

# Best Practices for Storing and Applying Pressure Sensitive Adhesive Tapes



## Applying the PSA

### Prepare the Surface

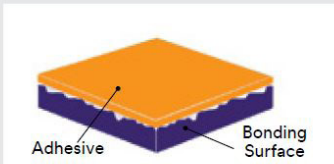
When preparing to apply a Pressure Sensitive Adhesive (PSA), the bonding surface should be **clean, dry and free of lint, grease and oil contaminations**. Surfaces that have been exposed to the elements prior to use, should be wiped down with an evaporative solvent such as MEK (methyl ethyl ketone). After the surface has been cleaned and dried, follow by wiping the area again with isopropyl alcohol. Other cleaning products that can be used include esters (ethyl acetate or acetone) and naphtha-based products. It may be necessary to improve the surface energy by using primers, flame treatment, corona treatment, etc.

### Apply Pressure

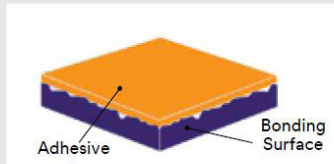
Generally PSA's require a minimum of **15 psi to secure most bonds**. Pressure can be applied via hand, hand roll down, squeegee, roll/nip laminator, etc. The minimum application temperature is 50° F. The adhesive will continue to wet-out or build in adhesion for up to **72 hours**, especially acrylic and silicone pressure sensitive adhesive systems. Heat lamination improves surface contact area and decreases wet-out time.

Applying firm pressure to the bond increases adhesive flow and contact for more secure bonding. Time and temperature will typically further increase contact and adhesion values.

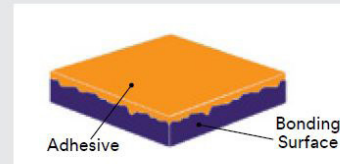
① Initial Contact  
(Minimal Contact)



② After Rubdown  
(More Contact)



③ After Dwell Time  
(Excellent Contact)



graphic by 3M

## Storing the PSA

It is recommended to store pressure sensitive adhesive tapes at the following conditions:

- 68-72° F
- 50% relative humidity
- Stored in original packaging, away from direct sources of UV, such as lights and sunlight

*Review these guidelines with your Marian Sales Engineer and Material Supplier. Some of these recommendations may vary based on the specific PSA being chosen.*



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