



Adhesive Tape Systems
For Sign and Display Markets











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Located just outside of Berlin in the heart of Europe, the ORAFOL Europe GmbH headquarters is the hub of the organization's culture of leadership and excellence.



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Adhesive Tape Systems For Sign and Display Markets

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Sign & Display Applications

Bonding A frame signs

Fixing box signs - panels to frames

Large panel signs

Bonding clear polycarbonate
for illuminated signs

Fixing housings and light units
in emergency signs

Name plate bonding

Bonding plate signs

Fixing individual letter signs

Point of sale bonding

Construction of obelisk signs

Fixing LED strip lights

Road Traffic Signs

Dot matrix signs

Frame bonding for digital signs



ORABOND™

High Performance Adhesive Tapes

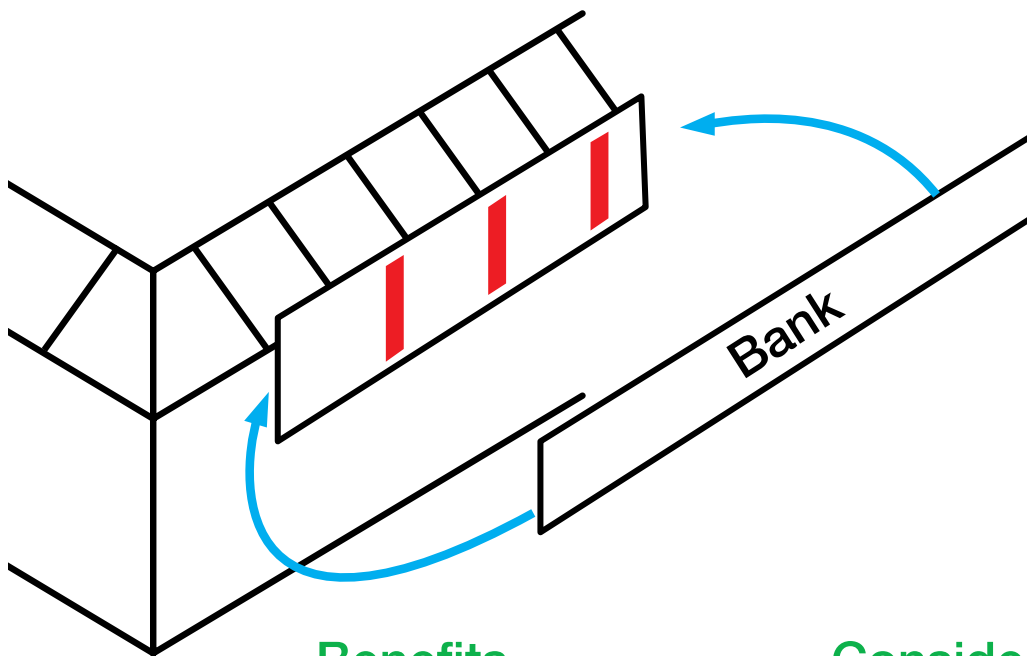
Excellent adhesion to high and low energy surfaces

High Peel and **Shear Strength**

Excellent resistance to UV light, solvents and plasticizers.



Fascia



Benefits

- Easy to apply without any mechanical attachment systems
- Enhanced aesthetics
- High performance of UHB tapes increases durability of sign

Considerations

- Durability and choice of materials will determine the best bonding option.



