



ForzaTM

TAPE

A FORCE TO BE RECKONED WITH

Transportation

T-T420



Double-Coated Ultra High Bond Acrylic Foam Tape



ForzaTAPE® T-T420 is an ultra-high bond double-coated acrylic foam tape for demanding applications.

Benefits

- Good initial tack
- High performance bond
- Conformable
- Easy to die-cut
- Unique visco-elastic nature ensures a strong bond which can absorb shocks and stress
- .062in thick
- Long-lasting bond for indoor and outdoor applications
- The adhesives have an excellent solvent plasticizer, and moisture resistance
- Slitted on request
- 100% closed cell structure

Product Application

- Ensure substrate is clean and dry and free from dust, dirt, oil, wax, or silicone.
- Apply to part to be bonded, ensuring that no air is trapped between the tape and the substrate.
- Apply adequate pressure using a J roller.
- Apply with recommended application pressure of 15 pounds per inch of tape width.
- Apply with care to avoid wrinkles or trapped air.
- During application, for optimal performance, surface temperatures should be near comfortable room temperature.

Refer to surface preparation guidelines

Applications

ForzaTAPE® T-T420 is specially designed for bonding and mounting to a wide range of substrates, including aluminum, stainless steel, composites, plastics, acrylics, and ABS plastic in the commercial vehicle market. Applications include:

- Panel attachment in trailers, truck bodies, ambulances, RVs, buses, and emergency vehicles
- Panel attachments where overlaps occur
- Bonding roof panels to roof bows

Property	Value	Methods
90° Peel Adhesion, Initial, Stainless, 20min Dwell	33 psi	ASTM D3330
90° Peel Adhesion, Final, Stainless, 72hr Dwell	62 psi	ASTM D3330
Static shear (68°F / 20°C)	52 oz	ASTM D3654
Static Shear (194°F / 90°C)	8.8 oz	ASTM D3654
Dynamic Shear	63 psi	ASTM D1002
Minimum long term temp	-40°C	Internal Method
Maximum long term temp	302°F / 150°C	Internal Method
Maximum short term temp	392°F / 200°C	Internal Method
Density	39lbs/ft³	Internal Method

Sizes

1/2" x 108 ft	1.0" x 108 ft
1/4" x 108 ft	1 1/2" x 108 ft
3/4" x 108 ft	3/8" x 108 ft

CREATING INDUSTRIAL ADHESIVE, TAPE AND SEALANT SOLUTIONS THAT OUTPERFORM

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Surface Preparation Guidelines

Proper surface preparation is essential to achieving a strong bond when using Forza tape products. Depending on the substrates to be bonded, one of the following preparation methods may be required.

01. Clean Only: Clean the surface using a 50:50 mixture of isopropyl alcohol (IPA) and water (50–70% IPA) to remove contaminants.
02. Abrade + Clean: Lightly abrade the surface to improve adhesion, followed by cleaning with an IPA/water mixture.
03. Clean + Adhesion Promoter or Primer: Clean the surface with an IPA/water mixture, then apply an appropriate adhesion promoter or primer (e.g., ForzaBOND™ Adhesion Enhancer).
04. Abrade + Clean + Adhesion Promoter or primer: Lightly abrade the surface, clean with an IPA/water mixture, and then apply an adhesion promoter or primer (e.g., ForzaBOND™ Adhesion Enhancer).

Application Temperature and Bond Strength

Recommended Application Temperature:

Apply at temperatures between 60°F and 100°F (15°C to 38°C) for optimal results.

- Application below 60°F (15°C) may require enhanced surface preparation (methods 3 or 4) to ensure proper bonding.
- Pressure-sensitive adhesives rely on viscous flow to achieve maximum contact with the substrate. Applying firm, even pressure during installation enhances adhesive-to-surface contact and improves bond strength.
- A minimum of 15 psi (100 kPa) is recommended for effective bonding. For best results, use a dense laminate roller (e.g., Beno J. Gundlach V300-SB) to apply 15 pounds (67 N) of downward force, facilitating optimal adhesive wet-out on the prepared surface.

Additional Information

Forza offers comprehensive guidance on surface preparation and bonding at low temperatures. Please contact Forza technical support for detailed instructions and product recommendations.

Please Note:

Follow manufacturer guidelines and safety precautions when using cleaning solvents.

Ensure compliance with local and state air quality regulations before using any materials during cleaning and surface preparation.

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