

## SUBJECTIVE BONDING STUDY

### PRODUCTS TESTED

#### Fostek EPDM Rubber Products

- 2996N.3149 – Supersoft, Semi-Closed Cellular Rubber [EPDM SKIN/ SKIN]
- 3996.3.315 – Ultra Soft, Semi-Closed Cellular Rubber [SKIN/ SKIN]
- 3996.3.50 – Ultra Soft, Semi-Closed Cellular Rubber [SKIN/ SKIVE; Tested Both Sides]
- 3996.3.3543 – Ultra Soft, Semi-Closed Cellular Rubber [SKIN/ SKIN]
- Fostek Crushed EPDM (5MM) [SKIN/ SKIVE; Tested Both Sides]

### SETUP AND TESTING

Adhesive systems evaluated were backed with 1 mil PET film (liner-side for double-coated products) and trimmed to 1 inch width. 2 sample sets were laminated to customer-supplied materials using ~50% compression; one set laminated at Room Temperature, a second set was laminated using 140° F. Heat Assist. All samples were conditioned for 7 days at room temperature and evaluated. Samples further conditioned for 7 days @ 140°F and 5 days at Room Temperature and evaluated.

### SUBJECTIVE RATING SYSTEM

- EXCELLENT:** Completely destructive bond and/or substantial force required to remove adhesive from material.
- VERY GOOD:** Substantial Destruction to surface of material and/or significant force required to remove adhesive from material.
- GOOD:** Partially destructive bond and/or moderate force required to remove adhesive from material.
- FAIR:** Non-destructive bond to material but moderate force required to remove adhesive

### SYMBOLS

HEAT ASSIST NECESSARY	Δ Bond demonstrated improvement after accelerated aging noted (time and temp)
HEAT ASSIST BENEFICIAL	D Discoloration of adhesive noted after accelerated aging noted
S Indicates Product Series	OG Outgassing
LAM Lamination Temperature	L- Minor Legging      L Moderate Legging      L+ Major Legging
RT Room Temperature	

Foam Bonding evaluations are affected by foam thickness and integrity. Adhesion to foam and rubber products are affected by factors including material thickness and density, lamination speed, temperature, and compression. Bond strength observed immediately after lamination is often not a reliable indicator of long term adhesion or compatibility. Results being provided as a guide to product selection; products should be thoroughly tested to application materials applied using intended production equipment and practices and evaluated in conditions reflecting intended use.

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



MAT'L	2996N.3149	3996.3.315	3996.3.50		3996.3.3543	FOSTEK CRUSHED EPDM (5MM)		
			[TEST TO SKIN SIDE]	[TEST TO SKIVE SIDE]		[TEST TO SKIN SIDE]	[TEST TO SKIVE SIDE]	
SUBJECTIVE RATING	EXCELLENT	1132S	1132S 4787M	7744	1132S 3175M 5000M 4787M			
	VERY GOOD	1142S L 3175M 5000M 33M7H	1132S 3175M 4787M 5000M 5008B 7336A 33M7H	3175M 5000M 7336A	2016M Δ 554M Δ 655 Δ 700 S Δ 754 S	5008B 7744	1132S L 4787M 5008B	2016M 554M 5008B 655 7744
	GOOD	4787M 7336A	1142S L	1142S L 5008B L 754 S 7744 33M7H	256M Δ 4787M Δ 5008B 654M Δ 654T Δ 653 Δ	1142S L 554M L 7336A 754 L	1142S L 2237M	1132S 2237M 652, 653, 654M, 654T 700 S 754 S 33M7H
	FAIR	5008B L 754 S 7744	700 S 7744		1132S 1142S L 254M Δ 3175M Δ 353M 5000M Δ	2016M 33M7H	3175M 5000M 7324 7336A 7744 33M7H	1142S L 5944M 7324M 7511 3000-2

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