



Laminating Adhesives/Data Page

FOD # 0911

Scotch™ 919 Laminating Adhesive Tape

Description:

Scotch 919 is a 5 mil reinforced synthetic adhesive developed for the nameplate industry. The adhesive formula is ideal for bonding to plastic surfaces.

Features:

- Synthetic Rubber Adhesive High initial adhesion
High tear resistance
Low odor
Excellent bond to plastics
- Poly coated liner Moisture stable to resist wrinkling

Product Specifications:

	<u>Product Description</u>	<u>Approximate Thickness</u>	
		<u>Inches</u>	<u>(mm)</u>
Adhesive:	#700 "Hi-Bond" Synthetic Rubber	0.005	(0.125)
Liner:	65# Poly Coated Kraft	0.0042	(0.11)
	Total Thickness:	0.0092	(0.235)

Properties and Performance:

Adhesion – 90° peel adhesion

Laminated to 0.008" aluminum strip, peeled at 12"/min. (305 mm/min)

	<u>Typical Value</u> <u>(260N/100 mm)</u>
Aluminum	15#/in.
Painted Metal	15#/in.
Stainless Steel	15#/in.
ABS	15#/in.
UPVC*	15#/in.
Polypropylene	15#/in.
Polyethylene	15#/in.

*Unplasticized vinyl

1. Scotch 919 is used in the nameplate industry for bonding metal nameplates to plastic surfaces.
2. Shelf life of roll tape is excellent. It is warranted for one year from date of purchase.
3. Liner removal is easy. When the tape is properly applied to clean, dry, smooth surfaces, the liner will release easily.
4. Bond strength can be improved by thoroughly cleaning and drying the surfaces to be joined. The typical cleaning solvent is heptane or isopropyl alcohol.
5. Bond strength can be improved with firm application pressure to develop intimate contact of adhesive to the bonding surfaces.
6. Scotch 919 can be used in applications that require high shear strength at normal room temperature conditions.
7. This adhesive is ideal for most indoor applications and can be used outdoors if the adhesive is not exposed directly to environment. The adhesive will discolor (yellowish) when exposed to direct U.V. light.
8. The temperature resistance is somewhat lower than our typical acrylics: therefore, temperatures over 200° F. (93°C.) should be avoided.
9. Avoid contact with plasticized vinyl or plasticized rubber surfaces. Plasticizers will soften the rubber adhesive.
10. The low odor adhesive is ideal for special applications inside refrigerators.

Applications:

Scotch 919 bonds nameplates and decorative trim to low surface energy plastics like polyethylene and polypropylene. (Also consider the #300 type acrylic adhesive for applications which require the features of acrylic adhesives.)

4/1/96

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