

## 3000 Performance Series DATASHEET 3300 Soft

### Product description

Acrylic Foam Tapes (AFT) are double sided high-performance structural adhesives. These adhesives provide a convenient and simple bonding solution and in many applications, they can be used to replace mechanical fasteners such as rivets, screws, welds or liquid adhesives.

Olympic 3300 Soft is designed to meet the highest industry standards. Its unique visco-elastic nature ensures a strong bond which can absorb shocks and stress. Thanks to its acrylic chemistry, it also provides a highly durable and long-lasting bond for indoor and outdoor applications alike. The adhesives are based on a 100% closed cell structure and have an excellent solvent, plasticizer, and moisture resistance.

The 3300 Soft is based on a lightly foamed soft multi-purpose acrylic adhesive. It is particularly suitable for adhesion to high and medium-surface-energy substrates and enhanced adhesion to low surface energy substrates. The 3300 series is also an excellent choice for adhesion to plastics to which a primer layer is applied or which has been exposed to a corona/plasma treatment. Furthermore the 3300 series is also ideal when high temperature tolerance and/or excellent holding power are required.





### Application techniques

To achieve a proper bond it is important to consider the following:

- ✓ Olympic 3300 Soft is a pressure sensitive adhesive. Firm application pressure improves the bonding strength.
- ✓ Olympic 3300 Soft adheres to surfaces immediately and the bond strength further improves over time. It reaches maximum bond strength after 72 hours (at room temperature).
- ✓ The time needed to reach maximum bond strength can be reduced significantly by increasing the overall temperature of the bonded surfaces.
- ✓ The bonding surfaces must be clean and dry to achieve full adhesion. Surfaces must be cleaned by using solvents such as isopropyl alcohol, rubbing alcohol, or heptane.
- ✓ The ideal adhesive application temperature range is 20 °C to 35 °C. Initial adhesive application to surfaces at temperatures below 10 °C is not recommended. However, once properly applied, low temperature holding is generally satisfactory.

## General physical characteristics

The table below lists the standard physical properties of a roll AFT from the 3300 series as it is typically produced. Other thicknesses, adhesive colors (red, blue), types of release liner (i.e. paper) and types of cores (i.e. paper core) are all possible on customer request.

Series	Adhesive			Release liner			Core	
	Color	Adhesive type	Foam type	Material	Thickness (mm)	Color	Size (mm)	Material
3300	  	Acrylic	Soft	PE	0.14		76.20	Polystyrene

 White  Gray  Black  Red

The PE liner has a differential release value of 1:2. One side is MDPE and the other side is LLDPE. The liner does not contain silicones. We can use other liners, i.e. paper, or your own branded liner on request.









## Roll sizes

The 3300 series is typically produced in several different roll sizes. Both smaller and larger rolls are possible.

Series	Thickness (mm)	Standard Length (meter)	Minimum usable width (mm)
3302	0.25	66	900
3304	0.40	66	900
3305	0.50	66	900
3306	0.60	66	900
3308	0.80	66	900
3310	1.00	33	900
3312	1.20	33	900

## Typical performance characteristics

The adhesive properties of the 3300 series can be characterized by a variety of methods. The typical values for the most commonly used mechanical and adhesive properties are listed in the table below.

Series	Color	Thickness (mm)	Density (gram/liter)	90° Peel Adhesion (N/cm)	Static shear (grams)		Maximum Temperature (°C)	
					At 20 °C	At 90 °C	Short term	Long term
3302		0.25	780	28	1500	1000	230 °C	150 °C
3304		0.40	780	30	1500	1000	230 °C	150 °C
3305		0.50	780	31	1500	1000	230 °C	150 °C
3306		0.60	780	32	1500	1000	230 °C	150 °C
3308		0.80	780	33	1500	1000	230 °C	150 °C
3310		1.00	780	34	1500	1000	230 °C	150 °C
3312		1.20	780	35	1500	1000	230 °C	150 °C
3316		1.60	780	35	1500	1000	230 °C	150 °C

 White  Gray  Black

This product has excellent solvent and fuel resistancy



90° peel strength according to ASTM D3330. Stainless steel substrate, aluminum backing. 72-hour dwell time at room temperature. Listed value is average value force to remove adhesive at room temperature.



Static shear according to ASTM D3654. Stainless steel substrates, 0.5 sq.in. (3.23 sq.cm.), 24-hour dwell time at room temperature. The adhesive will hold its listed weight for 10,000 minutes (approximately seven days) at the listed temperature.

Long term maximum temperature is the temperature at which the adhesive will hold 250 grams under static load.

Short term maximum temperature is the temperature to which the adhesive can be exposed for four hours with a static load of 100 grams.

## Storage and shelf life

Shelf life is 24 months from the date of manufacture when stored in its original casing between 18 ° - and 22 °C at 50% relative humidity.

## Additional information

The technical information, recommendations, and other statements contained in this document are based on Olympic's tests or experience. Many factors beyond Olympic's control and uniquely within user's knowledge and control can affect the use and performance of an Olympic product in a particular application. Given the variety of factors that can affect the use and performance of an Olympic product, the user is solely responsible for evaluating the Olympic product and determining whether it is fit for a particular purpose and suitable for user's method of application.

**OLYMPIC** 

Keizersveld 30

5803 AN Venray

The Netherlands

Tel: +31 (0) 478 7452 20

Email: [info@olympicbonding.com](mailto:info@olympicbonding.com)