



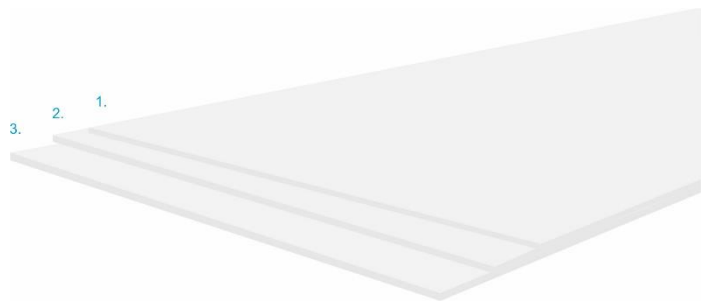
## Technical Data –

# HB6530HA/6550HA/65100HA/6515HA/65200HA

## Thermal Bonding acrylic rubber hybrid pressure sensitive tape.

### Product description

- Can be die-cut
- Impact resistant
- Activated by heat
- Easily removed
- Quick application and bond build strength
- Very high bond strength



### Construction

- Release liner PET 50um
- Adhesive (transparent)
- Release liner PET 25um

### Application

Applications in bonding a wide range of high and low surface energy materials in the electronics industry.

It is used in bonding LCD TVs, smart phones, tablet PCs, digital cameras, and mobile game devices.

### Technical data

Product Name	Adhesive Thickness ( um )
HB-6530HA	30
HB-6550HA	50
HB-65100HA	100
HB-6515HA	150
HB-65200HA	200

### High Performance Tapes and Adhesive Products

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## Shear strength at various temperatures

Temperature (°C)	Pressure (MPa)	Time (SEC)	Adhesive oozing	Adhesive thickness (um)	Shear strength (kgf)
25	0.2	3	N	50	5.4
			N	100	7.2
40	0.2	3	N	50	5.4
			N	100	8.0
100	0.2	3	N	50	5.5
			N	100	8.3
150	0.2	3	Y	50	9.2
			Y	100	12.3
200	0.2	3	Y	50	14.6
			Y	100	19.5

Note :

- Substrates: 1mm thickness Stainless steel Bonding area: 5mm x 5mm
- Mechanical bonding method: both side (up and down plate) heating system.

press each condition → remove heat and pressure → cool for 1min(500g load) → 1hr aging at room temperature

- Bond strength determined using vertical tensile tester at 50mm/min.

## Shear strength at various substrates

Substrate	Adhesive Thickness ( um )	Shear Strength (kgf)
SUS	50	5.5
	100	7.2
Al	50	4.8
	100	6.8
Mg	50	4.3
	100	5.4

Note :

- Substrates: all 1mm thickness Bonding area: 5mm X 5mm
- Bonding conditions: 100°C/0.2MPa/3sec
- Mechanical bonding method : both side(up and down plate) heating system.

press each condition → remove heat and pressure → cool for 1min(500g load) → 1hr aging at room temperature

- Bond strength determined using vertical tensile tester at 50mm/min.

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## Shear strength at various times

Temperature (°C)	Pressure (MPa)	Time (SEC)	Adhesive oozing	Adhesive thickness (um)	Shear strength (kgf)
100	0.2	3	N	100	8.3
100	0.2	6	Y	100	9.2
100	0.2	9	Y	100	11.4
100	0.2	15	Y	100	13.3

Note :

- Substrates: 1mm thickness Stainless steel Bonding area: 5mm x 5mm
- Mechanical bonding method: both side (up and down plate) heating system.

press each condition → remove heat and pressure → cool for 1min(500g load) → 1hr aging at room temperature

- Bond strength determined using instron tester at 50mm/min.

## Shear strength at various pressure

Temperature (°C)	Pressure (MPa)	Time (SEC)	Adhesive oozing	Adhesive thickness (um)	Shear strength (kgf)
100	0.2	3	N	50	5.5
			N	100	8.3
100	0.4	3	y	50	7.9
			y	100	10.2
100	0.6	3	y	50	9.3
			y	100	12.4

Note

- Substrates: 1mm thickness Stainless steel Bonding area: 5mm X 5mm
- Mechanical bonding method: both side (up and down plate) heating system.

press each condition → remove heat and pressure → cool for 1min(500g load) → 1hr aging at room temperature

- Bond strength determined using vertical tensile tester at 50mm/min.

## 180° peel adhesion at various substrates

Substrate	HB 6100HA	HB 6200HA
PC	4.1 kgf/inch	4.7 kgf/inch
SUS	4.3 kgf/inch	5.4 kgf/inch

Note : • PET# 25 backing • measured at room temperature

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## 180° peel adhesion at various temperatures

Temperature (°C)	1hr dwell	24hrs dwell
25		4.2 kfg/inch
40	-	3.1 kgf/inch
60	-	2.0 kgf/inch
80		0.95 kgf/inch
100	-	0.6 kgf/inch

Note : • Substrate : stainless steel • PET#25 backing

## Holding power

		500g load	1kg load
Creep length (mm)	1hr	-	No creep
	24hr	No creep	-

Note: • Substrate: stainless steel • Attached size: 25mm x 25mm, PET#25 backing • Temperature: 85°C

## Note

Unless stated otherwise all values given are average. All of the tapes in our range should be thoroughly tested on the substrates in the particular application they are intended for. Hi-Bond Tapes Ltd. will not be responsible for product failure unless full testing has been completed. The customer has to decide on the tapes suitability for the intended application.



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