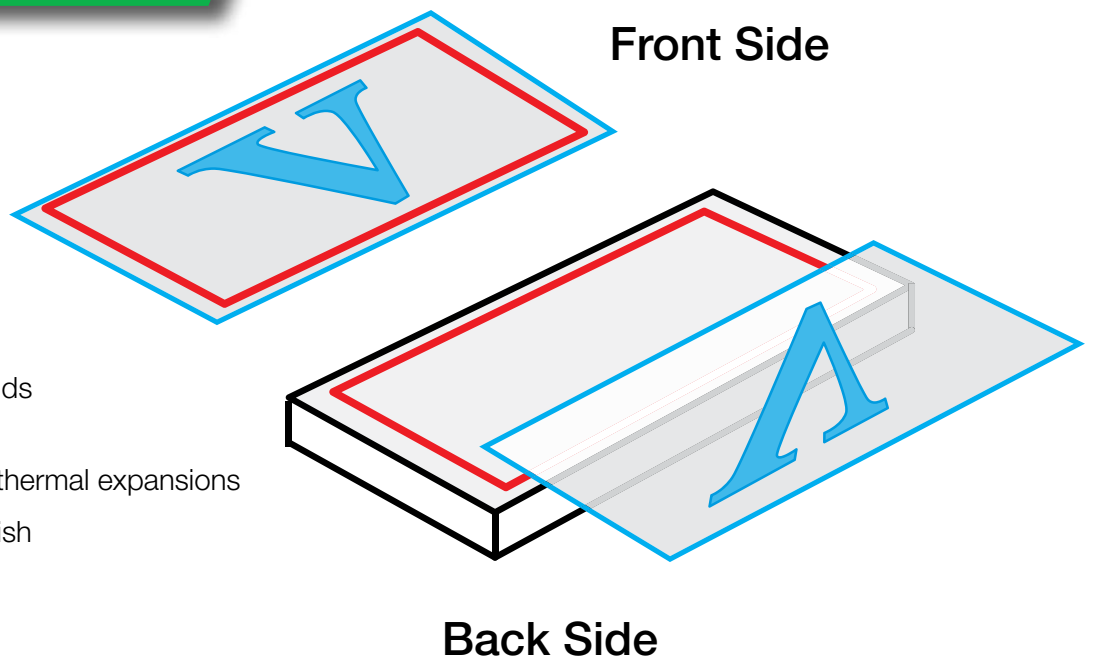
Light box

Benefits

- Tape seals and bonds in one operation
- Allows for different thermal expansions
- Clean, attractive finish

Considerations

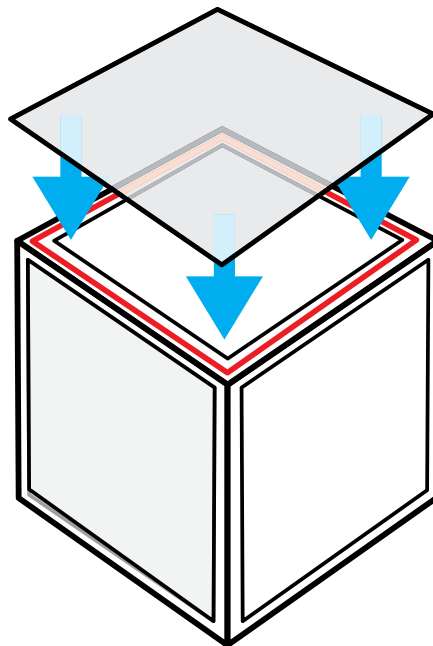
- Heat resistance required from light source
- Clarity of bonding products required when transparent materials are used
- External applications usually demand a water-tight seal
- Bonding to different materials, eg. aluminum, polycarbonate





