

## TECHNICAL BULLETIN

### DOUBLE-COATED FOAM TAPE SYSTEM

PRODUCT:	6181/4281/4481		
PRIMARY USE:	For use in mounting of signs, wire clips, moldings, reflectors, molded and extruded plastics, hardware, etc. 6181, 4281, and 4481 have moderate tack and excellent shear and adhesion to most surfaces. All three products are easily die cut.		
DESCRIPTION:	<p>6181 – A 6lb. density, white closed cell, cross-linked polyethylene foam coated on both sides with the same synthetic rubber adhesive.</p> <p>4281 – A 4 lb. density, white closed cell, cross-linked polyethylene foam coated on both sides with the same synthetic rubber adhesive.</p> <p>4481 – A 4 lb. density, white closed cell, cross-linked polyethylene foam coated on both sides with the same synthetic rubber adhesive.</p> <p>6181 is available in black as product #B181. 4281 is available on special order in black as product #B281.</p>		
LINER:	60 # standard silicone treated Densified Kraft.		
TYPICAL PHYSICAL PROPERTIES:	Thickness	Liner (nominal) – all products	3.5 mils
	Peel Adhesion	PSTC #101; based on adhesives coated directly to 1 mil polyester film	
		No dwell	160 oz./inch (cohesive)
		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; Procedure A, Modified, 1000 gm/sq. in. @ 72° F, no dwell	
		Exposed Side	14+ days, no creep
Liner Side		14+ days, no creep	

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**6181/4281/4481**

<p><b>PRODUCT FEATURES:</b></p>	<ul style="list-style-type: none"> <li>. Low cost.</li> <li>. Foam carrier facilitates gap filling for bonding to irregular surfaces.</li> <li>. Excellent shear strength.</li> <li>. Closed cell foam does not absorb water.</li> <li>. Foam die-cuts cleanly and easily.</li> </ul>
<p><b>SERVICE TEMPERATURE:</b></p>	<p>30° F. – 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>
<p><b>NOTES:</b></p>	<p>Surfaces to be bonded to should be dry, clean, and free from grease and oil. These products should not be laminated to any material that contains migrating plasticizers.</p>
<p><b>RELATED ADCHEM PRODUCTS:</b></p>	<p>Other double-coated foam tape products include:</p> <p>EBT Series – Acrylic adhesive foam tapes for demanding interior and exterior applications. 74 lb poly-coated paper liner.</p> <p>GT Series – Acrylic adhesive foam tapes on 5-mil film liner used in the fenestration industry.</p> <p>HF Series – Acrylic liner side rubber exposed side foam tapes on 5-mil film liner used in fenestration industry.</p> <p>MT Series – Acrylic adhesive foam tapes for adhesion of SDL muntin bars to glass. 74lb. poly-coated paper liner.</p>
<p><b>SHELF LIFE:</b></p>	<p>One year from date of shipment when stored under cool, dry conditions.</p>

Rev. 03.06.13

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