



Laminating Adhesives Data Page

FOD # 0914

Scotch™ 7952MP Double Lined Laminating Adhesive

Description

Liner: 58# Polycoated Kraft
Adhesive: #200 “Hi-Performance” Acrylic
Liner: 58# Polycoated Kraft

Typical Applications

Attachment of graphic overlay to membrane switch or keyboard.
Attachment of membrane switch to product housing.
Lamination to polyester for membrane spacers.

Features

- Long term environmentally stable bond.
- Smooth adhesive for high quality appearance on thin graphic overlays.
- High cohesive strength to withstand repeated stresses from switch activation.
- High temperature, humidity, and chemical resistance.

<u>Component</u>	<u>Description</u>	<u>Appropriate Thickness</u>	
		<u>Inches</u>	<u>(MM)</u>
Release Liner	58# Polycoated Kraft	0.004	0.10
Adhesive	#200 “Hi-Performance” Acrylic	0.002	0.05
Release Liner	58# Polycoated Kraft	0.004	0.05
	Total	0.010	0.20

Adhesion Properties

The results indicated are typical values.

	7952MP			
	<u>OZ/IN</u>		<u>N/100 mm</u>	
ASTM D903 180 degree peel 12"/minute 1 mil polyester to stainless steel	54		59	
	72 Hour Dwell		Ultimate Bond	
	<u>OZ/IN</u>	<u>N/100 mm</u>	<u>OZ/IN</u>	<u>N/100 mm</u>
3M test 90% peel 12"/minute 8 mil aluminum to various surfaces				
Stainless Steel	130	144	204	226
Epoxy	132	146	144	158
Polyester	122	134	132	146
Polycarbonate	140	154	138	152
ABS	114	126	106	116

Application Techniques

1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact and thus improves bond strength.
2. To obtain optimum adhesion, the bonding surfaces must be clean, dry, and smooth. Some typical surface cleaning solvents are isopropyl alcohol or heptane. Use proper safety precautions for handling solvents.
3. Ideal tape application temperature range is 70 degrees F. to 100 degrees F. (21 degrees C. to 38 degrees C.). Initial tape application to surfaces at temperatures below 50 degrees F. (10 degrees C.) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

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