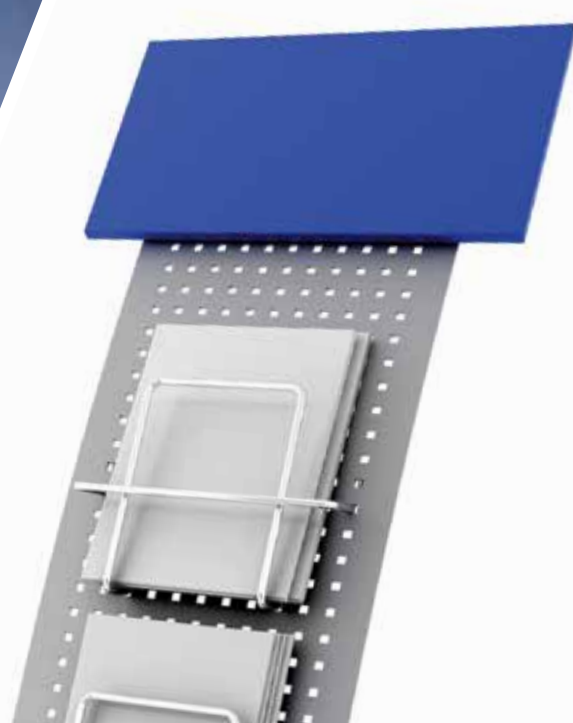
Box signs

Aluminum Sheet bonded
to box frame.
Panels bonded to frame



Benefits

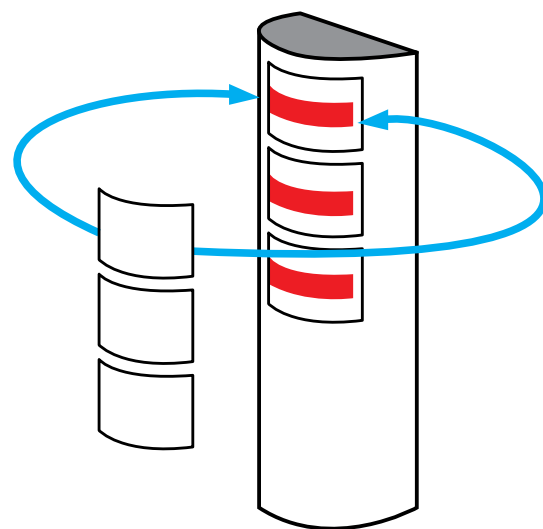
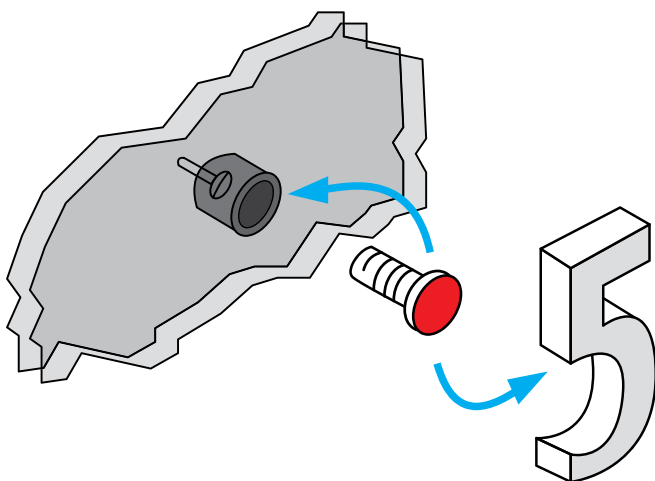
- Flush, clean surfaces
- Improved cost saving as a tape enables use of thinner, lighter materials.
- Speed and simplicity of assembly (critical for modular sign construction.)



Mounted Letters & Obelisk

Benefits





- No deterioration of sign face; improved appearance
- Allows for expansion and contraction of sign panel
- Bonds and seals in one step



Benefits

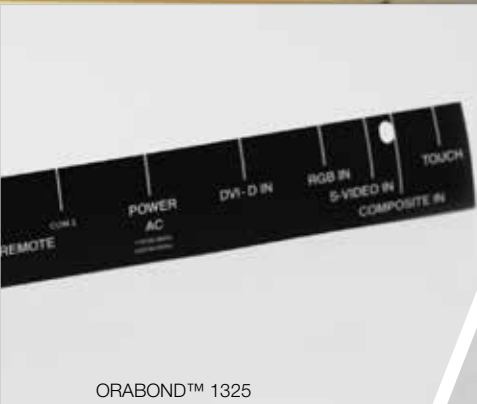
- Ensures flush vandal-resistant finish
- Invisible fixing and minimal surface damage
- Structural strength achievable on small areas

ORABOND™ Transfer Tapes

	1375		1377	1325	1327	1328
						
Alternative to	3M 467MP		3M 468MP	3M 9471LE	3M 9453LE	3M 9472LE
Application Areas	Ideally suited for – <ul style="list-style-type: none">• Metal & plastic nameplates• Fascia panels for electronics• Sign & Display industry			Ideally suited for materials that require an extremely high shear & temperature resistance. (All films.) For adhesion to rough and slightly structured or stamped surfaces. (ORABOND™ 1327 & 1328 only.)		
Key Property	Excellent peel and shear strength Extreme resistance to UV light, solvents, and plasticizers 170°C/338°F long-term temperature resistance			Excellent peel and shear strength Extreme resistance to UV light, chemicals, solvents, and humidity Extremely durable on metal, varnish and high energy plastic surfaces Very durable on low-energy plastic surfaces		
Adhesive	A7 Pure Acrylate			AM12 Modified Solvent Acrylate		
Carrier	Unsupported transfer					
Liner	Moisture stable PE-coated paper, brown with Blue ORAFOL® imprint			Siliconised PE-coated paper (both sides), brown with Blue ORAFOL® imprint		
Thickness	57 microns 2.25-mil	120 microns 4.75-mil		57 microns 2.25-mil	89 microns 3.5-mil	119 microns 4.7-mil
Roll Size & Rolls/Case	305 mm x 50 m (12" x 55 yd)	4		305 mm x 50 m (12" x 55 yd) 610 mm x 50 m (24" x 55 yd) 1220 mm x 50 m (48" x 55 yd)	1	
	610 mm x 50 m (24" x 55 yd)	1			1	
	1220 mm x 50 m (48" x 55 yd)	1			1	
	25 mm x 50 m (1" x 55 yd)	60				
	38 mm x 50 m (1½" x 55 yd)	36				
	50 mm x 50 m (2" x 55 yd)	30				
	610 mm x 914 mm (24" x 36")	100 sheets/ream		ORABOND™ 1327 is only available in 1220mm/48" roll width x 50m/55 yd. roll length.		



