



Description

Gaska Hi Bond® Adhesive System (GHB™) consists of a solid adhesive mass high performance acrylic adhesive. This adhesive system provides excellent long term holding power. The tape conforms to a wide variety of substrates providing a superior bond.

GHB tapes are well suited for interior and exterior applications

and in many instances can replace rivets, screws, welds and liquid adhesives. GHB tapes are recommended in "laminated glass" systems.

GHB tapes will bond to most dry, clean, oil free surfaces and provide bond strengths along with dynamic shear that is significantly higher than typical pressure sensitive tapes.

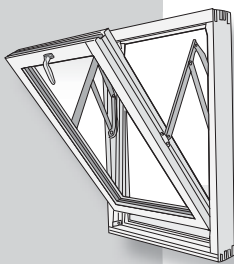
Performance Characteristics

- Designed specifically where an invisible tape is desired.
- High tensile, shear and peel adhesion.
- Moisture/solvent resistant with excellent weathering properties.
- Shock, vibration and noise dampening.
- Ease of application reduces production time and cost.
- Creates permanent dust, light, air and moisture seal.
- Exceptional dynamic shear properties at cold and hot temperatures.

GHB6626CL

Industry Applications

- **Leisure-**
Recreational Vehicles
- **Appliances-**
Refrigerators, Washers, Dryers, Stoves
- **Signs-**
Highway, Traffic, Advertising, Graphics
- **HVAC-**
Air Conditioners
- **Construction-**
Laminated Glass Systems, Glass Assembly
- **Industrial-**
Metal Cabinetry, Trim Attachment, Laminated Glass, Acrylic, Plexiglass and Lexan
- **Clean, ease of use.**
- **Bonds dissimilar materials.**
- **Allows unique designs, with improved appearance.**
- **Proven successful with UVEKOL® laminated glass systems.**
- **Corrosion resistance.**
- **No fixtures, proven durability, weight reduction.**
- **Seals and bonds, vibration and fatigue resistant.**



Gaska Hi Bond® Series

GHB6626CL

Roll Sizes

Available Thicknesses:

.010, .020, .030, .040, .045, .060, .080,
.100, .120" (0.5mm – 3.05mm)

Available Widths:

.010" Thickness: .250" – 17" (6.4 – 431.80mm)
.020" Thickness: .250" – 17" (6.4 – 431.80mm)
.030" Thickness: .250" – 36" (6.4 – 914.40mm)
.040" Thickness: .250" – 36" (6.4 – 914.40mm)
.045" Thickness: .250" – 17" (6.4 – 431.80mm)
.060" Thickness: .250" – 17" (6.4 – 431.80mm)
.100" Thickness: .250" – 17" (6.4 – 431.80mm)
.120" Thickness: .250" – 16" (6.4 – 406.40mm)

Available Lengths:

.010, .020, .030" Thickness: 216' (66M)
.040, .045, .060, .100" Thickness: 108' (33M)
.045, .120" Thickness: 54' (16.46M)

How To Make Gaska Hi Bond® Work

Test Substrate	Always test the substrate before applying GHB for surface energy and contamination. Use the first 4-6" of the roll.
Abrade	This step is only necessary if low surface energy or contamination is present. The grit needed will vary.
Cleaning	High-performance PSA's like GHB should have a clean surface. We recommend a 50/50 mix of IPA and water.
Primer/Promoter	Apply primer when necessary. Recommended for maximum performance.
Applying GHB	Overlap both ends by 2". Temperature Should be 50–110°F
Rolling	Requires a minimum of 15psi pressure.

Time for Curing

20min - 50%
1 Hr. - 75%
1 Day - 90%
3 Day - 100%

Typical Physical Properties

Not for specification purposes.

Test Method	GHB6626CL	
ASTM D-1667 Density	(lbs./cu.ft.)	66
	(kg/m ³)	1060
QA3012 Tensile Adhesion (T block)	(psi)	125
ASTM D-1000 Adhesive Peel	(pli)	6
QA3006 Holding Power (180° Shear)	(psi)	0.5
QA3030 Lap Joint (Dynamic) Shear	(psi)	65
Recommended Service Temperature	(°F)	-20 – 200
	(°C)	-29 – 93
Recommended Application Temperature	(°F)	50 – 110
	(°C)	10 – 45
Oxidation Resistance		Excellent
Weather Resistance		Excellent

Notes:

Substrate surfaces must be clean and dry to insure a good bond. The use of a primer to clean and properly prepare the surface is recommended before using the GHB6626CL product.

(1) Gaska Tape Procedure

Typical performance properties and characteristics are based on samples tested and are not guaranteed for all samples of this product.

Data is intended as a guide only and is presented without guarantees and without assumption of liabilities resultant from the use of information provided. This data is not to be used for specification purposes.

Warranty

Gaska Tape Inc. warrants its product to be free from defects in material and workmanship for a period of one year beginning on the date of purchase, provided the purchaser installs and uses the products according to any instructions provided by Gaska Tape Inc. Any product which fails during the warranty period due to a defect will be replaced.

Upon request, Gaska Tape Inc. will be pleased to provide a copy of its written Limited Warranty with complete details of coverage, conditions and limitations.

Gaska Tape Inc. makes no other warranty, expressed or implied, and specifically disclaims and disavows any implied warranty of merchantability and of fitness for a particular use.



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