

**TECHNICAL BULLETIN**

**TRANSFER TAPE**

PRODUCT:	<b>6405 Rubber Based Adhesive Transfer</b>			
PRIMARY USE:	6405 is a high performance, rubber-based transfer adhesive which exhibits high peel strength, and excellent initial tack and shear strength. It bonds to a wide variety of substrates especially to foam materials and low energy surfaces.			
DESCRIPTION:	A 5-mil unsupported rubber based adhesive system coated to a 12-point board.			
LINER:	12pt natural poly-coated Kraft.			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Adhesive Exposed Side (nominal)	5.0 mil	
		12pt Release Liner (nominal)	11.3 mil	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>		
		Exposed Side		185 oz/inch
		Liner Side		
		PSTC #101; backed with 2 mil dead soft aluminum foil <i>24 Hour Dwell:</i>		
		Exposed Side		330 oz/inch
		Liner Side		
	Shear Adhesion	PSTC #107; Modified, 1000 gm/sq. in. @ 72° F. <i>No Dwell:</i>		
		Exposed Side		7 Days
		Liner Side		NA
Loop Tack	PSTC-16;		240 oz./in. width	
PRODUCT FEATURES:	<ul style="list-style-type: none"> <li>• Aggressive high caliper transfer tape with good internal strength.</li> <li>• 12-pt. board release liner for die cutting and kiss cutting.</li> <li>• High peel strength.</li> <li>• Also available in a 3-mil caliper transfer tape as 6403-12pt and as a double coated tape as 4787M-74.</li> </ul>			

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**6405-12PT-54 Transfer Tape**

FOAM BONDING STUDIES:		7 DAYS @ 72°F	7 DAYS @ 120°F															
	PVN (SKIN)	EXCELLENT	EXCELLENT															
	PVN (SKIVED)	EXCELLENT	EXCELLENT															
	PORON	EXCELLENT	EXCELLENT															
	ESTER	EXCELLENT	EXCELLENT															
	ETHER	EXCELLENT	EXCELLENT															
	XLPE	GOOD	VERY GOOD*															
* Strong bond but no Foam Tear																		
LSE BONDING STUDIES:	<table border="1"> <tr> <td></td> <td></td> <td>24 hr Dwell @ RT</td> </tr> <tr> <td>180° PEEL</td> <td>TFPP:</td> <td>160+ COH</td> </tr> <tr> <td>oz/inch width</td> <td>NYLON:</td> <td>160+ COH</td> </tr> <tr> <td></td> <td>ABS:</td> <td>160+ COH</td> </tr> <tr> <td colspan="3">COH = Cohesive Failure</td> </tr> </table>					24 hr Dwell @ RT	180° PEEL	TFPP:	160+ COH	oz/inch width	NYLON:	160+ COH		ABS:	160+ COH	COH = Cohesive Failure		
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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:	<p>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.</p>																	
SHELF LIFE:	<p>One year from date of shipment when stored under cool, dry conditions.</p>																	

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