

TECHNICAL BULLETIN

FILM SUPPORTED TAPE

PRODUCT:	4373M-12pt-54 Double-Coated Polyester Film			
PRIMARY USE:	Forms excellent bonds to a wide variety of ether, ester and low perm urethane foams. Additional utility is found when bonding to closed-cell sponges. The product's polyester carrier provides dimensional stability in die cutting operations.			
DESCRIPTION:	<p>Liner Side Adhesive: 4373M uses an acrylic adhesive that exhibits outstanding shear and heat resistance properties in addition to forming excellent bonds to a wide variety of substrates.</p> <p>Exposed Side Adhesive: 4373M uses an acrylic adhesive that exhibits excellent bonds to most polyether and polyester urethane foams. Bond to foam will be enhanced with longer residence times and laminating pressure. Can be effective in foam applications where higher foam bond stress is required.</p> <p>Both the exposed and liner side adhesives have a biostatic additive which retards microbial growth. The product's 12pt board stock allows easy removal of kiss cut parts.</p>			
LINER:	12pt. Board			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	0.5 mils	
		Adhesive Exposed Side (nominal)	1.5 mils	
		Adhesive Liner Side (nominal)	1.5 mils	
		12pt Natural Poly-coated Kraft Release Liner	11.3 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>		
		Exposed Side		60 oz/inch
		Liner Side		65 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum foil <i>24 Hour Dwell:</i>		
		Exposed Side		150 oz/inch
		Liner Side		160 oz/inch
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.				

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TYPICAL PHYSICAL PROPERTIES: (Cont.)	Shear Adhesion	PSTC #107; Modified, 1000 gm/sq. inch @ 72° F.	
		Exposed Side	168 Hours
		Liner Side	168 Hours
		PSTC #107, Modified; 1000 gm/sq. inch @ 120°F	
		Exposed Side	168 Hours
		Liner Side	168 Hours
		PSTC #107, Modified; 1000 gm/sq. inch @ 150°F	
		Exposed Side	168 Hours
		Liner Side	30 Hours
		PSTC #107, Modified; 1000 gm/sq. inch @ 200°F	
		Exposed Side	5 Hours
Liner Side	1 Hours		
GENERAL USE:	4373 is used in the seal and gasket market and for foams and other materials in the sound attenuation and automotive market. It's elevated temperature resistance makes it ideal for automotive under-hood applications or other high heat environments. Tested and approved to Delphi Automotive SD2-324 for High Temperature Permanent Bonds to 250°F, 4373 and 4374 are also qualified under several automotive specifications (refer to the Supplemental Product Information Bulletin).		
PRODUCT FEATURES:	<ul style="list-style-type: none"> • Excellent adhesion to a broad spectrum of foam substrates. • High tack, high adhesion acrylic adhesive. • High heat resistance. • Biostatic additive inhibits microbial growth. • Two liner options available. 		
	-30°F to 250°F		
SERVICE TEMPERATURE:	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.		
SHELF LIFE:	One year from date of shipment when stored under cool, dry conditions.		

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