

Surface Preparation & Application Information

Arlon AGT, AWT2 and HiPerGLAZE™ glazing tapes are compression sealants designed for “drop in” glazing applications. Arlon glazing tapes are not designed to perform structural functions. As with all sealants, proper surface preparation and application are required to obtain acceptable results.

SURFACE PREPARATION:

Arlon glazing tapes must be applied to clean, dry and non-porous surfaces. Appropriate preparation is required to attain desired results. The following guidelines should be followed:

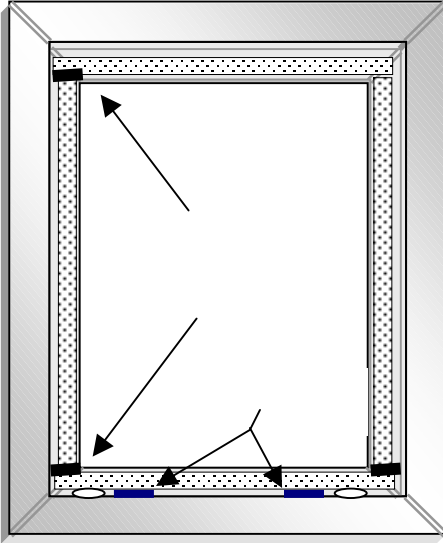
<u>Surface Type</u>	<u>Preparation</u>
<i>Sash Materials:</i>	
<ul style="list-style-type: none"> ▪ Wood and Wood Particle substrates ▪ PVC ▪ Aluminum (mill finish) ▪ Aluminum (anodized or painted) 	<p>Substrate must be completely sealed (i.e. primed and sealed against moisture. Sealants should be dry before tape application.</p> <p>Wipe with isopropyl alcohol</p> <p>Wipe with MEK</p> <p>Wipe with Xylol or Naptha</p>
<i>Lite Surfaces:</i>	
<ul style="list-style-type: none"> ▪ Glass (Single lite) ▪ Glass (Sealed unit) ▪ Acrylic ▪ Polycarbonate 	<p>Run through glass washer if possible. Wipe with Xylol, Industrial Strength Windex® or toluene</p> <p>Clean all IG sealant from glass and wipe with Xylol and Windex®</p> <p>Wipe with isopropyl alcohol</p> <p>Wipe with isopropyl alcohol. <i>Note:</i> Polycarbonate sheeting may be coated with an abrasion-resistant silicone coating that will prevent the formation of a suitable bond. Sheet manufacturers should be contacted to confirm surface treatment and to obtain recommendations for removal.</p>

All the solvents cited above are readily available in hardware and paint supply stores. Review the relevant flammability and/or toxicity guidelines to avoid misuse.

APPLICATION INFORMATION:

Proper application will enhance the performance and overall function of the sealant. Application should occur at temperatures of at least 50°F. Excessive handling of the tape should be avoided. The protective liner should not be removed to expose the adhesive until the lite is ready for installation. Joints should fit well and welds be smooth and free of burrs. Surfaces must be properly prepared and dry.

The tape may be applied to either the lite surface or the sash – in most situations direct application to the sash is most practical.



- **Application:** Tape should be pressed into place with light pressure. Care should be taken to avoid stretching the tape during application.
 - **Treatment of corners:** Butt joints should be used at the corners, with vertical runs abutting the horizontal. Tape should not be overlapped, folded or radiused to form the corners. A small amount of silicone joint sealant should be used at the joint to ensure a continuous seal.
 - **Compression:** Although Arlon glazing tapes use only closed-cell foam, a 15% minimum compression is recommended to allow for wind load and temperature changes. The following pressure is recommended:
 - $\frac{1}{32}$ " and $\frac{1}{16}$ " – 6 p.s.i.
 - $\frac{3}{32}$ " and $\frac{1}{8}$ " – 6 p.s.i.
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- Tape gauge should be selected to allow a minimum + $\frac{1}{32}$ " over the designed tolerance to allow for planar variation in the sash.
 - A cap bead of silicone sealant is recommended for very large lites, or for windows designed for use in areas with very high wind loads and higher elevation. A toe bead of sealant will add additional protection against moisture.
 - Test all materials for compatibility. Compatibility letters are available for silicone sealants supplied by General Electric and the Dow Corning Corporation.

Contact Arlon for additional information.

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