ORABOND™ 1375



ORABOND™ 1325



ORABOND™ 1327



ORABOND™ 1328

ORABOND™ 1325, 1327 & 1328 – Ideal for foams and materials that require a **Very High Adhesive Strength**.

Strong bonding solutions

and high performance – *every time!*

ORAFOL's *best selling*



**Double-sided
Adhesive Tapes**

AM2– Modified Solvent Acrylic Adhesive

Easy to Identify Color Coded Liners

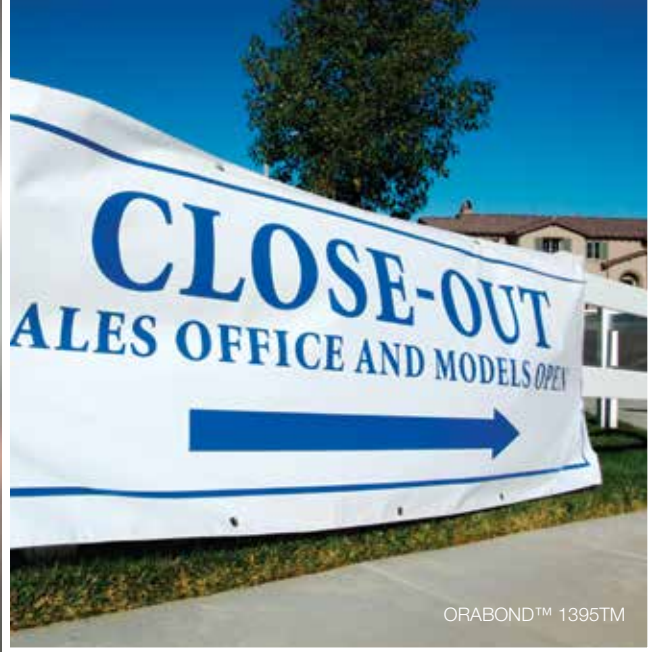
Strong Adhesion

Superior High Tack

Bonds Efficiently and Aggressively to most surfaces –

Perfect for Low-energy Surfaces

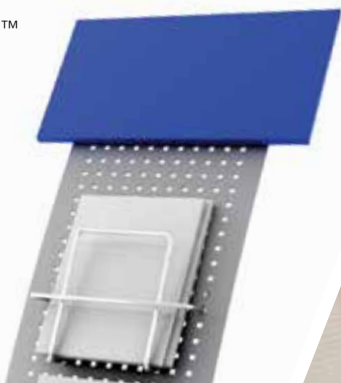
High Temperature and Shear Resistance



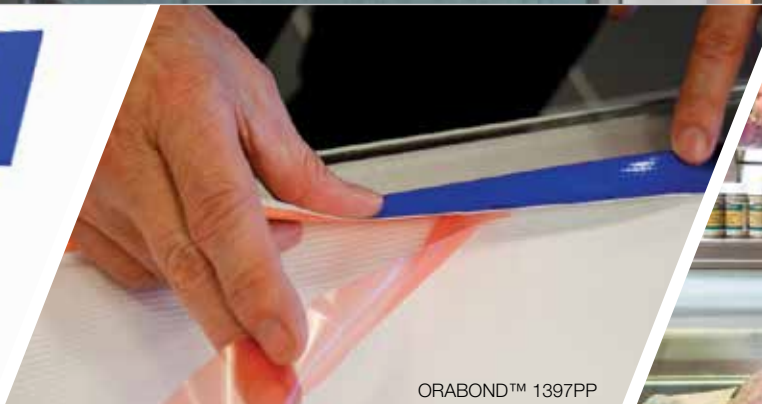
ORABOND™ 1395TM

ORABOND™ 1397TM

ORABOND™
1392TM






ORABOND™ 1397PP






ORABOND™ 1399TM

ORABOND™ AM2

	1392TM		1395TM		1397PP	
						
Alternative to	Tesa 4970, 3M 9087, Lohmann 370		Nitto 5011, 3M 9098, Lohmann 3720		Tesa 4965, 3M 9088FL, Lohmann 376F/377F	
Application Areas	Car and truck mirrors in plastic housing		POP displays, outdoor signs, banner splicing, etc.		POP displays, outdoor signs, banners, APET, fluted PP board, Falcon foam, Lexan, high impact Styrene, etc. which have to be very stress-resistant	
Key Property	High peel and shear strength for opaque applications		High-tack and medium-shear strength		High peel and shear strength	
	Extreme resistance to UV light, high temperature, chemicals, solvents, humidity, and plasticizer				Extreme resistance to UV light, temperature, chemicals, solvents, and humidity	
	70°C/158°F long-term temperature resistance		160°C/320°F long-term temperature resistance		160°C/320°F long-term temperature resistance	
Adhesive	AM2 Modified Solvent Acrylate					
Carrier	38 micron 1.5-mil hard white PVC		12 micron 0.5-mil Clear PET			
Liner	55# 3.0-mil white paper with Blue ORAFOL® imprint				80 micron 3.15-mil red polypropylene film	
Thickness	260 microns 10.25-mil		130 microns 5-mil		210 microns 8.25-mil	
Roll Size & Rolls/Case	12 mm x 50 m (½" x 55 yd)	80	12 mm x 33 m (½" x 36 yd)	120	12 mm x 50 m (½" x 55 yd)	120
	19 mm x 50 m (¾" x 55 yd)	52	19 mm x 33 m (¾" x 36 yd)	78	19 mm x 50 m (¾" x 55 yd)	78
