



### DESCRIPTION

Gaska Hi Bond Adhesive (GHB<sup>®</sup>) is a high performance acrylic adhesive system. GHB4526BK is a gray foamed acrylic core that is coated on both sides with a black high performance acrylic adhesive. This strong closed cell foamed core conforms to a wide variety of substrates providing a superior bond.

GHB<sup>®</sup> tapes are well suited for interior and exterior applications and in many instances can replace rivets, screws, welds and liquid adhesives. GHB<sup>®</sup> tapes will bond to most dry, clean, oil free surfaces. It provides bond strengths along with dynamic shear that is significantly higher than typical pressure sensitive tapes.

### ROLL SIZES

Available Thicknesses:  
.025", .045", .063" (.635mm – 1.6mm)

Available Widths:  
.025" Thickness: .250" – 17" (6.4mm – 431.8mm)  
.045" Thickness: .250" – 36" (6.4mm – 914.4mm)  
.063" Thickness: .250" – 17" (6.4mm – 431.8mm)

Available Lengths:  
.025" Thickness: 216' (66m) Red PE Liner  
.045" Thickness: 108' (33m) Red PE Liner  
.063" Thickness: 108' (33m) Red PE Liner

### PERFORMANCE CHARACTERISTICS

- Designed specifically to bond to high energy surfaces, but will work with low energy surfaces.
- Corrosion resistant.
- No fixtures, proven durability, and weight reduction.
- High tensile, shear and peel adhesion.
- Moisture/solvent resistant with excellent weathering properties.
- Shock, vibration and noise dampening.
- Ease of application reduces production time and cost.
- Creates permanent dust, light, air and moisture seal.

### HOW TO MAKE GASKA HI BOND WORK

|                                 |  |
|---------------------------------|--|
| <b>Test Substrate</b>           | Before applying GHB <sup>®</sup> , always test the substrate for surface energy and contamination. Use the first 4-6" of the roll. |
| <b>Abrade</b>                   | This step is only necessary if low surface energy or contamination is present. The grit needed will vary.                          |
| <b>Cleaning</b>                 | High-performance PSA's like GHB <sup>®</sup> should have a clean surface. We recommend a 50/50 mix of IPA and water.               |
| <b>Primer Promoter</b>          | Apply primer when necessary. Recommended for maximum performance.  |
| <b>Applying GHB<sup>®</sup></b> | Overlap both ends by 2". Temperature should be 50-110°F.   |
| <b>Rolling</b>                  | Requires a minimum of 15 psi pressure.   |

**Time for Curing**

|         |      |
|---------|------|
| 20 min. | 50%  |
| 1 hr.   | 75%  |
| 1 day   | 90%  |
| 3 days  | 100% |

\*Quote can be provided upon request for the Adhesion Promoter.\*

| Test Method- Typical Physical Properties                | GHB4526BK   |
|---|---|
| ASTM D-1667 <b>Density</b>                              | <b>46 lbs/ft<sup>3</sup></b><br><b>740 kg/m<sup>3</sup></b> |
| QA3012 <sup>(1)</sup> <b>Tensile Adhesion (T block)</b> | <b>130 psi</b>  |
| ASTM D-1000 <b>Peel Adhesion</b>                        | <b>12 lbs / linear inch</b>                                 |
| QA3006 <sup>(1)</sup> <b>Holding Power (180° Shear)</b> | <b>1.0 psi</b>  |
| QA3006 <sup>(1)</sup> <b>Lap Joint (Dynamic) Shear</b>  | <b>120 psi</b>  |
| <b>Recommended Service Temperature</b>                  | <b>-31 - 180 °F</b><br><b>-35 - 82 °C</b>                   |
| <b>Recommended Application Temperature</b>              | <b>50 - 110 °F</b><br><b>10 - 45 °C</b>                     |

(1) Gaska Tape Procedure

Data is intended as a guide only and is presented without guarantees and without assumption of liabilities resultant from the use of information provided. This data is not to be used for specification purposes.

### WARRANTY

Gaska Tape Inc.<sup>®</sup> warrants its product to be free from defects in material and workmanship for a period of twelve (12) months beginning on the date of invoice, provided the purchaser installs and uses the products according to any instructions provided by Gaska Tape Inc. Any product which fails during the warranty period due to a defect will be replaced.

Upon request, Gaska Tape Inc.<sup>®</sup> will provide a copy of its written Limited Warranty with complete details of coverage, conditions and limitations.

Gaska Tape Inc.<sup>®</sup> makes no other warranty, expressed or implied, and specifically disclaims and disavows any implied warranty of merchantability and of fitness for a particular use.