



ADCOBOND® D18-221

ADCOBOND® D18-221 tapes are a group of high performance, butyl, pressure sensitive tapes that are black in color. The material is extruded to conform to either round or flat profiles with specified dimensional tolerances. Unless otherwise specified the material is protected on one side with a removable release liner.

Thickness ranges from 0.5mm to 12mm (0.020in to 0.47in)

Width ranges from 4mm to 305mm (0.16in to 12in)

Technology / Base	Butyl
Type of Product	High Performance Tape
Appearance / Color	Black
Consistency	Tape

Features and Benefits

- Excellent sealing properties
- Good adhesion to polar surfaces (ABS, acrylic, aluminum, glass, painted and steel substrates)
- Good adhesion to non-polar surfaces (EPDM, polyethylene, polypropylene and TPO substrates)
- Exceptional performance in low temperature environments
- Good heat resistance and moderate strength for bonding applications

Technical Data

Property	Typical Value	Test Method
Specific Gravity	1.1	ASTM D71
Cone Penetration	85 dmm	ASTM D217, 150g added Load
Elongation	800%	ASTM D412, Die C
Tensile Strength	80 kPa	ASTM D412, Die C
Peel Adhesion	2 N/mm	FLTM BU 112-02, Method A
Adhesive Strength	1.5 N/mm	FLTM BU 112-02, Method C
Yield Strength	41 kPa	Chrysler LP463CB-10-01
Creep Resistance	1.5 mm	GM9758P
Cold Shock Resistance	Passes 10 slams @ -29°C (-20°F)	GM9773P
Fogging Resistance	80	SAE J1756
Burn Rate	0.99 in/min	FMVSS 302
Service Temperature Range	-40°C to 88°C (-40°F to 190°F)	



Typical Applications

- Automotive weather strip attachment - door and trunk
- Automotive die cut profiles for weather strip and polystyrene foam inner panel door stiffeners attachment
- Adhesive for traffic and pedestrian markers
- Assembly aid – temporarily fixtures components
- General purpose joint sealing against air, dust and moisture infiltration

Specifications

Meets requirements of:

Chrysler	MS-CC-257, MS-CD-610 MS-CD-641 Type A
Ford	WSB-M3G210-A
General Motors	9984192 9985636 9985882 GMW15410
Nissan	NES M 8505
Toyota	TSM-1712G

Typical Packaging

Contact your H.B. Fuller representative for specific sizes.

Storage and Shelf Life

Store material in original unopened packaging at temperatures between 20°C to 50°C (68°F to 120°F). Shelf life is 24 months when stored as recommended.

Safety and Disposal

Prior to working with this or any product consult product label and Safety Data Sheet (SDS) for necessary health and safety precautions and disposal considerations.

General Instructions

Materials vary so evaluation of the specific substrate to be adhered to is recommended prior to use.

The substrate to be bonded should be cleaned with an appropriate solvent, preferably IPA (Isopropanol) no more than 15 minutes prior to bonding of a ADCOBOND® D18-221 adhesive backed part. To ensure removal of all contaminants without leaving any residue, use a clean, lint-free wiping cloth (never recycled rags). Other solvents such as hexane, heptane or methanol may be suitable for cleaning various substrates after thorough evaluation. The substrate must be thoroughly dry before bonding ADCOBOND® D18-221 adhesive backed parts. Ensure optimum substrate temperature, never below 10°C (50°F) at application time. Store ADCOBOND® D18-221 adhesive backed parts to be bonded at no less than room temperature to avoid moisture condensation on D18-221's surface.

Remove the protective release liner from the ADCOBOND® D18-221 tape immediately prior to application, being careful not to contaminate the ADCOBOND® D18-221 adhesive. Apply the part without entrapping air between the tape and the substrate with a recommended minimum application pressure of 15 pounds per inch of tape width to achieve adhesive to substrate contact and maximum bond strength.

Ensure optimum application temperature of 10°C to 49°C (50°F to 120°F).

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