	25 mm x 50 m (1" x 55 yd)	40	25 mm x 33 m (1" x 36 yd)	60	25 mm x 50 m (1" x 55 yd)	60
	38 mm x 50 m (1½" x 55 yd)	24	38 mm x 33 m (1½" x 36 yd)	36	38 mm x 50 m (1½" x 55 yd)	36
	50 mm x 50 m (2" x 55 yd)	20	50 mm x 33 m (2" x 36 yd)	30	50 mm x 50 m (2" x 55 yd)	30
	1370 mm x 50 m (54" x 55 yd)	1			Also available in 1370mm/54" roll width.	

Double-Sided Adhesive Tapes

1397TM		1399TM		1812TM	
					
Tesa 4965, 3M 9088FL, Lohmann 376F/377F		3M 9086, Lohmann 3702, Tesa 4959		Tesa 4952, 3M 9546, Lohmann 5011, Scapa 5464, St. Gobain V1600	
POP displays, outdoor signs, banners, APET, fluted PP board, Falcon foam, Lexan, high impact Styrene, etc. which have to be very stress-resistant		POP displays, outdoor signs, splicing on difficult boards and banners, etc.		Bonding to rough or dissimilar surfaces, exhibition mounting, mirror mounting, outdoor signs, etc.	
High peel and shear strength (for opaque applications-1399TM)				Excellent resistance to UV light, solvents, and plasticizer	
Extreme resistance to UV light, temperature, chemicals, solvents, and humidity				High peel and shear strength on difficult plastics	
Long-term temperature resistance		140°C/284°F long-term temperature resistance		Long-term temperature resistance 100°C/212°F	
AM2 Modified Solvent Acrylate					
12 micron 0.5-mil Clear PET		1.5-mil tissue		1 mm 39.5-mil white PE Foam	
55# 3.0-mil white paper with Blue ORAFOL® imprint					
210 microns 8.25-mil		190 microns 7.5-mil		1.1 microns 43.5 mil	
12 mm x 50 m (½" x 55 yd)		120		12 mm x 50 m (½" x 55 yd)	
19 mm x 50 m (¾" x 55 yd)		78		19 mm x 50 m (¾" x 55 yd)	
25 mm x 50 m (1" x 55 yd)		60		25 mm x 50 m (1" x 55 yd)	
38 mm x 50 m (1½" x 55 yd)		36		38 mm x 50 m (1½" x 55 yd)	
50 mm x 50 m (2" x 55 yd)		30		50 mm x 50 m (2" x 55 yd)	
ORABOND™ 1397TM is also available in 1370mm/54" roll width.				20	
				13	
				10	
				6	
				5	

LEVEL **3** - DEPART

LEVEL **2** - PUBLIC

LEVEL **1** - PARKING

LEVEL **G** - ARRIVAL

GREETER

&

ORABOND™ 1852

CHECK IN FOR

Specialty Tapes

Perfect for **Window Applications** when a ***permanent bond*** is needed on the graphic side and a ***removable bond*** is need on the window side.

