

**TECHNICAL BULLETIN**

**FILM SUPPORTED TAPE**

PRODUCT:	<b>4351M Double-Coated Polyester Film</b>			
PRIMARY USE:	Laminating adhesive forms an excellent bond to a variety of ether, ester and low perm urethane foams. The liner side adhesive is designed to adhere to low-energy surfaces substrates including talc-filled polypropylene.			
DESCRIPTION:	The liner side adhesive is a high tack, heat-resistant rubber adhesive combined with a high heat-resistant acrylic adhesive on the exposed side of a 0.5 mil polyester film. The exposed side adhesive also contains a biostatic additive to resist microbial growth.			
LINER:	12-pt Board			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	0.5 mils	
		Adhesive Exposed Side	1.5 mils	
		Adhesive Liner Side (nominal)	1.5 mils	
		Liner (nominal)	11.3 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>		
		Exposed Side		60 oz/inch
		Liner Side		115 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum foil <i>24 Hour Dwell:</i>		
		Exposed Side		140 oz/inch
		Liner Side		160 oz/inch
	Shear Adhesion	NOTE: Peel tests are performed as per PSTC #101, which states one minute maximum dwell time. In general, for acrylic adhesives, longer residence time yields much higher peel values.		
		PSTC #107; Modified, 1000 gm/sq. inch @ 72° F; <i>one minute maximum dwell:</i>		
		Exposed Side		7 Days
		Liner Side		7 Days

**ADCHEM CORPORATION**  
1852 Old Country Road  
Riverhead, NY 11901  
P: 631-727-6000  
[www.adchem.com](http://www.adchem.com)

Data presented are typical properties taken from a limited number of production runs and should not be used for specification purposes. Adchem Corporation makes no warranty, expressed or implied, and specifically disclaims and disavows any implied warranty of merchantability and of fitness for a particular purpose. Accordingly, all Adchem products are sold with the understanding that purchasers will be solely responsible for determining the suitability of the materials for any purpose.

**TECHNICAL BULLETIN**

**4351M Double-Coated Polyester Film**

PRODUCT FEATURES:	<ul style="list-style-type: none"> <li>• Excellent adhesion to a broad spectrum of foam substrates.</li> <li>• High heat resistance.</li> <li>• Easy release 12PT board liner.</li> <li>• Low fogging (when tested for 24 hrs. 200°F).</li> </ul>
AUTOMOTIVE SPECIFICATIONS:	<p>Chrysler PF-10770(NC)            Delphi SD2-324 4.1.1, 4.1.4, 4.3.3            Ford ESA-M11P19-A            Ford ESB-M3G76-B2            Ford ESH-M11P19-B            GM 3607M Type I            GM 3622M Type IV            Toyota TSK6712G</p> <p>NOTE: Individual reports containing A2LA accredited data can be provided on request.</p>
SERVICE TEMPERATURE:	<p>30°F to 160°F</p> <p>NOTE: This information is provided as a means to help characterize the adhesive's temperature resistance. Note that this data is based on limited testing and under no load. The practical service temperature of this or any adhesive system is dependent on many variables including the substrates being bonded, environmental conditions, and the loading and method of application. The purchaser is responsible for determining the suitability of this or any product for their particular purpose and process. The recommended application temperature is 68°F to 100°F.</p>
NOTES:	Surfaces to be bonded to should be clean, dry and free of grease and oil. This product should not be laminated to any material that contains migrating plasticizers.
RELATED ADCHEM PRODUCTS:	<p>Other high performance acrylic/rubber products include:</p> <p>4377M - 1.4-mils liner side &amp; 1.3-mils exposed side.            4380M – 1.4-mils liner side &amp; 1.5-mils exposed side.            4352M – Liner side engineered for bonding to Nylon.</p>
SHELF LIFE:	One year from date of shipment when stored under cool, dry conditions.

Rev.04.04.14

**ADCHEM CORPORATION**

1852 Old Country Road  
 Riverhead, NY 11901  
 P: 631-727-6000

[www.adchem.com](http://www.adchem.com)

Data presented are typical properties taken from a limited number of production runs and should not be used for specification purposes. Adchem Corporation makes no warranty, expressed or implied, and specifically disclaims and disavows any implied warranty of merchantability and of fitness for a particular purpose. Accordingly, all Adchem products are sold with the understanding that purchasers will be solely responsible for determining the suitability of the materials for any purpose.