

TECHNICAL BULLETIN

TRANSFER TAPE

PRODUCT:	7854 Adhesive Transfer Tape		
PRIMARY USE:	Engineered for bonding to TPO and PVC foam. Forms excellent bonds to a variety of substances including solid and foamed synthetic rubbers. Suitable for low energy substrates such as powder-coated surfaces.		
DESCRIPTION:	7854 is a 4-mil high tack and moderate shear acrylic adhesive.		
LINER:	12 pt Natural Poly-coated Board		
TYPICAL PHYSICAL PROPERTIES:	Thickness	Adhesive Exposed Side (nominal)	4.0 mils
		Adhesive Liner Side (nominal)	NA
		12pt Natural Poly-coated Board (7854-12pt-54)	11 mils
		PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>	
	Peel Adhesion	Exposed Side	110 oz/inch
		Liner Side	NA
		PSTC #101; backed with 2 mil dead soft aluminum foil <i>24 Hour Dwell:</i>	
		Exposed Side	215 oz/inch
		Liner Side	NA
		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; Modified, 1000 gm/sq. in. @ 72° F. <i>No Dwell:</i>	
		Exposed Side	24 Hours
		Liner Side	NA
	Loop Tack	PSTC-16;	
		Exposed Side	160 oz/inch
		Liner Side	NA

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7854 Adhesive Transfer Tape

<p>PRODUCT FEATURES:</p>	<ul style="list-style-type: none"> • Excellent adhesion to a broad spectrum of substrates. • High bond strength to TPO, PVC Foams, and powder-coated surfaces. • Aggressive high tack adhesive. • Moderate shear resistance. • Two release liner options.
<p>SERVICE TEMPERATURE:</p>	<p>0°F to 180°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>NOTES:</p>	<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>
<p>RELATED ADCHEM PRODUCTS:</p>	<p>Other 4-mil acrylic transfer tapes include: 7334 – Moderate tack and peel, general purpose.</p>
<p>SHELF LIFE:</p>	<p>One year from date of shipment when stored under cool, dry conditions.</p>

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