Clean removability from a variety of surfaces, even after an extended period of time

No damaged surfaces or messy cleanup!

ORABOND™ Specialty Tapes

	1331TM		1852	
			 	
Alternative to	3M 776, Tesa 4917		3M 4658, Essentra Remo One, Tesa 65605	
Application Areas	Displays, exhibition boards and posters, temporary fixing, etc. with the ability to remove cleanly			
Key Property	Covered/Removable Side – Easy, clean removability from a variety of surfaces			
	Open/Permanent Side – Strong bonding characteristics to many surfaces			
	Good resistance to temperature (120°C/248°F) and moisture			
Adhesive	AM1/AM5 Modified Solvent Acrylic		AM2/AM6 Modified Solvent Acrylic	
Carrier	12 micron 0.5-mil Clear PET		1.0 mm Closed cell PE Foam with interlayer polyester film	
Liner	90g white paper with Blue ORAFOL® imprint		90g white paper	
Thickness	100 microns 4-mil		1.2 microns 47.5-mil	
Roll Size & Rolls/Case	12 mm x 50 m (½" x 55 yd)	120	12 mm x 50 m (½" x 55 yd)	20
	19 mm x 50 m (¾" x 55 yd)	78	19 mm x 50 m (¾" x 55 yd)	13
	25 mm x 50 m (1" x 55 yd)	60	25 mm x 50 m (1" x 55 yd)	10
	38 mm x 50 m (1½" x 55 yd)	52	38 mm x 50 m (1½" x 55 yd)	6
	50 mm x 50 m (2" x 55 yd)	30	50 mm x 50 m (2" x 55 yd)	5



ORABOND™ 1331TM

Great for Point of Sale Applications when a **Removable Tape** is *needed*.



DEPARTURES

ORABOND™ 1810



ORABOND™ 1812™



ORABOND™ 1831




Double-Sided Adhesive Tapes with Foam Carriers

High Performance adhesive tapes used to bond ***rough*** or ***dissimilar surfaces***.

Excellent resistance to UV light, solvents and plasticizers.

Excellent for mirror mounting and hanging of indoor signs.

ORABOND™ Double-Sided

	1810	1812TM
	 	
Alternative to	3M 9539, Lohmann 918	Tesa 4952, 3M 9546, Lohmann 5011, Scapa 5464, St. Gobain V1600
Application Areas	Bonding to rough or dissimilar surfaces, exhibition mounting, mirror mounting, outdoor signs, etc.	
Key Property	Excellent resistance to UV light, solvents, and plasticizer	
	Maximum peel & shear strength on glass and metal	High peel and shear strength on difficult plastics
	Long-term temperature resistance 95°C/203°F	Long-term temperature resistance 100°C/212°F
Adhesive	A1 Pure Solvent Acrylate	AM2 Modified Solvent Acrylate
Carrier	1 mm 39.5-mil white PE Foam	
Liner	86# 5.5-mil blue PE paper	55# 3.0-mil white paper with Blue ORAFOL® imprint
Thickness	1.1 microns 43.5-mil	
Roll Size & Rolls/Case	12 mm x 50 m (½" x 55 yd) 19 mm x 50 m (¾" x 55 yd) 25 mm x 50 m (1" x 55 yd) 38 mm x 50 m (1½" x 55 yd) 50 mm x 50 m (2" x 55 yd)	20 13 10 6 5

Adhesive Tapes with Foam Carriers

1831	1852
	
3M 9536, Lohmann 5008, Scapa 5474, St. Gobain V1500	3M 4658, Essentra Remo One, Tesa 65605
Bonding to rough or dissimilar surfaces, exhibition mounting, mirror mounting, indoor signs, etc.	Displays, exhibition boards and posters, temporary fixing, etc. with the ability to remove cleanly
Very high initial-tack and good shear strength Excellent adhesion to a variety of plastics	Covered/Removable Side – Easy, clean removability from a variety of surfaces
	Open/Permanent Side – Strong bonding characteristics to many surfaces
	Good resistance to temperature (120°C/248°F) and moisture
RL2 Synthetic Rubber	AM2/AM6 Modified Solvent Acrylic
1 mm 39.5-mil, white PE Foam	1.0 mm Closed cell PE Foam with interlayer polyester film
55# 3.0-mil white paper	90g white paper
1.1 microns 43.5-mil	1.2 microns 47.5-mil
12 mm x 50 m (½" x 55 yd) 19 mm x 50 m (¾" x 55 yd) 25 mm x 50 m (1" x 55 yd) 38 mm x 50 m (1½" x 55 yd) 50 mm x 50 m (2" x 55 yd)	20 13 10 6 5

