

**TECHNICAL BULLETIN**

**FILM SUPPORTED TAPE**

PRODUCT:	<b>353M Double-Coated Polyester Film</b>			
PRIMARY USE:	353M exhibits excellent adhesion to a wide variety of substrates. 353M has very good foam lamination properties and good lamination to fabricated parts.			
DESCRIPTION:	A high-peel, high-tack, moderate shear acrylic adhesive film coated on both sides of a high quality polyester film.			
LINER:	74 lb. white poly-coated Kraft; 12-pt board			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier (nominal)	0.5 mils	
		Adhesive Exposed Side (nominal)	1.7 mils	
		Adhesive Liner Side (nominal)	1.3 mils	
		74# Release Liner (nominal)	5.5 mils	
		12-pt Board Liner (nominal)	11.3 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour dwell:</i>		
		Exposed Side		99 oz/inch
		Liner Side		94 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum foil <i>24 Hour dwell:</i>		
		Exposed Side		220 oz/inch
		Liner Side		210 oz/inch
	Shear Adhesion	PSTC #107; Modified, 1000 gm/sq. in. @ 72° F <i>One minute maximum dwell time:</i>		
		Exposed Side		4 Days
		Liner Side		7 Days
GENERAL USE:	For bonding and laminating to a wide variety of urethane foams including polyether, polyester and low perm foams. For bonding and laminating to a wide variety of cloths, vinyl's, corks, papers, rigid and flexible plastics.			

**ADCHEM CORPORATION**

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**353M Double-Coated Polyester Film**

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<p>PRODUCT FEATURES:</p>	<ul style="list-style-type: none"> <li>• Excellent peel properties.</li> <li>• Excellent tack.</li> <li>• Die cuts cleanly.</li> <li>• Bonds well to most surfaces.</li> </ul>																																								
<p>SERVICE TEMPERATURE:</p>	<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>																																								
<p>ADHESION TO OTHER SUBSTRATES:</p>	<table border="1"> <thead> <tr> <th></th> <th>exposed</th> <th>liner</th> </tr> </thead> <tbody> <tr> <td colspan="3">IMMEDIATE PEEL, oz/in. width</td> </tr> <tr> <td>S. S. Average</td> <td>72</td> <td>64</td> </tr> <tr> <td>ABS Average</td> <td>50</td> <td>50</td> </tr> <tr> <td>HDPE Average</td> <td>38</td> <td>42</td> </tr> <tr> <td>PP Average</td> <td>75</td> <td>72</td> </tr> <tr> <td>TFPP Average</td> <td>43</td> <td>42</td> </tr> <tr> <td colspan="3">Peel after 24 hr dwell, oz/in. width</td> </tr> <tr> <td>S.S. Average</td> <td>90</td> <td>84</td> </tr> <tr> <td>ABS Average</td> <td>57</td> <td>52</td> </tr> <tr> <td>HDPE Average</td> <td>40</td> <td>41</td> </tr> <tr> <td>PP Average</td> <td>86</td> <td>85</td> </tr> <tr> <td>TFPP Average</td> <td>72</td> <td>72</td> </tr> </tbody> </table>		exposed	liner	IMMEDIATE PEEL, oz/in. width			S. S. Average	72	64	ABS Average	50	50	HDPE Average	38	42	PP Average	75	72	TFPP Average	43	42	Peel after 24 hr dwell, oz/in. width			S.S. Average	90	84	ABS Average	57	52	HDPE Average	40	41	PP Average	86	85	TFPP Average	72	72	<p>NOTE: The use of heat and pressure will help to increase the initial bond of the product to the substrate. Surfaces to be bonded to should be clean, dry and free from grease and oil. This product should not be laminated to any material that contains migrating plasticizers.</p>
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<p>SHELF LIFE:</p>	<p>One year from date of shipment when stored under cool, dry conditions.</p>																																								

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