Double Linered Laminating Adhesive 7955MPL

Product Data Sheet

Updated : July 2000
Supersedes : December 1994

Physical Properties
Not for specification purposes

Release Liner 1	0.10mm 58# Polycoated Kraft
Adhesive	0.127mm #200 “Hi-Performance” Acrylic
Liner 2	0.05mm 58# Polycoated Kraft
Shelf Life	24 months from date of manufacture when stored in cartons at 70°F at 50% relative humidity.

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.

Applications

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

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Properties and Performance
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Temperature Range	Low : -40°F (-40C) High Long Term (days/weeks) : 300°F (149°C). High Short Term (minutes/hours) : 400°F (204°C).
Chemical Resistance	Solvent resistance is excellent when this product is properly applied to impervious materials. The adhesive resists softening through edge contact with mild acids, alkalis, oil, gasoline, Kerosene, JP-4 fuel and many other solvents. Not recommended for total immersion.
Dielectric Strength (ASTM D149)	0.95 KV/mil
Insulation Resistance (ASTM P257)	N.A. ohms
Volume Resistivity (ASTM D257)	2.2×10^{15} ohm-cm
Surface Resistivity (ASTM D257)	1.3×10^{14} ohms/square
Moisture & Humidity Resistance	No adverse effect on the bond after exposure to 100% Relative Humidity at 100°F.
Bond Build Up	The bond strength of Scotch #200 Hi-Performance Acrylic adhesive increases as a function of time and temperature.
U.V. Resistance	Adhesive is very resistant to oxidisation and ozone when exposed to air or sunlight (U.V.).

Adhesion Properties
Not for specification purposes

ASTM D903 180° peel 12"/minute 1 mil polyester to stainless steel	
N/ 10mm	**9.6**

3M test 90° peel 12/Minute 8 mil aluminium to various surfaces		
	72 hour Dwell N/10mm	Ultimate Bond N/10mm
Stainless Steel	18.0	27.0
Epoxy	17.2	23.6
Polyester	14.2	15.6
Polycarbonate	18.8	21.8
ABS	19.0	14.6

Application Techniques

- 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.
- To obtain optimum adhesion, the bonding surfaces must be clean, dry and smooth. Some typical surface cleaning solvents are isopropyl alcohol or heptane. Observe proper safety precautions when handling solvents.
- Ideal tape application temperature range is 70°F to 100F (21°C to 38°C).
- Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

3M

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