ORAFOL® Adhesives

Name	Type	Properties & Features
A1	pure solvent acrylic	High-shear adhesive with excellent resistance to high temperatures, solvents, humidity and outdoor exposure.
A7	pure acrylic	High-shear adhesive with excellent high-tack, excellent adhesion on all high-energy surfaces.
AM1	modified solvent acrylic	Medium-shear adhesive with excellent adhesion to most foams where plasticizers and other impregnates are used.
AM2	modified solvent acrylic	High-shear, high-tack adhesive with excellent balance of properties for use in high performance bonding applications. This product features good adhesion to low-energy plastic surfaces.
AM5	modified solvent acrylic	Ultra removable adhesive with excellent no-build adhesion to most surfaces.
AM12	modified solvent acrylic	Excellent high-tack and outstanding adhesion on high-energy and especially on low-energy surfaces.
RL2	synthetic rubber	High shear solvent rubber with good adhesion to low-energy plastic surfaces.

ORABOND™ Carpet Tape

1362



Alternative to	Lohmann 4313, Tesa 4964			
Application Areas	Good bonding to carpet with clean removability from exhibition floors.			
Adhesive	Modified dispersion acrylate		Carrier	Rayon, White
Liner	55# white paper		Thickness	292 microns 11.5-mil
Roll Size & Rolls/Case	12 mm x 50 m (½" x 55 yd)	80	38 mm x 50 m (1½" x 55 yd)	24
	19 mm x 50 m (¾" x 55 yd)	52	50 mm x 50 m (2" x 55 yd)	20
	25 mm x 50 m (1" x 55 yd)	40		

PRODUCT OVERVIEW

(All Sign & Display Tapes except ORABOND™ UHB tapes)

Substrate	Tape Carrier	PVC	PET	Tissue		Foam			Transfer		
		White	Clear	Off White		White			Clear		
Foam Sign Board (uncoatedPVC)	1392TM		1397PP 1397TM				1812TM		1375	1377	
PET Sheets											
Paper Laminated Foam Board											
Coated Foam Board	1392TM		1399TM			1810		1831			1328
Polypropylene Sheet											
PVC Sign Board											
Polycarbonate Sheet			1397PP 1397TM				1812TM		1375	1377	1328
Filled Polypropylene											
Banner, Heavy											
Banner, Light	1392TM										
Polystyrene Sheet						1810		1831	1375	1377	
Uncoated Cartonboard			1399TM	1358TM							
Uncoated Paper											
Corrugated Board											
Mirrors (glass sheet)					1810	1812TM	1831				
Mirrors (acrylic sheet)											

For more product information, please contact tapes-americas@orafol.com.

- ORABOND™ 1399 is very widely used in splicing of paper and carton boards in coating and printing applications.
- ORABOND™ 1397PP is very popular because the red film liner is widely seen as a measure of product performance (3M 9088FL and Tesa 4965 for example).



ORABOND™ 3598



ORABOND™ 3601



ORABOND™ 3599



ORABOND™ 3600



ORABOND™ 3597



What makes UHB tapes bond so well?

ORABOND™ UHB (Ultra High Bond) tapes bond to a wide variety of surfaces.

The **viscoelastic properties (flow characteristics)** of the UHB tapes allow the adhesive to flow into the microscopic surface of materials. The adhesive bond is very strong when there is good 'wet out', maximum adhesive contact under pressure with the substrates to be bonded.

Abrading the surface to be bonded actually improves the strength of the bond.






This creates a rough surface for a greater adhesive bonding area.

The **elastic characteristics** of the foam give it very good internal cohesive strength to support loads in both static and dynamic shear. It also gives the foam very good peel adhesion strength.






The tape is soft and very flexible which means it has **great conformability**.

The tape will **radius well** (go around curves).

