ADCHEM
The adhesive tape engineers®

TECHNICAL BULLETIN

TRANSFER TAPE

PRODUCT:	**4628 Adhesive Transfer Tape**		
DESCRIPTION:	A 5-mil unsupported acrylic adhesive system. 4628 adhesive was designed for improved adhesion to low energy surfaces such as talc-filled polypropylene as well as to various urethane foams. 4628 exhibits improved temperature resistance as required by many automotive appliances and other industries applicants.		
LINER:	80 lb. white Densified Kraft		
TYPICAL PHYSICAL PROPERTIES:	Thickness	Adhesive Exposed Side Liner (nominal)	5.0 mils
		Release Liner (nominal)	4.0 mils
	Peel Adhesion	PSTC #101; backed with 1 mil polyester	
		Immediate	60 oz/inch
		24 Hour Dwell	85 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum foil	
		Immediate	150 oz/inch
		24 Hour Dwell	190 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, 1" x 1" x 1000 grams, at 90°F, backed with 2-mil polyester	
		30 Minute Dwell	72 Hours
PRODUCT FEATURES:	• Heavy mass of acrylic adhesive. • Bonds well to low energy surfaces. • Bonds well to most foam products. • Passes selected IBM Specifications (See special testing below).		

ADCHEM CORPORATION
1852 Old Country Road
Riverhead, NY 11901
P: 631-727-6000
www.adchem.com

The adhesive tape engineers®

TECHNICAL BULLETIN

4628-80-54 Adhesive Transfer Tape

SPECIAL TESTING:	4628 has been tested on selected customer supplied polyester urethane foam and passes IBM Specifications 877551, 877553, 898395, 1499160 and 5496244. These tests were specific for the foams supplied. Users must determine the suitability and performance using their own urethane foam.
SERVICE TEMPERATURE:	-30°F to 220°F 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.
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:	Other 5 mil transfer tapes: 6405-12PT-54 – Aggressive rubber based transfer tape on board. 7335-74-54– General purpose foam bonding acrylic based transfer tape. 7725-55-54 – Fiber filled for ATG and narrow width slitting. 7511-80-54 – General purpose acrylic based transfer tape with some degree of repositionability.
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