



# Forza™

## TAPE

A FORCE TO BE RECKONED WITH

### Transportation

# T-T415



## Ultra High Bond Acrylic Foam Tape



**ForzaTape® T-T415** 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
- .045in 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-T415** 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	30 psi	ASTM D3330
90° Peel Adhesion, Final, Stainless, 72hr Dwell	56 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	70 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	39 lb/sq³	Internal Method

#### Sizes

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