



# Membrane Switch Spacer/Data Page

FOD # 0922

## Scotch™ 7965MP Double Lined Laminating Adhesive

### Description

Liner: 86# Polycoated Kraft  
Adhesive: #200 “Hi-Performance” Acrylic  
Liner: 58# Polycoated Kraft

### Typical Applications

Attachment of graphic overlay to membrane switch or keyboard.  
Attachment of membrane switch to product housing.  
Lamination to polyester for membrane spacers.

### Features

- Long term environmentally stable bond.
- Smooth adhesive for high quality appearance on thin graphic overlays.
- High cohesive strength to withstand repeated stresses from switch activation.
- High temperature, humidity, and chemical resistance.
- Lay-flat liner provides greater stiffness and rigidity.
- Thick adhesive provides higher bond strength on rough or smooth surfaces.

<u>Component</u>	<u>Description</u>	<u>Appropriate Thickness</u>	
		<u>Inches</u>	<u>(MM)</u>
Release Liner	86# Polycoated Kraft	0.0065	0.165
Adhesive	#200 “Hi-Performance” Acrylic	0.005	0.127
Release Liner	58# Polycoated Kraft	0.004	0.10
	Total	0.0155	0.392



## Adhesion Properties

The results indicated are typical values.

	7965MP			
	<u>OZ/IN</u>		<u>N/100 mm</u>	
ASTM D903 180 degree peel 12"/minute 1 mil polyester to stainless steel	87		96	
3M test 90% peel 12"/minute 8 mil aluminum to various surfaces	72 Hour Dwell		Ultimate Bond	
	<u>OZ/IN</u>	<u>N/100 mm</u>	<u>OZ/IN</u>	<u>N/100 mm</u>
Stainless Steel	164	180	244	270
Epoxy	156	172	214	236
Polyester	128	142	142	156
Polycarbonate	170	188	198	218
ABS	174	190	134	146

## Application Techniques

1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact and thus improves bond strength.
2. To obtain optimum adhesion, the bonding surfaces must be clean, dry, and smooth. Some typical surface cleaning solvents are isopropyl alcohol or heptane. Use proper safety precautions for handling solvents.
3. Ideal tape application temperature range is 70 degrees F. to 100 degrees F. (21 degrees C. to 38 degrees C.). Initial tape application to surfaces at temperatures below 50 degrees F. (10 degrees C.) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

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