ORABOND™ Ultra

	3594	3595	3596	3597	3598
					
Alternative to	3M RP25	3M 4930	3M 9473	3M 4905	3M 5314
Application Areas	Ideally suited for a wide range of applications in – <ul style="list-style-type: none">• Automotive• Electronic• Sign & Display industry• Solar	Ideally suited for structural and general bonding including – <ul style="list-style-type: none">• Body panels• Emblems• Illuminated displays• Signage			
Key Property	High Performance Bonding & Mounting High shear holding power and temperature resistance		High Performance Bonding & Mounting High shear holding power and temperature resistance Clear adhesive improves bondline aesthetics when joining transparent materials		High Performance Bonding & Mounting High shear holding power and temperature resistance Elastomeric nature of the foamed adhesive makes it ideal for applications requiring conformability
Adhesive	Foamed Acrylic, Grey	Foamed Acrylic, White	Foamed Acrylic, Clear		Foamed Acrylic, Grey
Liner	5-mil release coated polyethylene, Red				
Thickness	640 microns 25-mil		249 microns 10-mil	500 microns 20-mil	800 microns 31-mil
Roll Size & Rolls/Case	12 mm x 33 m (½" x 36 yd) 19 mm x 33 m (¾" x 36 yd) 25 mm x 33 m (1" x 36 yd)			24 16 12	

High Bond (UHB) Tapes

3599	3600	3601	3602	3603		
						
3M 4910	3M 4941/5952	3M 4950	3M 4991	3M 4956		
<p>Ideally suited for mounting, bonding and sealing of –</p> <ul style="list-style-type: none">• Glass displays• Illuminated displays• Laminated safety glass• Signage• Shower screens	<p>Ideally suited for structural and general bonding including–</p> <ul style="list-style-type: none">• Body panels• Emblems• Illuminated displays• Signage• Window glazing bars (3601 only)					
<p>High Performance Bonding & Mounting</p> <p>Ideal for applications where thermal expansion differences are a concern</p> <p>Clear adhesive improves bondline aesthetics when joining transparent materials</p>	<p>High Performance Bonding & Mounting</p> <p>Ideal for applications where thermal expansion differences are a concern</p>		<p>High Performance Bonding & Mounting</p> <p>High shear holding power and temperature resistance</p> <p>Ideal for applications where thermal expansion differences are a concern</p>			
Foamed Acrylic, Clear	Foamed Acrylic, Grey	Foamed Acrylic, White	Foamed Acrylic, Grey			
5-mil release coated polyethylene, Red						
1,000 microns 40-mil	1,100 microns 44-mil		2,000 microns 78-mil	1,500 microns 60-mil		
	12 mm x 33 m (½" x 36 yd)	24	13 mm x 16.5 m (½" x 18 yd)	23	13 mm x 25 m (½" x 27 yd)	23
	19 mm x 33 m (¾" x 36 yd)	16	15 mm x 16.5 m (¾" x 18 yd)	20	15 mm x 25 m (¾" x 27 yd)	20
	25 mm x 33 m (1" x 36 yd)	12	25 mm x 16.5 m (1" x 18 yd)	12	25 mm x 25 m (1" x 27 yd)	12

ORABOND™ UHB Tapes

Adhesion Guidelines for Substrates

Substrate Material		Adhesion	Primer Usage
Aluminum Anodized Aluminum Copper Lead	Painted Metal Stainless Steel Tin Zinc	Excellent	Not Necessary
Alkyd Enamel Epoxy Paint Kapton Nylon	Polychloroprene Polyester Polyurethane	Very Good	May Need Primer
ABS (Acrylonitrile-Butadiene-Styrene) Acrylic Polycarbonate	Polystyrene PVA (Polyvinyl Acetate) PVC (Polyvinyl Chloride)	Good	Recommended
EPDM (Ethylene Propylene Diene Monomer-Rubber) EVA (Ethylene Vinyl Acetate)	Polyethylene Polypropylene Tedlar	Good	Required
Silicone	Teflon	Poor	

Attention

Surfaces to which the material will be applied must be cleaned thoroughly of dust, grease or any contaminants. It is the end users responsibility to verify painted surfaces are completely cured prior to adhesive tape application.

Preparation

Cleaned with an appropriate solvent; preferably IPA no more than 15 minutes prior to bonding.

Typically, full bond is reached after 72 hours.
(50% at 20 minutes, 90% at 24 hours.)



ORABOND™ UHB

The Tape
that replaces the need for
**Mechanical Fasteners
& Liquid Adhesives.**

Adhesive Tape Systems
Engineered to Perform Better™



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ATS-SD-BROCHURE



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