

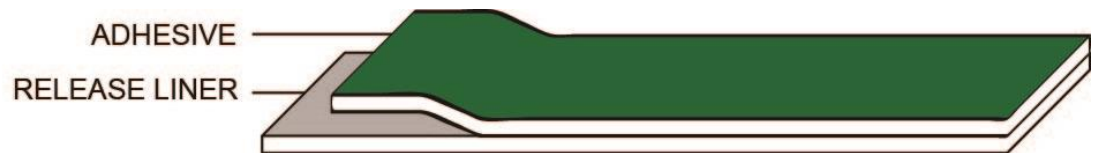
ARcare® 93020 is a self-wound heat seal adhesive that is designed to be activated with UV energy to produce heat resistant bonds when used to combine substrates. The adhesive film is designed to activate upon exposure to UVB energy and have an open time of up to 3 hours after activation when used to combine substrates with heat and pressure.

PRODUCT APPLICATIONS

The typical use for this product is to laminate substrates using mild heat and pressure (i.e. 95°C / 203°F, 10 psi) using a heated laminator or platen press.

Remove the release liner and expose the adhesive to 200-300 mJ/cm² UVB.

Within 3 hours at room temperature, combine the UV activated adhesive coated part to the second substrate of interest using heat, pressure, and time sufficient to achieve a bond temperature of 120°C (248°F) for 90 seconds.



FEATURES AND BENEFITS

- Low thermal cure temperature
- Heat resistant bonds
- UV-blocking release liner
- Fast/low dose UV activation step
- The ability to use a UV curable adhesive on opaque parts
- Excellent chemical resistance

Product Construction			
	Typical Values*		Description
Liner thickness	2.0 mil	50 µm	White UV-blocking polyester, D/F
Adhesive thickness	3.8 mil	97 µm	HA-37 Polyester resin-based thermoset heat activated
Total thickness	3.8 mil	97 µm	(Excluding liner)

*All stated values are nominal and should only be used as a guide for selection. They are not specifications.

Technical Properties			
Attribute*	Typical Values*		Test Method*
Dynamic Shear @ RT, fiberglass reinforced plastic to itself	600 psi	4.1 N/mm ²	0.05 ipm to cohesive failure
Dynamic Shear @ 65°C, fiberglass reinforced plastic to itself	55 psi	0.4 N/mm ²	0.05 ipm to cohesive failure
Lap Shear-Accelerated Hygrothermal Aging		Initial psi (Kg/cm ²)	Post psi (Kg/cm ²)
	FR4 to FR4	540 (37.9)	1386 (97.4)
	SS to SS	365 (25.7)	738 (51.9)
Recommended storage of unconverted product	70°F ± 20°F 50% ± 20% RH	21°C ± 11°C 50% ± 20% RH	
Shelf life of unconverted product	Not to exceed 6 months from date of manufacture		

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Product Information Sheet

ARcare® 93020



Note: The information contained on this data sheet is based upon test results of limited quantities of this material and may be modified by Adhesives Research following additional production experience and evaluation. This data should not be used in preparing specifications. Products identified as developmental may be subject to modification by Adhesives Research, Inc.

APPLICATION AND STORAGE OF PRESSURE-SENSITIVE ADHESIVE TAPES

Pressure-sensitive adhesive tapes function as a mechanical product; however, the adhesive itself is a chemical composition that can be sensitive to environmental conditions. A purchaser of pressure-sensitive adhesive products should be aware of the shelf life of each product and not purchase more than it can use before the expiration date. Shipping and storage conditions affect shelf life. The optimum storage temperature is 70 °F (21 °C). Cool, dry storage is recommended.

For best results...

- 1) The surfaces you wish to bond should be clean and free of oil, moisture and dust. If the surface temperature is below 40°F, it may be difficult to achieve a proper bond.
- 2) Do not use a pressure-sensitive adhesive product where it will be exposed to temperatures lower or higher than those designated for each product. Heat can destroy the effectiveness of the bond and extreme cold can cause the adhesive to harden and not adhere properly.
- 3) When the tape is applied, use firm hand or lamination pressure to achieve contact between the adhesive and the surface to which it is applied. Hand rollers or nip rollers may be needed for certain products or applications.

Consult your AR sales representative if you need additional information.

THIS IS NOT AN OFFER

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AR limits the purchaser's remedies in the event of a breach of any warranty. The purchaser's exclusive remedy and AR's obligations for a breach of any warranty shall be as set forth in the Sales Order Acknowledgment.

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