



# HPA 1905

## High Performance Transfer Tape

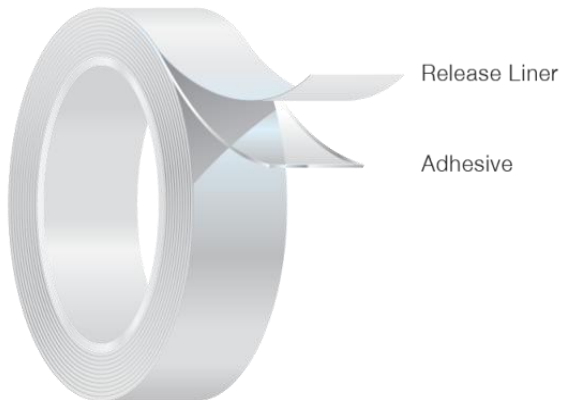
Specially designed for use on nameplates, membrane touch switch assemblies and graphic overlays. Applications requiring good "holding power" under stress and load and environmental resistance.

### FEATURES:

- Unsupported, specially formulated acrylic adhesive
- Adhesive protected by moisture resistant polycoated kraft liner
- Thick adhesive mass for good adhesion to high surface energy plastics
- Ease of die-cutting and liner removal
- UL 969 Recognition under File No. MH13584 (PGGU2 Category)
- UL 746C Recognition under File No. E328479 (QQW2 Category)

### BENEFITS:

- Excellent balance of properties to perform in demanding applications
- Excellent high temperature peel adhesion
- Chemical, solvent, heat, humidity and UV resistance
- Thick adhesive mass allows for improved bonding and gap filling
- Moisture stable liner provides lay flat for easy processing



### CONSTRUCTION:

#### Liner:

Red Printed Natural Stafflat

#### Adhesive:

Acrylic

**HPA 1905**

Adhesive Properties:		Typical Values	
Thickness	Test Method(s): PSTC-133	US Mils	MM's
Liner:		5.6	0.14
Adhesive:		5.0	0.13
Total Caliper:		10.6	0.27

**PEEL ADHESION** Test Method(s): PSTC-101, ASTM D-3330, STD-10

2 mil PET 24 hr dwell 180° 12" min

Substrate	Lbf / In	US Oz / In	N / Meter
SS	3.7	59	643
Aluminum	2.7	42	464
Glass	3.1	50	543
Paint	3.7	59	646
ABS	4.8	76	835

**LOOP TACK** Test Method(s): PSTC-16, STD-7

2 mil PET 180° 20" min

Substrate	Lbf / in	US Oz / In	N / Meter
SS	7.7	123	1348

**STATIC SHEAR** Test Method(s): PSTC-107, ASTM D 3654, STD-9

Aluminum Foil 1" sq (6.5 cm2) 1000 g

Substrate	Min to Fail
SS	> 10,000

**STATIC SHEAR** Test Method(s): PSTC-107, ASTM D 3654, STD-9

Aluminum Foil 400°F Static Shear 24 hr dwell 1" sq (6.5 cm2) 1000 g

Substrate	Min to Fail
SS	> 5,000

**SAFT** Test Method(s): ASTM D 3654, STD-243

Aluminum Foil 1" sq (6.5 cm2) 1000 g

Substrate	Min to Fail	Fail Temp °F
SS	> 475	> 403

TEMPERATURES	° F	° C
Min Application Temp	50 ° F	10 ° C
Max Continuous Operating Temp	400 ° F	204.5 ° C
Max Intermittent Operating Temp	450 ° F	232.3 ° C

THE LISTED VALUES ARE TYPICAL AND NOT INTENDED TO SERVE AS PRODUCT SPECIFICATIONS

**APPLICATION TECHNIQUES**

- It is essential, as with all pressure-sensitive tapes, that the surface to which the tape is applied be clean, dry, and free of grease or oil
- Bond strength is dependent upon the amount of adhesive-to-surface contact developed
- Note that different pressure, time and temperature on different (film / rigid) surface achieves different performance

**STORAGE / SHELF LIFE**

- One year when stored at 70°F (21°C) 50% RH out of direct sunlight.

Please refer to [Tapes.AveryDennison.com](http://Tapes.AveryDennison.com) for complete terms and conditions, including warranty terms, relating to this product. You should periodically review the site as terms and conditions are subject to change without notice.

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