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Adchem adhesive systems (see chart below) backed with 1 mil PET (liner-side for double-coated products) and trimmed to 1" width for testing. Adhesive systems applied to customer supplied PORON® foams (2 sets) with 50% compression. One set laminated at Room Temperature and the second set laminated @ 210°F roller temperature. Both sets dwelled for 5 days at Room Temperature and subjectively evaluated and further conditioned for 4 days at 120°F and 24 hours at Room Temperature and subjectively evaluated for bond strength.

SUBJECTIVE RATING SYSTEM

EXCELLENT [E] – Complete foam destructive bond and/or substantial force required to remove adhesive from material.

VERY GOOD [VG] – Substantial destruction to surface of foam material and/or significant force required to remove adhesive from material.

GOOD [G] – Partially destructive foam bond and/or moderate force required to remove adhesive from material.

FAIR [F] – Non-destructive bond to foam material but moderate force required to remove adhesive.

POOR [P] – No bond development to foam. Adhesive not recommended.

LEGGING [L] – Softening of adhesive causes "strings" of adhesive between tape and substrate upon removal.

OUTGASSING [O] – Development of bubbles. Very small to large, in the adhesive from contact and interaction with a substrate.

Data presented are typical properties taken from a limited number of production runs, and should not be used for specification purposes. Adchem Corporation makes no warranty expressed or implied, and specifically disclaims and disavows any implied warranty or merchantability and of fitness for a particular purpose. Adchem also is not responsible for formulation changes in products that could impact the bonding ability of the Adchem materials tested. Accordingly, all Adchem products are sold with the understanding that purchasers will be solely responsible for determining the suitability of the materials for any purpose."

Results: 5 DAYS @ ROOM TEMPERATURE

Adchem Product	PORON® FOAMS													
	4701-30-15250-04		4701-40-15250-04		4701-41-15250-04		4701-50-15250-04		4701-60-15250-04		4790-79-15250-04		4790-92-15250-04	
	W/HEAT	W/OUT	W/HEAT	W/OUT	W/HEAT	W/OUT	W/HEAT	W/OUT	W/HEAT	W/OUT	W/HEAT	W/OUT	W/HEAT	W/OUT
652	E	E	E	E	E	E	E	E	E	E	E	E	E	E
653	E	E	E	E	E	E	E	E	E	E	E	E	E	E
655	E	E	E	E	E	E	E	E	E	E	E	E	E	E
7832	E	E	E	E	E	E	E	E	E	E	P	P	E	E
7834	E	E	E	E	E	E	E	E	E	E	F	F	E	E
254M	E	E	E	E	F	P	P	P	P	P	P	P	E	E
256M	E	E	E	E	G	P	P	P	P	P	P	P	E	E
4377M	E	E	E	E	E	E	E	F	E	E	F	P	E	E
4380M	E	E	E	E	E	E	E	F	E	E	F	P	E	E
5000M	E	E	E	E	E	E	E	P	P	P	P	P	E	E
5944M	E	E	E	E	E	E	VG	F	P	P	F	P	E	E
654M	E	E	E	E	E	E	E	E	E	E	E	P	E	E

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Results: 5 DAYS @ ROOM TEMPERATURE & 4 DAYS @ 120°F & 24 HOURS @ ROOM TEMPERATURE

Adchem Product	PORON® FOAMS													
	4701-30-15250-04		4701-40-15250-04		4701-41-15250-04		4701-50-15250-04		4701-60-15250-04		4790-79-15250-04		4790-92-15250-04	
	W/HEAT	W/OUT	W/HEAT	W/OUT	W/HEAT	W/OUT	W/HEAT	W/OUT	W/HEAT	W/OUT	W/HEAT	W/OUT	W/HEAT	W/OUT
652	E	E	E	E	E	E	E	E	E	E	E	E	E	E
653	E	E	E	E	E	E	E	E	E	E	E	E	E	E
655	E	E	E	E	E	E	E	E	E	E	E	E	E	E
7832	E	E	E	E	E	E	E	E	E	E	VG	P	E	E
7834	E	E	E	E	E	E	E	E	E	E	E	F	E	E
254M	E	E	E	E	E	E	F	G	P	F	F	P	E	E
256M	E	E	E	E	E	E	G	G	F	P	VG	P	E	E
4377M	E	E	E	E	E	E	E	E	E	E	F	F	E	E
4380M	E	E	E	E	E	E	E	E	E	E	F	F	E	E
5000M	E	E	E	E	E+	E	E+	E	P+	F	E	G	E	E
5944M	E	E	E	E	E	E	VG	E	P	VG	E	F	E	E
654M	E	E	E	E	E	E	E	E	E	E	E	E	E	E

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