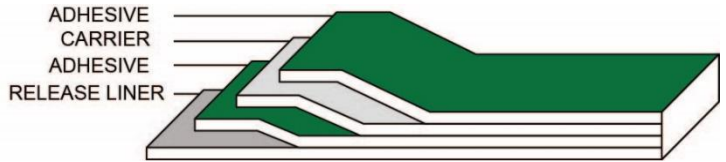


ARclad® 8645-78 is a high performance gray foam tape with acrylic adhesive and a blue polypropylene liner.

PRODUCT APPLICATIONS

The typical use for this product is in the window industry for attaching muntin bars to the exterior glass of the window. This tape can also be used in applications where extruded acrylic foam tapes are overkill for the application, thus saving money while matching the needed performance. Other applications are found in the signage and display markets and transportation applications.



FEATURES AND BENEFITS

- Excellent bond strength to aluminum, glass, wood, polycarbonate & acrylic
- Excellent shear strength
- Good temperature resistance
- FGIA (formerly AAMA) 813-19 certified
- 10 year limited warranty for muntin applications
- Silane coupling agent is not required

Product Construction			
	Typical Values*		Description
Adhesive thickness	2.3 mil	58 µm	AS-181 acrylic adhesive
Foam thickness	42.0 mil	1067 µm	6# gray EVA foam
Adhesive thickness	2.3 mil	58 µm	AS-181 acrylic adhesive
Liner thickness	3.0 mil	76 µm	D/F, blue polypropylene release liner
Total thickness	46.6 mil	1184 µm	(Excluding liner)

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

Product Information Sheet

ARclad® 8645-78



Technical Properties			
Attribute*	Typical Values*		Test Method*
Peel adhesion to Stainless Steel (both sides)	85 oz/inch	23.4 N/25mm	180 degrees, 12 ipm, 60 min. dwell
Static shear to Stainless Steel (both sides)	> 300 minutes		½" x ½", 500 grams
Liner release	70 g/2"		180 degrees, 300 ipm
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 one year from date of manufacture		

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

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

This Product Information sheet ("PI Sheet") is not an offer to sell by Adhesives Research ("AR") and does not contain any binding warranties or terms of sale. While this PI Sheet does contain technical information and general warranty information, this PI Sheet is non-binding and is for information purposes only. If you wish to purchase the product set forth on this PI Sheet ("Product"), or have any questions regarding the warranty or other terms related to this Product, contact AR customer service or a sales representative and they will provide you with AR's terms of sale for the Product in the form of a Sales Order Acknowledgment. AR shall not be bound by any terms or information set forth in this PI Sheet.

DISCLAIMER OF WARRANTIES

AR's warranty on product is limited to the warranty set forth in the Sales Order Acknowledgment. **NOTHING SET FORTH IN THIS PRODUCT INFORMATION SHEET SHALL CONSTITUTE A WARRANTY OF ANY KIND AND EXCEPT AS SET FORTH IN THE SALES ORDER ACKNOWLEDGMENT, AR EXPRESSLY DISCLAIMS ALL WARRANTIES, INCLUDING THE WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.** No provisions, statements, diagrams, drawings or pictures contained in any product literature, price list, catalogue, purchase order, product data sheet, order acknowledgment, invoice, delivery ticket, or any other communication by AR, including information on AR's website or statements made by AR's employees or agents, constitute express warranties. Results of tests and recommendations included in communications of AR do not constitute express warranties. **MANY FACTORS MAY AFFECT THE USE AND PERFORMANCE OF AN AR PRODUCT IN A PARTICULAR APPLICATION, INCLUDING, AMONG OTHERS, THE PRODUCT SELECTED FOR USE, THE CONDITIONS IN WHICH THE PRODUCT IS USED, THE TIME AND ENVIRONMENTAL CONDITIONS IN WHICH THE PRODUCT IS EXPECTED TO PERFORM, THE MATERIALS TO BE USED WITH THE PRODUCT, THE SURFACE PREPARATION OF THOSE MATERIALS, AND THE APPLICATION METHOD FOR THE PRODUCT; THEREFORE, PURCHASER ACCEPTS RESPONSIBILITY FOR DETERMINING WHETHER AR'S PRODUCT IS FIT FOR A PARTICULAR PURPOSE AND SUITABLE FOR PURCHASER'S METHOD OF APPLICATION.** AR retains the right to modify or change its products if in AR's judgment it is advisable.

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.

ARcare®, ARclad®, ARclean®, ARflow®, ARseal®, ARclear® are registered trademarks of Adhesives Research, Inc. Adhesives Research® is a registered service mark of Adhesives Research, Inc. for engineering and design services in the field of pressure-sensitive adhesive systems.

©2006 Adhesives Research, Inc. Printed in USA.

(Revised 10 July 2020)

North America – Headquarters

Adhesives Research, Inc.
400 Seaks Run Road
Glen Rock, PA 17327
Phone: +1 (717) 235-7979
Toll-free: +1 (800) 445-6240
Fax: +1 (717) 235-8320

Europe

Adhesives Research Ireland, Ltd.
Raheen Business Park
Raheen, Limerick
V94 VH22 Ireland
Phone: +353 61 300 300
Fax: +353 61 300 700

China

Adhesives Research China Co., Ltd.
Room 2710-2711, Building B
Far Glory International Square
No. 317 Xianxia Road
Shanghai, China 200051
Phone: +86 (21) 6150 4358
Fax: +86 21 6278 5576

Singapore

Adhesives Research PTE Ltd.
60 Paya Lebar Road
#04-04 Paya Lebar Square
Singapore 409051
Phone: +65 6774 9580
Fax: +65 6777 7261