
PRATIQUES****APPLICATION
PRODUCT DATA SHEETS
Technical Double-face Tape
TT000 RANGE****MATERIAL REQUIRED**

- ✓ Tesa® 7476 adhesive agent
- ✓ HEXIS'O surface active agent
- ✓ CLEAN HEXIS medium degreaser
- ✓ ND45 degreaser
- ✓ A scraper
- ✓ A hard roller

**STORE YOUR PRODUCTS IN GOOD
CONDITIONS**

Keep the double-face tapes away from all sources of heat (radiators, direct exposure to sunlight, etc.): the ideal temperature is between 10°C and 30°C. The recommended storage temperature for TTGRIP is 20°C.

Store the tapes in a place with little humidity (50% relative humidity).

Keep your tapes in their original packaging.

CHARACTERISTICS

Technical double-face tapes, with high adhesion capacities, composed of an adhesive foam that is pressure sensitive. Designed for permanent adhesion to a wide range of supports. Can, in certain cases, replace mechanical fixations such as solders, rivets, glue, etc.).

TT611

- ✓ 1.1 mm thick.
- ✓ Colour: grey.
- ✓ Adhesion 180° (stainless steel): 52 N/25mm.

TT613

- ✓ 1.1 mm thick.
- ✓ Colour: white.
- ✓ Adhesion 180° (stainless steel): 52 N/25mm.
- ✓ Especially designed to adhere to metallic paint supports.

TT905

- ✓ 0.5 mm thick.
- ✓ Colourless.
- ✓ Adhesion 180° (stainless steel): 25 N/25mm.

TT905

- ✓ 1 mm thick.
- ✓ Colourless.
- ✓ Adhesion 180° (stainless steel): 30 N/25mm.

TTGRIP

- ✓ Closure system using self-adhesive pressure opening / closing.

PREPARING THE APPLICATION SUPPORTS

You can apply your HEXIS double-face tapes to a wide range of substrates, on the condition that these substrates have a clean, dry, smooth, non-porous surface with no traces of oil, grease, wax, silicon or other pollutants. To avoid any nasty surprises, work on the principle that all substrates are polluted and must be cleaned (see Chapter 3). Do not forget to first do a test on a small surface area to make sure that the substrate will not be damaged.

SOMMAIRE

- 1- Recommandations
- 2- Preliminary testing of substrates
- 3- Cleaning
- 4- Application of the double-sided tape

I. RECOMMANDATIONS

> Optimal adhesion of the films is obtained after 24 hours of contact at 23°C.

2. PRELIMINARY TESTING OF SUBSTRATES

- > Any fresh paint must be allowed to dry for at least 7 days at 25°C to allow total degassing to take place.
- > Any older paint, or paint that has become either dry or dusty, must be sanded and renovated before application, and undergo an adherence test.
- > For all painted substrates, apply only to original, undamaged paint. If the paint is not original, or has been damaged, the application and/or removal of the film is at the discretion of the person applying it.

Adherence test

With adhesive tape of the Tesa® 7476 type or equivalent, stick to the surface a sample of 2.5cm x 5cm, plus some extra length to hold. Fold and tear off in a swift movement at a right angle to the surface. No trace of adhesive should be left on the substrate. Repeat the operation in different areas.

> On request, HEXIS can supply 2.5 x 5cm Tesa® adhesive tape.

3. CLEANING

Depending on the state of the substrate, there are three possible cleaning methods:

3.1 A clean-looking substrate:

Before applying the tape to the substrate to be covered, we recommend that you clean it with a gentle cleaning solution, HEXIS'O. Dry with a clean, lint-free cloth.

3.2 A dirty-looking substrate:

Clean the substrate with a cloth soaked in CLEAN HEXIS medium degreaser and dry with a cloth before it evaporates.

If the substrate has been dirtied by resistant polluting agents such as diesel, tar or rubber, use a cloth soaked in a strong degreaser, HEXIS ND 45. If necessary, first use a soft, non-abrasive scraper.

In all cases, wash the areas in question with HEXIS'O afterwards.

3.3 Special cases:

Remember to adapt the substrate preparation methods to the nature and state of the substrate. Painted surfaces must thus be dry and hardened, baked paints must have cooled. Air-dried paints or vehicle paint require 7 to 10 days' drying before application of the films. For bare metallic surfaces, clean the substrate with soapy water and then with a cloth soaked in HEXIS'O.

HEXIS'O
agent nettoyant
et dégraissant



CLEAN HEXIS
agent nettoyant
et dégraissant
moyen



ND45
agent nettoyant
et dégraissant
puissant



HEXIS'O
Cleaning agent and degreaser

CLEAN HEXIS
Cleaning agent and medium
degreaser

ND45
Cleaning agent and strong
degreaser

4. APPLYING THE TAPE

Before starting to apply the double-face tape, make sure that all the surfaces are clean (see paragraph 3), paying particular attention to critical areas such as corners and edges.

The ideal temperature for application is between 15 and 30°C, and this must be respected for both the air temperature and that of the substrate. If the application temperature is lower, it is not possible to guarantee sufficient adhesion of the tape to the substrate.

The ambient humidity level may also have an influence on the quality of the film's adhesion to the substrate.

Study your substrate prior to application:

> If your substrate is very porous (brick, concrete, construction materials, etc.), it is necessary to apply a coating (such as paint or varnish) so as to obtain a homogenous surface. Take the coating's drying time into account.

> Metallic substrates that are liable to rust must first be coated with an adequate rust-prevention coating. If the substrate is already rusted, sand down the surface before applying the coating. Take the coating's drying time into account.

4.1 Applying double-sided tape:

Once the substrate has been prepared, cleaned and dried, you can start to apply the double-sided tape:

> Stick the tape to the surface, leaving the protection liner in place. Press down firmly, using the scraper, all along the length of the tape. (FIG 01)

Apply maximum pressure during application so as to guarantee optimum adhesion.

> Remove the protection liner.

> Put the part into position and press down firmly. If the geometry of the part allows it, use the tool (hard roller) to exert sufficient pressure. (FIG 02)

4.1 Applying a TTGRIP closure system

Once the substrate has been prepared, cleaned and dried, you can start to apply the TTGRIP to the two parts that are to be assembled:

> Remove the protection liner.

> Stick the product down using as much pressure as possible. If the geometry of the part allows it, use a hard roller to exert sufficient pressure. (FIG 03)

> The two parts can then be assembled by simply pressing them together. The TTGRIP has no particular right side. The closure works perfectly regardless of the angle between the two elements.
(FIG 04)

For any further information of a technical nature, please consult the technical data sheets available for download from our internet site www.hexisgroup.com in the Professionals/Technical Data Sheet section.

The very wide range of substrates available, combined with the ever-increasing number of new possibilities, obliges the user to examine the aptitudes of the product for each particular usage.

All the information given herein nevertheless does not constitute an absolute warranty factor. The seller assumes no liability for any indirect damage and cannot be held financially responsible beyond the price of his own products. All our specifications are liable to modification without prior notice. Our specifications are updated automatically on our site, www.hexisgroup.com.



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