

**TECHNICAL BULLETIN**

**TRANSFER TAPE**

PRODUCT:	<b>7603-PET Acrylic Adhesive Transfer Tape</b>			
GENERAL USE:	For bonding to cast vinyl, vinyl foams, vinyl-coated fabrics, and other plasticized materials used in sound damping, marking and construction applications. Bonds urethane foam to embossed vinyl for headliner applications.			
DESCRIPTION:	A 3-mil film acrylic adhesive cast onto a PET release liner. 7603 is a moderate tack product which develops a strong bond to a variety of substrates at room temperature. It exhibits excellent resistance to materials containing plasticizers such as vinyl products used in flooring, wall coverings, synthetic leather, and banner stock. 7603-PET exhibits some short-term repositionability.			
LINER:	2-mil clear polyester film liner			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Adhesive Exposed Side (nominal)	3.0 mils	
		Adhesive Liner Side (nominal)	NA	
		PET Release Liner (nominal)	2.0 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>		
		Exposed Side		50 oz/inch
		Liner Side		NA
		PSTC #101; backed with 2 mil dead soft aluminum foil <i>24 Hour Dwell:</i>		
		Exposed Side		150 oz/inch
		Liner Side		NA
	Shear Adhesion	PSTC #107; Modified, 1000 gm/sq. in. @ 72° F. <i>One Minute Maximum Dwell:</i>		
		Exposed Side		168 Hours
		Liner Side		NA
		PSTC #107, Modified; 1000 gm/sq. in. @ 150°F <i>One Minute Maximum Dwell:</i>		
		Exposed Side		18 Hours
		Liner Side		NA

**ADCHEM CORPORATION**

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**7603-PET Adhesive Transfer Tape**

METHOD OF APPLICATION:	<p>INITIAL LAMINATION:</p> <p>Laminate adhesive film to substrate with a firm even pressure, preferably through a nip roller. Be sure laminating surface is clean, dry, and free from grease and oil.</p> <p>FINAL ASSEMBLY:</p> <p>Bond initial laminate to final assembly with firm even pressure. Surface to be bonded should be clean, dry and free from grease and oil.</p> <p>NOTE: Ultimate bond strength with increased temperature and solvent resistance may be accelerated by the use of heat, e.g.: 225°F with a 5 second dwell time.</p>
PRODUCT FEATURES:	<ul style="list-style-type: none"> <li>• Low to moderate tack 3 mil adhesive.</li> <li>• Bonds well to variety of substrates most notably, highly plasticized materials.</li> <li>• Excellent peel and shear properties.</li> <li>• Polyester liner for improved die cutting, kiss cutting and removing.</li> </ul>
NOTES:	<p>In controlled lab testing 7603 has shown better resistance than other acrylic and rubber-based systems to monomeric plasticized vinyl films. However, commercially available flexible vinyl films can differ in composition from the films used in the controlled testing. Therefore Adchem disclaims liability under actual use conditions and suggests that the adhesive be tested and approved under actual use conditions by the end user.</p>
SERVICE TEMPERATURE:	<p>-30°F to 220°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.</p>
SHELF LIFE:	<p>One year from date of shipment when stored under cool, dry conditions.</p>

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