



# HPA 1931

Avery Dennison<sup>TM</sup> HPA 1931 is a single lined transfer tape specifically developed for heavy duty bonding applications requiring a high shear performance and/or moisture, chemical, UV or temperature resistance

## FEATURES:

- Cross-linked acrylic adhesive
- Cohesive adhesive layer
- Polyethylene protected liner
- Easy release liner

## BENEFITS:

- Provides a very high temperature resistance and a high chemical, moisture and UV-light resistance
- Facilitates slitting and conversion
- Combines a high degree of moisture stability with excellent die-cutting properties
- Enables smooth removal during application



## CONSTRUCTION:

### Adhesive:

Cross-linked acrylic adhesive

### Liner:

PEK liner with red Avery Dennison imprinted logo

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Adhesive Properties	Typical Values		
	US Mils	mm	Microns (µm)
THICKNESS			
Adhesive	1.06	0.027	27
Liner	4.53	0.115	115
Total	5.59	0.142	142

\*PSTC-133

### PEEL ADHESION

2 mil PET; 90°; 12" / min; 50µm Al

Substrate	Lbf / in		N / 25mm	
	20 min	24 hr	20 min	24 hr
Stainless steel	2.5	2.7	11	12
Polypropylene	2.0	2.0	9	9

\*PSTC-101, ASTM D-3330, STD-10

### LOOP TACK

2 mil PET; 90°; 20" / min; 1" sq (6.5 cm<sup>2</sup>)

Substrate	Lbf / in		N / 25mm	
Stainless steel	3.6		16	

\*PSTC-16, STD-7

### STATIC SHEAR

Foil; 1" sq (6.5 cm<sup>2</sup>); 1000 g

#### Min to Fail

>10,000 min

\*PSTC-107, ASTM D 3654, STD-9

### TEMPERATURES

Min. Application Temp.	50 ° F	10 ° C
Max. Continuous Operating Temp.	400 ° F	204 ° C
Max. Intermittent Operating Temp.	450 ° F	232 ° C

\*TEST METHODS

Note: The listed values are typical only and not intended to serve as product specifications

## APPLICATION TECHNIQUES

- It is essential with all pressure-sensitive tapes the application surface is clean, dry and free of grease and oil
- Bond strength is dependent upon the amount of adhesive-to-surface contact developed
- Note that different pressure, time and temperature on different (firm / rigid) surface achieves different performance

## STORAGE AND SHELF LIFE

The shelf life of the product is two years when stored at 18-22°C / 64-72°F, 30-70% relative humidity and out of direct sunlight, in original packaging.

Please refer to [Tapes.AveryDennison.com](http://Tapes.AveryDennison.com) for complete terms and conditions, including warranty terms, relating to this product. You should periodically review the site as terms and conditions are subject to change without notice.

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