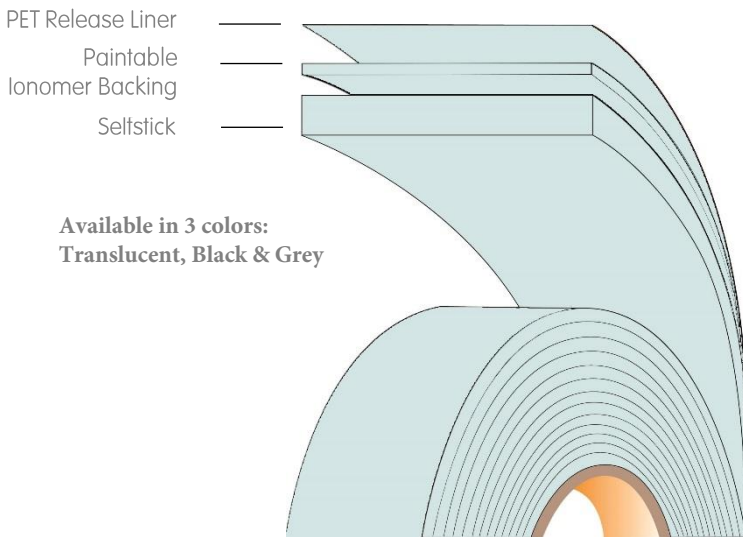


Technical Data Sheet

Extreme Sealing Tape Chem-Set™ 3620B Black

Chem-Set™ 3620B

Chem-Set™ extreme sealing tape is a single sided high performance acrylic based adhesive tape. This conformable tape is especially designed for difficult sealing applications. The ionomer backing on this extreme sealing tape is very tough, flexible, abrasion resistant and paintable. This single-sided tape is neutral translucent and especially designed to seal an existing joint or seam. The adhesive has been designed so that overlapping tape joints can be made while maintaining a strong seal. In combination with a primer this tape guarantees excellent adhesion performance even on low surface energy substrates.



Thickness:	2.0 mm (0.080inch) ±10%
Core:	Closed cell acrylic
Adhesive:	Closed cell acrylic
Density:	900 kg/m ³ (lb/ft ³)
Color:	Transparent, Black, Grey
Liner:	PET Release Liner
Temperature Resistance:	
Minimum	-40°C (-40°F)
Maximum	95°C (°F)

90° Peel Adhesion (Based on ASTM D-3330; various substrates, 72 hour room temp with AFTC SilverTape AM1008HC to attach aluminum peel strip backing; adhesion promoter or primer used on substrates)	N/10mm (lb/in)	128 (12)	ASTM D3330
Tensile Strength	kPa (lb/in ²)	620 / 90	ASTM D3759

Suitable for:

- The tape is and remains soft and flexible, making it easy to mold to contours, edges, rivets, screws used for motorhome leaks, roof and gutter holes/tears, and the transportation industry.

Available sizes:

- jumbo: 900mm x 165 m (76,2mm core)
- log: 900mm x 16.5 / 33m (76,2mm core)
- slit roll: 4 – 250mm x 16.5/33m (76,2mm core)
- spool roll: 5 – 25mm x max 1000 m (152,4mm core)

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Product Information

Surface: Tape bonding is one of the most variable and easy technology mating substrates. Especially for assemblies made of different substrates having different thermal expansion rates bonding is a easy method for a long term durable joint. **Chem-Set™ 3620B tape** allow a high variation in such substrates as all are available in different thickness. To ensure proper performance of such bonded part follow the following recommendations.

Design: A proper tape bond design means avoiding cleavage and peel forces. Design leading to pure shear and tensile loads have to be preferred to utilize full **Chem-Set™ 3620B tape** performance.

Surface Preparation: All bonding process require proper surface preparation / cleaning. This will enable **Chem-Set™ 3620B tape** to get in direct contact with the surface creating full adhesion force. Remove most (polar) contaminations such as fingerprints and light oil. Check suitable cleaner with surface test inks. Use lint free tissues for such operations.

Surface Modification: If simple cleaning cannot achieve appropriate adhesion forces the following surface modifications can be used. All primer / activators should only be used on the area for bonding. Excess material has to be cleaned immediately.

Temperature: After proper surface preparation / modification **Chem-Set™ 3620B tape** should be applied at a temperature level above 18°C (65°F). For temperatures below this but above 0°C (32°F) use low temperature **Chem-Set™ 3620B tape**.

Pressure: Ensure immediate part assembly after liner removal. Pressure should be applied in rolling fashion at approx. 10N/cm². Recommended roller speed at 10 mm/s (24 in./min.). Higher velocities might require higher pressure or control with surface pressure films. **Chem-Set™ 3620B tape** achieve their full strength after 24h at ambient temperature. Higher temperatures can accelerate strength development.

Storage & Shelf Life: Store **Chem-Set™ 3620B tape** between 5° and 35°C (40°-95°F). Humid condition causing condensation should be avoided. For products with non-siliconized liners shelf life is 24 months; products with siliconized liners is 12 months.

Disclaimer: All technical data in this product data sheet are based on Chemical Concepts experiences and external testing. These values are representative for the overall performance. These data sheets are NOT to be used for specification purposes or for your own specific application. It is your responsibility to test whether the tape is suitable for your application or project. Chemical Concepts will NOT be held liable for any information provided on this data sheet. Please follow the rules and regulations that are applicable in the state, county or country where the product(s) are being used. If you have any questions regarding the use of the **3620B tape**, please contact your local sales team. For questions on the standard warranty, please review our terms and conditions.