# Adhesive solutions for powder coating operations

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Over the years, within the industrial painting market, BMP has been able to test and select the best range of special solutions fulfilling all the most critical applications during the powder coating process.
Whatever the kind of masking adhesive tape required, we can offer the most suitable solutions from a wide range of products made with different carriers (polyester, polyimide, paper or glass cloth) and adhesives (silicone or natural rubber) to achieve the right result. Our selection of masking tapes guarantees:

- outstanding temperature resistance,
- bonding on different substrates,
- conformability and flexibility,
- easy and clean removal.

At the same time, in this brochure, beyond our most popular masking adhesive tapes, you can find a short list of products we can recommend as complementary solutions to be used also as bonding solutions during pre and post powder coating process.

## Pre-powder coat bonding solutions

| PRODUCT | CARRIER/ ADHESIVE | THICKNESS (µm) | PEEL ADHESION (N/25mm) | OPERATING TEMPERATURE | APPLICATIONS | FEATURES |
|---|---|---|---|---|---|---|
| 3M™ VHB™ GPH - 060 | Acrylic foam/ Acrylic | 600 | 62.5 | + 150 °C (+ 230 °C short time) | Bonding metal to metal before passing through the powder coat painting process. Panel fixation, metal stiffener and reinforcement bar bonding. | Foam density: 710 Kg/m³. Grey colour. 3M™ red polyethylene liner. |
| 3M™ VHB™ GPH -110 | Acrylic foam/ Acrylic | 1100 | 92.5 | + 150 °C (+ 230 °C short time) | Bonding metal to metal before passing through the powder coat painting process. Panel fixation, metal stiffener and reinforcement bar bonding. | Foam density: 710 Kg/m³. Grey colour. 3M™ red polyethylene liner. |
| 3M™ VHB™ GPH - 160 | Acrylic foam/ Acrylic | 1600 | 85 | + 150 °C (+ 230 °C short time) | Bonding metal to metal before passing through the powder coat painting process. Panel fixation, metal stiffener and reinforcement bar bonding. | Foam density: 710 Kg/m³. Grey colour. 3M™ red polyethylene liner. |

| PRODUCT | DESCRIPTION AND FEATURES |
|---|---|
| 3M™ Scotch-Weld™ DP8805NS | High performance, two-part acrylic adhesive that offers excellent shear, peel, and impact performance. It provides improved adhesion to many plastics and metals, including those with slightly oily surfaces. This adhesive features a fast rate of strength build, providing structural strength in minutes. Its low odor and non-flammability features also make it easier to incorporate into a manufacturing process. Time to Handling Strength: 7 minutes. Structural Strength: 10 minutes. |
| 3M™ Scotch-Weld™ DP8405NS | High performance, two-part acrylic adhesive offering excellent shear, peel, and impact performance. This toughened product provides improved adhesion to many plastics and metals, including those with slightly oily surfaces. This durable product features a fast rate of strength build, providing structural strength in minutes. Time to Handling Strength: 15 minutes. Structural Strength: 20 minutes. |

## Masking solutions

| PRODUCT | CARRIER/ ADHESIVE | THICKNESS (µm) | PEEL ADHESION (N/25mm) | OPERATING TEMPERATURE | APPLICATIONS | FEATURES |
|---|---|---|---|---|---|---|
| 4341 | Crepe paper/ Natural rubber | 190 | 11.75 | Up to + 140 °C | Professional masking applications | Suitable for sensitive surfaces. Good flexibility for curves. |
| CSIL 1100 HT | Crepe paper/ silicone | 145 | 7.5 | + 180 °C (+ 220 °C short time) | High temperature masking applications. Powder coating operations. | Good adhesion on a variety of substrates. Clean removal. |
| HOP40 | PET/ Siliconico | 60 | 7.5 | + 130 °C (+ 200 °C short time) | High temperature masking applications. Powder coating operations. | Clean removal. Green colour. |
| INTERTAPE | Polyester/ Silicone | 80 | 10.9 | Up to + 180 °C | High temperature masking applications as in powder coating and PCB protective masking. | Clean removal. Precision cut for tear resistance and clean, crisp paint lines. Green colour. |
| 8SL | Polyester/ Silicone | 100 | 3.25 | + 130 °C (+ 200 °C short time) | High temperature masking applications. Powder coating operations. | Excellent initial tack. Clean removal. Brown colour. |
| ML271 | Polyimide /Silicone | 60 | 5.75 | + 180 °C (+ 260 °C short time) | Very high temperature masking applications. | Flame retardant. Amber colour. |
| FIBER170 | Glass cloth/ Silicone | 165 | 5.5 | + 180 °C (+ 280 °C short time) | Outstanding temperature masking applications. | High tack. Good flexibility for curves. Clean removal. White colour. |

## Post powder coat bonding solutions

| PRODUCT | CARRIER/ ADHESIVE | THICKNESS (µm) | PEEL ADHESION (N/25mm) | OPERATING TEMPERATURE | APPLICATIONS | FEATURES |
|---|---|---|---|---|---|---|
| 5952 | Acrylic foam/ Acrylic | 1100 | 8.5 | + 120 °C (+ 150 °C short time) | Adheres to powder coated surfaces usually without the need for specialist surface preparation including priming or abrading. | Foam density: 590 Kg/m³. Black colour. Red polyethylene liner. |

| PRODUCT | DESCRIPTION AND FEATURES |
|---|---|
| 3M™ Scotch-Weld™ DP8405NS | High performance, two-part acrylic adhesive offering excellent shear, peel, and impact performance. This toughened product provides improved adhesion to many plastics and metals, including those with slightly oily surfaces. This durable product features a fast rate of strength build, providing structural strength in minutes. Time to Handling Strength: 15 minutes. Structural Strength: 20 minutes. |
| 3M™ Scotch-Weld™ DP620NS | Black, rapid setting, two-component polyurethane. It is packaged as 1:1 ratio liquids in a duo-pack cartridge. With the squeeze of the trigger, the components are automatically mixed and easily dispensed as a bubble-free non-sag paste. Best gap filling. Low temperature flexibility. |

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we work in Team

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