

# Guidelines for Secon Pressure-Sensitive Foam Muntin Tape Applications

- Cleaning of IG Unit Glass Surface- We suggest that the bonding area of the glass surface be cleaned with a mixture of 50% isopropyl alcohol (IPA), 50% water.
- Cleaning Muntin Bars-Ensure the sash surface is free from dirt or residue by wiping with a clean, dry cloth. If static is causing PVC shavings or particles to stick to the muntin leg, a mixture of isopropyl alcohol/water as described above will help remedy the problem. This mixture can also be used to remove dust, dirt, and handling contaminants.
- Avoid touching and making contact with the surface areas where tape will be applied. Also never touch the exposed adhesive face of the tape to be applied (fingers contain contaminants and oil). Tape should be handled from the edges.
- All materials (tape, sash, IG units, glass, etc.) must be at or above the suggested 60°F minimum tape application temperature prior to use. Materials being stored in cooler locations must be brought inside and/or allow to warm to or above 60°F.
- The exposed side of the muntin tape is to be bonded to the back of the muntin bar and affixed with a minimum of 10-lb roller per inch of muntin bar or result in >50% compression of the foam.
- Allow the muntin tape to dwell on the muntin bar for a minimum of 1 hour before removing the liner and affixing to glass.
- The muntin tape must cover 100% of the backside of the muntin bar. If a channel is cut in the backside of the muntin bar and the tape does not make contact with 100% of the muntin bar surface, the bond strength and bond life may be affected.
- If the muntin bar has “legs” at the edges as part of the design, then the MT tape must be thicker than two-times the height of the legs, thus allowing >50% compression when affixing to the glass.
- The liner side is to be applied to the glass and affixed with a minimum of 10-lb roller per inch of muntin bar or result in >50% foam compression
- Adhesion to the glass must take place immediately following the liner removal to reduce the risk of dust contaminating the liner side adhesive.
- The muntin bar must be cut and affixed to the glass in such a way that allows for the muntin bar manufacturer’s recommended expansion at both ends. Failure to leave adequate room for expansion can result in undue stress and bar deflection.
- Allow at least 1 hour after affixing the muntin bar to the glass before subjecting the bond to adverse conditions ranging from high and low heat, moisture, and bond stress.
- We suggest sending samples of any muntin bars, glass, or other window component parts if changing compound formulas, surface finishes, or silicone corner sealants. This is to determine if any compatibility problems exist before full production.



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This information is furnished as a guide for applying muntin tape. Secon Rubber and Plastics, Inc. 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.