

# ARclad<sup>®</sup> 8645-78

## Muntin Mounting Tape



### PRODUCT DESCRIPTION

ARclad<sup>®</sup> 8645-78 is the next generation of high performance muntin mounting tapes from Adhesives Research. ARclad<sup>®</sup> 8645-78 has been specifically developed for the rigorous demands of the muntin mounting application. This new tape combines advancements in adhesive technology with years of industry knowledge to provide window manufacturers with exceptional performance that meets or exceeds industry standards.

### FEATURES

- High performance acrylic adhesive system
- 45 mil closed cell polyethylene foam construction
- 3 mil blue poly liner

### BENEFITS – The ARclad<sup>®</sup> Advantage

When applied in accordance with ARclad<sup>®</sup> application guidelines:

- Exceptional adhesion to the broad range of substrates commonly used across the industry without the need for abrasion or other surface treatments
- Optimum balance of performance properties which resist the forces that work to pull the grille away from the sash:
  - Variances in expansion and contraction rates of the grille substrates vs. the glass
  - Use of the grille to raise and lower the window
- Co-extruded smooth coat foam allows superior wet-out of the tape to the glass surface, ensuring a watertight bond
- Custom-developed adhesive polymer which resists
  - Temperature extremes
  - High humidity
  - UV degradation
  - Cleaning solutions\*
- Silane coupling agent is not required – eliminating the cost, risk, resources and time associated with silane use
- 10-year limited warranty

\*Ammonia or alcohol-based cleaners are recommended. Citrus oil cleaners and muriatic acid brick treatment should be avoided with ARclad<sup>®</sup> 8645-78 and any other adhesive product.

### PRODUCT APPLICATIONS

Simulated Divided Light (SDL) grilles. Users should assure the product meets the specific needs of their application(s). Adhesives Research can tailor the product to meet the needs of specific applications as requested by customers.

### PRODUCT PROFILE AND DIAGRAM

3 mil D/F Siliconized Polypropylene Liner  
 High Performance Acrylic Adhesive  
 Smooth Coat 45 mil Gray PE Foam  
 High Performance Acrylic Adhesive



### ADHESIVE PERFORMANCE PROPERTIES – Typical Values\*

Test Performed	Dwell Time	Condition/Rate	Typical Values	Test Methods
180° Peel Adhesion**	72 hours	12 ipm	>125 oz/in	PSTC-101, ASTM D-3330, ART 1005
500g Static Shear, 1/2" x 1/2"***	72 hours	150°F	>24 hours	PSTC-107, ASTM D-3654, ART 1011
500g Static Shear, 1/2" x 1/2"***	72 hours	100°F/95% RH	>24 hours	PSTC-107, ASTM D-3654, ART 1011
Dynamic Shear***	72 hours	0.1 ipm	>55 lbs/in <sup>2</sup>	ASTM D-1002, DART 3027
Dynamic Z-Tensile***	72 hours	0.1 ipm	<55 lbs/in <sup>2</sup>	ASTM D-897, DART 3020

**\*All stated values are nominal and should only be used as a guide for selection. They are not specifications.**

\*\*Substrates Tested: Polystyrene (filled), Glass, Painted Aluminum, Unprimed Wood, Fiberglass

\*\*\*Substrates Tested: Aluminum Muntin bars to untreated glass

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### STORAGE AND SHELF LIFE

Unconverted product should be stored at 70°F ± 20°F (21°C ± 11°C) and 50% ± 20% relative humidity, out of direct sunlight. The shelf life of the product is not to exceed one year from date of manufacture.

### ROLL SIZE AVAILABILITY

Coated material yields 54" width. Material can be slit to order. Standard widths from 0.5" to 54.0". Standard slitting tolerance: +/- 1/32". Tighter slitting tolerance may be available on request.

Standard roll length 216 ft. to 500 ft.

Note: The information contained on this data sheet is based upon test results of limited quantities of this material and may be modified by Adhesives Research following additional production experience and evaluation. This data should not be used in preparing specifications. Products identified as developmental may be subject to modification by Adhesives Research, Inc.

(Revised 30 April 2014)

#### **APPLICATION AND STORAGE OF PRESSURE-SENSITIVE ADHESIVE TAPES**

Pressure-sensitive adhesive tapes function as a mechanical product; however, the adhesive itself is a chemical composition that can be sensitive to environmental conditions. A purchaser of pressure-sensitive adhesive products should be aware of the shelf life of each product and not purchase more than it can use before the expiration date. Shipping and storage conditions affect shelf life. The optimum storage temperature is 70°F (21°C). Cool, dry storage is recommended.

#### **For best results...**

- 1) The surfaces you wish to bond should be clean and free of oil, moisture and dust. If the surface temperature is below 40°F, it may be difficult to achieve a proper bond.
- 2) Do not use a pressure-sensitive adhesive product where it will be exposed to temperatures lower or higher than those designated for each product. Heat can destroy the effectiveness of the bond and extreme cold can cause the adhesive to harden and not adhere properly.
- 3) When the tape is applied, use firm hand or lamination pressure to achieve contact between the adhesive and the surface to which it is applied. Hand rollers or nip rollers may be needed for certain products or applications.

Consult your Adhesives Research sales representative if you need additional information.

#### **THIS IS NOT AN OFFER**

This Product Information sheet ("PI Sheet") is not an offer to sell by Adhesives Research ("AR") and does not contain any binding warranties or terms of sale. While this PI Sheet does contain technical information and general warranty information, this PI Sheet is non-binding and is for information purposes only. If you wish to purchase the product set forth on this PI Sheet ("Product"), or have any questions regarding the warranty or other terms related to this Product, contact AR customer service or a sales representative and they will provide you with AR's terms of sale for the Product in the form of a Sales Order Acknowledgment. AR shall not be bound by any terms or information set forth in this PI Sheet.

#### **DISCLAIMER OF WARRANTIES**

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AR limits the purchaser's remedies in the event of a breach of any warranty. The purchaser's exclusive remedy and AR's obligations for a breach of any warranty shall be as set forth in the Sales Order Acknowledgment.

ARclad<sup>®</sup> is a registered trademark of Adhesives Research, Inc. Adhesives Research<sup>®</sup> is a registered service mark of Adhesives Research, Inc. for engineering and design services in the field of pressure-sensitive adhesive systems.

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Internet: [www.adhesivesresearch.com](http://www.adhesivesresearch.com)

**Adhesives Research, Inc.**  
400 Seaks Run Road, P.O. Box 100  
Glen Rock, PA 17327 USA  
Toll-free: 800-445-6240  
Phone: 717-235-7979  
Fax: 717-235-8320

**Adhesives Research Ireland Ltd.**  
Raheen Business Park  
Raheen, Limerick  
V94 VH22 Ireland  
Phone: +353 61 300 300  
Fax: +353 61 300 700

**Adhesives Research Ltd.**  
United Kingdom  
Phone: +44 (0)1371 878187

**Adhesives Research Pte. Ltd.**  
60 Paya Lebar Road  
#04-04 Paya Lebar Square  
Singapore 409051  
Phone: +65 6774 9580  
Fax: +65 6777 7261

**Adhesives Research China Co., Ltd.**  
703B Xin Da Mansion  
#322 Xian Xia Road  
Shanghai 200335, China  
Phone: +86 21 6150 4358  
Fax: +86 21 6278 5576