

**TECHNICAL BULLETIN**

**TRANSFER TAPE**

PRODUCT:	<b>7511 Adhesive Transfer Tape</b>		
DESCRIPTION:	An unsupported, permanent acrylic pressure-sensitive film cast on a silicone release liner. Ultra-violet has little or no effect on this film adhesive. Initial tack is low enough to permit some repositionability. This product exhibits high ultimate bonds and has excellent shear and cohesive strength. Adhesion builds with time.		
LINER:	80# white Densified Kraft and 12pt natural poly-coated Kraft		
TYPICAL PHYSICAL PROPERTIES:	Thickness	Adhesive Exposed Side (nominal)	5.0 mils
		Release Liner (nominal for 80#)	4.0 mils
	Peel Adhesion	Release Liner (nominal for 12pt board)	11.3 mils
		PSTC #101; backed with 1 mil polyester	60 oz/inch
		<i>Initial</i>	75 oz/inch
		<i>24 Hour Dwell</i>	80 oz/inch
		<i>7 Day Dwell</i>	
		PSTC #101; backed with 2 mil dead soft aluminum foil	150 oz/inch
		<i>Initial</i>	175 oz/inch
		<i>24 Hour Dwell</i>	
	Shear Adhesion	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.	
		PSTC #107, Modified for weight & temperature; 500 gm/sq. in. <i>15 Minute Dwell:</i>	
		@ Room Temperature	7 Days
@ 158° F		7 Days	
GENERAL USE:	Applications where a high coat weight of an acrylic adhesive is needed for bonding metal and plastic nameplates as well as for joining dissimilar materials where long aging, UV and environmental resistance is needed. Excellent product for bonding rough, irregular or cellular products, i.e. foams, fabrics, embossed metals, and plastics. Ultimate adhesion to most surfaces is excellent. Recommended for use on enamel, metal, glass, wood and a variety of plastics. The use of heat and pressure will help increase the initial bond of 7511 to the substrate. Surfaces to be bonded should be clean, dry, and free of grease, oil, or other foreign matter that will interfere with the bond.		

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PRODUCT FEATURES:	<ul style="list-style-type: none"> <li>• Excellent Shear.</li> <li>• Die cuts cleanly.</li> <li>• Bonds well to most foam products.</li> <li>• Good service temperature.</li> <li>• Multiple liner options.</li> </ul>
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>Other 5-mil acrylic transfer tape products include:</p> <p>4628 – For foam bonding on 80# liner.</p> <p>7335-74 – General purpose bonding.</p> <p>7745-74 – High performance fiber-filled.</p>
SHELF LIFE:	<p>One year from date of shipment when stored under cool, dry conditions.</p>

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