

**TECHNICAL BULLETIN**

**TRANSFER TAPE**

PRODUCT:	<b>6403 Rubber Based Adhesive Transfer</b>		
PRIMARY USE:	6403 is a high performance, rubber-based transfer adhesive which exhibits high peel strength, and excellent initial tack and shear strength. It has excellent bonding characteristics to a wide variety of substrates.		
DESCRIPTION:	A 3-mil unsupported rubber-based adhesive system coated to a poly-coated release liner.		
LINER:	12pt natural poly-coated Kraft		
TYPICAL PHYSICAL PROPERTIES:	Thickness	Adhesive (nominal)	3.0 mil
		Liner (nominal)	11.3 mil
	Peel Adhesion	PSTC #101; backed with 1 mil polyester	
		24 Hour Dwell:	145 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum foil	
		24 Hour Dwell:	290 oz/inch
	Shear Adhesion	PSTC #107; Modified, 1000 gm/sq. in. @ 72° F.	
		No Dwell:	7 Days
		SAFT Test, ASTM D 4498-00 Modified,	
	Temperature Performance	24 Hour Dwell:	
		1" x 1" x 1000 grams	173°F (78°C)
		1" x 1" x 500 grams	191°F (88°C)
		NOTE: The SAFT temperature shown in the test report is the failure temperature as tested under the conditions of the test protocol. It is run under laboratory controlled conditions and can only be used to compare against other adhesives that are tested under identical conditions. The ASTM test method used has a certain precision and bias and the results will vary between different laboratories and between different lots of material in the same laboratory. The actual conditions in different applications will vary and therefore this temperature is not an indicator of the maximum service temperature of the product. Adchem disclaims any liability resulting from any legal cause of action related to dependence on the published SAFT values under actual use conditions.	

**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**

**6403**

SERVICE TEMPERATURE:	30°F to 150°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. 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.
GENERAL USE:	This product is designed for general purpose bonding especially to foam materials and other low energy surface substrates.
RELATED ADCHEM PRODUCTS:	Economical Transfer Tape. 12-pt. board release liner for die cutting and kiss cutting. High Peel Strength.
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.