

# HEAT ACTIVATED ADHESIVE TAPE HN-HA1120G

## TECHNICAL DATA SHEET

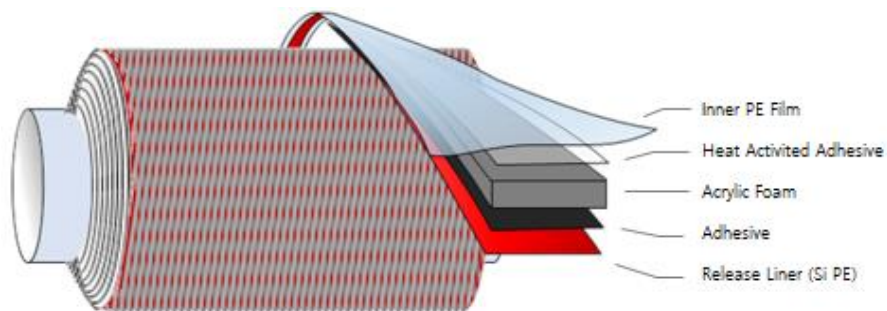
### Description

HN-HA1120G tape is a gray color and has a very conformable adhesive foam system. The base form is manufactured by UV curing, so it has properties excellent heat resistance and weather resistance. It has excellent adhesion to various panels under various environmental conditions, so it is widely used for general purpose, such as fixing parts or exterior parts of automobiles.

In addition, HN-HA1120G Tapes offer the following key features:

- Excellent adhesion to PP or PP+EPDM panels of LSE-type.
- Excellent initial adhesion.
- Excellent in long-term reliability tests and vibration and impact properties.
- It is possible to prevent the inflow of foreign substances, leakage and noise.

### Product Construction



### Physical Properties

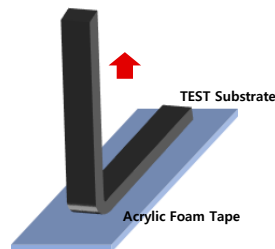
HN-HA1120G		
Thickness	1.20mm (0.047 in)	Range ±0.12mm (0.005 in)
Rolls length	Min 1.5m, Max 300m	
Spool length	900m based on 10mm width	
Width	- ± 0.4mm for rolls up to 20mm wide rolls. - ± 0.8mm for planetary rolls wider than 20mm	
LINER Type	CP, PE, PET Liner (Contact your sales representative.)	
Order	Minimum 1000SQM or more. (For OEM, please contact the person in charge)	

## HEAT ACTIVATED ADHESIVE TAPE HN-HA1120G

<b>Thickness</b>	Thickness Gauge 0.01mm (Unit : mm)	1.20
<b>Carrier</b>	—	Acrylic Foam
<b>Color</b>	—	gray
<b>Roll Width</b>	mm	4 ~ 16
<b>Roll Length</b>	M	66 ~ 900

### 90°Peel Adhesion

Jaw speed is 300mm/min  
(Unit : kgf/cm)

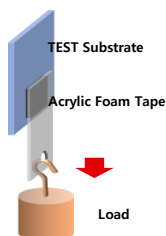


STS-304 - 30 minutes      2.40

STS-304 - 72 hours      2.80

### Static Shear

Sample Size: 25mm x 25mm  
Test condition: 80°C  
Test Load: 1kg  
(Unit : hr)



STS-304      24

### TEST Reference

The test method was measured by referring to KS T 1028 and ASTM regulations. Product data may vary depending on the composition of the test plate and the surface condition. Therefore, please refer to the above data as it does not represent the standard of the product.



### TAPE Guidelines

The following are recommended for successful tape applications:

- **Clean surface.** Cleanness of the tape surface can affect the adhesion. Clean the surface with isopropyl alcohol or petroleum ether, after drying completely and then attach.
- **Appropriate pressurization.** Pressure is needed to provide intimate contact between the tape and bonding surface. Recommends 15 psi momentary pressure on the bond line. This is a guideline and required pressure
- **Avoid air entrapment.** Apply pressure evenly from one end to the other to prevent air bubbles from entering the tape.
- **Avoid excessive tape stretch.** During tape application, do not exceed 4% stretch. Stretch can be influenced by tension, speed and roller diameter.
- **Appropriate temperature.** Ideal working temperature is 20~27deg °C for attaching or processing tape, Store tape under 15~27deg °C cool and dark place.

### Shelf Life

Two years from date of manufacture when stored at 10°C~38°C and 95% relative humidity or less.

Optimum storage conditions are 22°C and 50% relative humidity.

### Regulatory Information

Please refer to the product label and Safety Data Sheet (MSDS) for health and safety information before using. Observe proper handling precautions as outlined in the SDS, which is available on request.

### Contact Information

The information provided in this technical document is intended as a guide for this product. For more information or help in selecting a Hannam product for an application, please contact your responsible sales or call product application support at +82-41-881-0331.

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