

TECHNICAL BULLETIN

FILM SUPPORTED TAPE

PRODUCT:	5944M Double-Coated Polyester Film			
PRIMARY USE:	5944M is excellent for laminating to neoprene sponge rubber some PVC substrates, cork and rubber composites, and many urethane foams. This product offers the advantages of an acrylic laminating adhesive on the exposed side of a polyester film and a synthetic rubber-based adhesive on the liner side. The polyester carrier offers excellent dimensional stability for die cutting.			
DESCRIPTION:	A high tack, low shear acrylic adhesive coated on the exposed side of a ½ mil polyester film. The user side is rubber-based adhesive, exhibits excellent tack, high peel strength and moderate shear.			
LINER:	74# white poly-coated Kraft and 12pt. natural poly-coated Kraft.			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	1.5 mils	
		Adhesive Exposed Side	1.3 mils	
		Adhesive Liner Side	0.5 mils	
		74# Release Liner (nominal)	5.5 mils	
		12# Board Liner (nominal)	11.3 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>		
		Exposed Side		105 oz/inch
		Liner Side		100 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum foil <i>24 Hour Dwell:</i>		
		Exposed Side		209 oz/inch
		Liner Side		205 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) 1" x 1" x 500 gm/sq. in. @ 72° F.		
		Exposed Side		10 Hours
	Liner Side		7 Hours	

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TECHNICAL BULLETIN

5944M Double-Coated Polyester Film

GENERAL USE:	This product is engineered to bond to many foams, sponges, and rubbers.
PRODUCT FEATURES:	<ul style="list-style-type: none"> • Acrylic adhesive on exposed side allows for bonding to many types of foams. • Available in both 44" & 54" widths. • Multiple liner options.
SERVICE TEMPERATURE:	<p>30°F to 150°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 engineered for the automotive market include:</p> <p>4380M – 1.6-mils liner side & 1.9 mils exposed side. 4377M – 1.4-mils liner side & 1.3-mils exposed side. 4352M – Liner side engineered for Nylon. 4351M – 1.5-mils both liner & exposed side.</p>
SHELF LIFE:	One year from date of shipment when stored under cool, dry conditions.

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