

# Adhesive 19 on Woven Textiles

Technical Data Sheet

May 2025

## PRODUCT DESCRIPTION



**VELCRO® Brand 19 Pressure Sensitive Adhesive on Woven Textile Tape** is a rubber-based pressure sensitive adhesive (PSA) applied to VELCRO® Brand hook and loop fasteners. It should be applied at temperatures between 50° and 80°F. It has excellent adhesion, with an operating temperature range of 0° to 120°F. It adheres to many substrates to which a bond is difficult without solvent activation and high temperatures. This adhesive works well on low surface energy substrates and is considered a high tack, quick setting, semipermanent bond. Please allow adhesive to set for 24 hours before cycling the closure.

## PRODUCT CONSTRUCTION

Adhesive	VELCRO® Brand Adhesive 19
Material Composition	Rubber Hot Melt
Colour	N/A
Thickness	11.4mil
Add-On Weight	270 g/m <sup>2</sup>

## PERFORMANCE CHARACTERISTICS\*



**Peel 180° Adhesion**  
ITM-00054

Average PE: 8.11 PIW or 14.20 N/cm  
Average PP: 16.21 PIW or 28.39 N/cm  
Average Alum.: 17.84 PIW or 31.24 N/cm



**Static Shear**

Minimum: 7 days under some conditions  
Tested with Polypropylene, Polyethylene, and Aluminum



**SAFT**

Target: 90°C or 195°F



**Operating Temperature**

From -34°C or -30°F to 43°C or 110°F

\* The average values are only for reference. Suitable performance for a specific intended application should be evaluated by the user.

\*\* (x amount weight) and (X amount of area) will hold (X amount of minutes or X days).

**SUBSTRATE COMPATIBILITY of the VELCRO® Brand Adhesive 19 \*\*\***

Adhesive	Aluminium	ABS	Polycarbonate	Glass	Acrylic	Polystyrene	Polyethylene	Polypropylene
(Adhesive name: 19)	✓	✓	✓	✓	✓	✓	✓	✓

✓ Recommended  
 ✓ Good  
 ✗ Not Recommended

\*\*\* The table information should be used as reference only. Given the diversity of use of our products and different types of substrates, we strongly recommend our customers to evaluate the adhesive performance on the intended substrate to guarantee the correct fulfilment of the application requirements. Please follow the recommended VELCRO® Brand adhesive application guidelines explained below.

**PRODUCT COMBINATIONS**

The **VELCRO® Brand PS-19 adhesive** is combined with the VELCRO® Brand fastener. Other kind of combinations are under development.

**ADDITIONAL PERFORMANCE CHARACTERISTICS**

**Outdoor use**

Since the product has tendency to degrade in UV light, the **VELCRO® Brand PS-19 Adhesive** is not recommended for direct, prolonged exposure to UV light or outdoor applications.


**Resistance to solvents**

The product should be tested in use for a specific application and has not been tested for resistance to transportation fluids such as gasoline, motor oils, and transmission fluids. We recommend testing the product for its specific application.


**Fire resistance**

The **VELCRO® Brand PS-19 Adhesive** is not a fire retardant adhesive and should not be used where flammability resistance is a concern.


**Water/Moisture resistance**

This adhesive has a good resistance to humidity. The product should be tested when used for a specific application and has not been tested for complete immersion in water.


**Biocompatibility**

The **VELCRO® Brand PS-19 Adhesive** has not been tested for biocompatibility. Customers have full responsibility to determine the suitability for safety and biocompatibility assessments of the **VELCRO® Brand PS-19 Adhesive**.



### Storage & Shelf Life

For the **VELCRO® Brand PS-19 Adhesive** please make sure that the tape is stored in its original packaging, in a dry place and at a preferable temperature between 20 °C and 40 °C. When the tape is stored under the proper conditions, the tape has a shelf life of 24 months.

## APPLICATION GUIDELINES

Every good bond starts with proper surface preparation. This preparation consists of several steps, such as cleaning, abrading, applying pressure, the use of a primer and the right working environment. It is important to ensure your work area to be clean and free from dust and contaminants. A minimum temperature of 28°C or 68°F is required.



### Cleaning

To clean your light and medium contaminated substrates, isopropanol/alcohol solution (IPA) is acceptable. When cleaning your substrate, a tear free, light coloured paper towel is required. Wipe the substrate in one direction using the one cloth method (one cloth with cleaner) or a two cloth method (one cloth with cleaner and one dry cloth to follow) is acceptable if you are short on time. Repeat these steps until your cloth is clean and free of any contaminants. For heavily contaminated substrates, use a cleaning agent such as MEK, Heptane or Acetone. These cleaning agents may leave a residue, which would have to be removed using the IPA solution.

### Abrasion

When bonding to raw aluminium, abrading of the surface is recommended. The oils used in the waltzing of the aluminium are pressed into the pores of the material. To remove these oils, that will influence the bond, we recommend using the abrasive pads assuring the proper level of abrasion without damaging your substrates. Besides raw aluminium, abrading is a method utilized to help improve your bond. After the abrasion process is completed, remove any residue using an IPA solution following the methods mentioned above.



### Pressure

The **VELCRO® Brand PS-XXX adhesive** is a pressure sensitive adhesive. Therefore, a minimum amount of pressure is required on the bond line to ensure the maximum adhesion to your substrates. This pressure should be applied in a rolling fashion. A hand roller or mechanical pressure are the preferred methods. The pressure on the bond line must be a minimum of at least 3.45N/cm<sup>2</sup> or 5 lb/in<sup>2</sup>.

### Removing adhesive residuals

With acetone, white spirit, mineral oil, paraffin wax or with an ecological biodegradable cleaner with a basis of natural solvents.

**Important:** please assure that the substrate is compatible with the above-mentioned products.



Clean surface

Peel away

Place &amp; press

Press with roll  
(2KG)Wait minimum  
24h

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## REGULATORY ELEMENTS

For product declarations of conformity on regulatory elements and additional information, contact [ProductCompliance@velcro.com](mailto:ProductCompliance@velcro.com).

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## PRODUCT USE

The information, statements and comments contained within this document are based on our experience and testing and are believed to be accurate. However, because there are many factors involved in specific applications that can impact end use and performance, product users should always test the product for its ability to meet the requirements of their specific use and method of application.

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Given the diversity of our products, we recommend that our customers verify that the product satisfies the requirements of their application. The customer is responsible for the application and use of the product.

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