



# Technical Data Sheet

## Pres-On SG6400/6500 Series Structural Glazing Tape

- Superior initial adhesion to speed on-site fabrication
- High strength open cell urethane foam
- Long-term resistance to environmental and aging damage
- Excellent adhesion to bare metal, glass and paints
- Ideal for structural glazing, thermal breaks on storm windows and doors, curtain wall, and as die cut for vibration and sound dampening
- Color is black

### GENERAL DESCRIPTION

#### SG6400 Series

- ¥ double-coated
- ¥ blue P.E. release liner

#### SG6500 Series

- ¥ single coated
- ¥ paper release liner

SG6400 and SG6500 are high-strength open cell urethane foam tapes coated with a specifically formulated proven acrylic adhesive exhibiting superior initial adhesion properties and holding power, along with excellent bond to a wide range of fabrication materials including paints, vinyl, plastics, bare metal and glass. Highly resistant to weather extremes, fungi and oxidation.

### APPLICATIONS

Thermal break on storm windows and doors, curtain wall, die-cut to dampen vibration and sound

### PERFORMANCE

| TEST                                   | TYPICAL PERFORMANCE               | TEST METHOD   |
|--|-----------------------------------|---------------|
| Loop Tack                              | 60 oz/in typical                  | TLM1 LIB1     |
| Adhesion @ 72°F to the following       |                                   |               |
| Steel immediate                        | 2.5 lbs/in width                  | PSTC-1        |
| Steel after 24 hrs                     | 3.5 lbs/in width or foam tear     | PSTC-1        |
| Aluminum immediate                     | 2.5 lbs/in width                  | PSTC-1        |
| Aluminum after 24 hrs                  | 3.0 lbs/in width or foam tear     | PSTC-1        |
| Glass immediate                        | 2.0 lbs/in width                  | PSTC-1        |
| Glass after 24 hrs                     | 3-5.0 lbs/in width or foam tear   | PSTC-1        |
| Powder Paint immediate                 | 2.0 lbs/in width                  | PSTC-1        |
| Powder Paint after 24 hrs              | 3-5.0 lbs/in width of foam tear   | PSTC-1        |
| Static Shear @ 72°F 1 x 1 x 500 grams  | indefinite                        | PSTC-7        |
| Static Shear @ 72°F 1 x 1 x 1000 grams | 1000 hours minimum                | PSTC-7        |
| Water and Humidity Resistance          | excellent                         | Pres-on PTM-3 |
| Application Temperature                | 45°F to 120°F                     | Pres-on PTM-1 |
| Service Temperature                    | 40°F to 180°F                     | Pres-on PTM-2 |
| Shelf Life                             | 1 year stored at room temperature |               |

**PHYSICAL PROPERTIES**

| PROPERTY                              | TEST METHOD                                    | UNIT OF MEASURE    | RESULT     |
|---------------------------------------|--|--------------------|------------|
| Density                               | ASTM D 3574                                    | lb/ft <sup>2</sup> | 20         |
|                                       |  | kg/m <sup>3</sup>  | 272-368    |
| Hardness                              | ASTM D2240                                     | Shore A            | 30         |
|                                       | ASTM D1056                                     | Shore 00           | 78         |
| Tensile Strength                      | ASTM D3574                                     | psi                | 150 (min)  |
|                                       |  | kPa                | 1034 (min) |
| Elongation                            | ASTM D3574                                     | %                  | 120 (min)  |
| Tear Strength                         | ASTM D624                                      | lb/in              | 25 (min)   |
|                                       |  | kN/m               | 4.4 (min)  |
| Compression Set<br>(50%-22 hrs @73°F) | ASTM D1056                                     | %                  | 3 (max)    |
| Compression Force                     | ASTM D3574 <sup>2</sup>                        | psi                | 19-25      |
| Deflection 25%                        |  | kPa                | 131-172    |
| Compression<br>@25%                   | ASTM D1056                                     | psi                | 30-50      |
|                                       |  | kPa                | 207-345    |
| Color                                 | N/A  | N/A                | Black      |
| Flammability                          | FMVSS-302: Pass (.063 or Thicker) <sup>1</sup> |                    |            |

1. Submit request for any thickness below .063"

2. Deviation, material tested at .250° instead of .500°

3. This information is furnished as a guide for selecting materials. Pres-On disclaims liability for results or use of this information. It is the customer's responsibility to obtain and test samples when determining suitability of material for a particular application.

**STANDARD ROLL SIZES**

All rolls available in widths from  
3/16" to 54"

| SERIAL NUMBER | THICKNESS | LENGTH |
|---------------|-----------|--------|
| SG6412        | 1/8"      | 50'    |
| SG6425        | 1/4"      | 50'    |
| SG6437        | 3/8"      | 25'    |
| SG6512        | 1/8"      | 50'    |
| SG6525        | 1/4"      | 50'    |
| SG6537        | 3/8"      | 25'    |

**APPLICATION NOTES**

Thoroughly clean contact surface before use. Once SG6400 has been applied, it cannot be removed and reused. Therefore, position SG6400 carefully, assuring that it is in contact with all surfaces. If SG6400 is misaligned, remove used unit, discard and repeat application with new unit. Test product for system compatibility as individual application conditions can impact results. Due to the many variables involved in structural glazing systems, each project should be individually lab tested by the silicone manufacturer for compatibility between SG6400, structural silicone and all other adjacent components. SG6400/SG6500 is a spacer material and is not intended to be a structural component. Pres-On does not assume any responsibility or liability for any advice furnished by it, or for the performance or results of any installation or use of the product(s) or any final product into which the product(s) may be incorporated by the purchaser and/or user. The purchaser and/or user should perform its own tests to determine the suitability and fitness of the product(s) for the particular purpose desired in any given situation.

**CROSS REFERENCE**

St. Gobain: V-2200  
Capital Tape: UK2526

