



Cactus® Double Coated Foam Tape

Technical Data Sheet No. HA421

Product Information

Cactus® Double Coated Foam Tape HA421 is a two-sided heat activated adhesive. The closed side provides high adhesion and shear strength to most unfinished surfaces with its acrylic base, and the open side has glue that is heat activated at the temperature (302°F) 150°C, which by thermal bonding forms a durable, long lasting bond to most rubber, EPDM, PU and PVC-based plastic materials. Has good resistance to solvents, chemicals, UV and heat.

Composition & Physical Properties

Adhesive System	: O/S : HAT C/S : Acrylic	Thickness	: 43 mil (1.0 ± 0.1 mm)
Carrier	: PE Foam	Loop Tack FINAT-9	: Close Side 6.6 lbs/inch or stainless plate 1.54 lbs/inch for PP plate
Foam Density	: 6 PCF	Peel Adhesion PSTC-3	: Close Side 6.6 lbs/inch or stainless plate 2.64 lbs/inch for PP plate
Liner Material	: PE Film	Shear Strength PSTC-7	: Close Side over 72 hrs with 2.2 lbs loading on 1" x 1" on 25mm x 25mm
Liner Thickness	: 3 mil	Heat Resistance	: Close Side -40°F~230°F (-40°C~110°C) Open Side -22°F~248°F (-30°C~120°C)
Liner Color	: Orange	Carrier Color	: Black

Applications

- Bonding of extruded plastic and rubber profiles in a variety of outdoor or indoor industrial products
- Weather strip attachments
- Gasket bonding prior to mechanical fastening

Storage and Shelf Life

For best results, store this product at 72°F (22°C) and 50% relative humidity, use within 2 years from date of receipt.

Disclaimer and Limitation of Liability

In no event shall V. Himark USA and its employees be liable for any direct or indirect, special, incidental or consequential damage resulting from the use of this product. Therefore, it is strongly recommended that the user performs a test application first to determine the suitability of this product for the intended method of application.