

TECHNICAL BULLETIN

TRANSFER TAPE

PRODUCT:	9728 Medical Grade Acrylic Transfer Tape			
PRIMARY USE:	9728 has a broad range of bonding ability to a variety of substrates at room temperature: films, foams, and fabrics and it bonds well to skin.			
DESCRIPTION:	A 2 mil high-tack, unsupported acrylic, permanent pressure sensitive film cast on a paper release liner.			
LINER:	80# white Densified Kraft			
BIOLOGICAL PROPERTIES:	<p>NO CYTOTOXICITY* NON-IRRITATING* HYPOALLERGENIC*</p> <p>*Adchem's suppliers have provided information on adhesives used for skin contact that have been tested per the guidelines for cytotoxicity; skin irritation and sensitization as provided in ISO 10993. These test results suggest a positive outcome for skin contact applications, but it is device manufacturer's responsibility to test the finished article to the relevant sections of ISO10993 applicable to medical device.</p>			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Adhesive Exposed Side (nominal)	2 mils	
		Liner (nominal)	4.0 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester		
		Initial	40 oz/inch width	
		24 hour dwell	60 oz/inch width	
		PSTC #101; backed with 4 mil dead soft aluminum foil		
		Initial	72 oz/inch width	
		24 hour dwell	88 0z/inch width	
	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, 250 gm/sq. in @ 72°F		7+ Days
		@ 120°F		3+ Days
@158°F		2+ Days		

ADCHEM CORPORATION
1852 Old Country Road
Riverhead, NY 11901
P: 631-727-6000
www.adchem.com

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METHOD OF APPLICATION:	<p>Initial Lamination: Laminate adhesive film to substrate with firm, even pressure, preferably through a pressure roller. Laminating surface must be clean, dry, and free from grease and oil.</p> <p>Final Assembly: Bond initial laminate to final assembly with firm even pressure. Surface must be clean, dry, and free from grease and oil.</p> <p>Note: Ultimate bond strength may be accelerated by the use of heat e.g. 150-200°F with a 5 second dwell time.</p>
PRODUCT FEATURES:	<ul style="list-style-type: none"> . Smooth 2-mil adhesive. . Bonds well to variety of substrates. . Excellent peel and shear properties. . Hypoallergenic.
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>
RELATED ADCHEM PRODUCTS:	<p>9730: 3-mil medical grade acrylic transfer tape</p>
SHELF LIFE:	<p>One year from date of shipment when stored under cool, dry conditions.</p>

Rev. 04.04.14

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