

**TECHNICAL BULLETIN**

**FILM SUPPORTED TAPE**

PRODUCT:	<b>4377M Double-Coated Polyester Film</b>			
PRIMARY USE:	Exposed side 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 including mica-filled polypropylene. Engineered to meet automotive specifications.			
DESCRIPTION:	The product is constructed with a high tack, heat resistant rubber liner side adhesive and a high heat resistant acrylic adhesive on the exposed side of a 0.5 mil polyester film. The exposed side adhesive contains a biostatic additive, which aids in meeting the requirements for product that are resistant to microbial growth.			
LINER:	12PT Natural poly-coated Kraft			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	0.5 mils	
		Adhesive Exposed Side (nominal)	1.3 mils	
		Adhesive Liner Side (nominal)	1.4 mils	
		Liner (nominal)	11.3 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>		
		Exposed Side	50 oz/inch	
		Liner Side	85 oz/inch	
		PSTC #101; backed with 2 mil dead soft aluminum foil <i>24 Hour Dwell:</i>		
		Exposed Side	130 oz/inch	
		Liner Side	155 oz/inch	
	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.			
	Shear Adhesion	PSTC #107; Modified, 1000 gm/sq. in. 15-minute dwell		
		@ 72 <sup>0</sup> F	Exposed Side	168 hours
			Liner Side	168 hours
		@ 150 <sup>0</sup> F	Liner Side	140 hours

**ADCHEM CORPORATION**  
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**4377M 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 excellent for kiss cutting.</li> <li>• Biostatic additive inhibits microbial growth.</li> <li>• 54" and 60" widths available.</li> </ul>
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:	The use of heat and pressure will help to increase the initial bond of the product to the substrate. Testing is recommended prior to laminating to any material that contains migrating plasticizers.
RELATED ADCHEM PRODUCTS:	<p>Other high performance acrylic/rubber products include:</p> <p>4380M – 1.6-mils liner side &amp; 1.9-mils exposed side</p> <p>4352M – Liner side engineered for Nylon</p> <p>4351M – 1.5-mils both liner &amp; exposed side.</p>
SHELF LIFE:	One year from date of shipment when stored under cool, dry conditions.

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