Laminating Adhesives/Data Page

FOD # 0089

Scotch™ 9692 Laminating Adhesive
9695 Laminating Adhesive

Product Construction

Product	Adhesive	Liner
9692	2.0 mil (51 microns) #300MP “Hi-Strength” Acrylic Adhesive	6.5 mil (165 microns) 86# Polycoated Kraft
9695	5.0 mil (127 microns) #300MP “Hi-Strength” Acrylic Adhesive	6.5 mil (165 microns) 86# Polycoated Kraft

- #300MP “Hi-Strength” acrylic adhesive is very smooth and is suitable for bonding to most surfaces, including low surface energy plastics.
- 86# polycoated kraft liner improves lay-flat processing of plastic graphic overlays and foam fabricated parts.
- 86# polycoated kraft liner allows die-cutting of end tabs and multiple parts on a common carrier.

Applications

- Fabricated foam parts to contoured surfaces.
- Plastic nameplates or graphic overlays for use on low surface energy (LSE) plastics.
- Multiple die-cut parts on a common sheet for ease of application.
- Fabricated parts with end tabs for easy liner removal.
- Graphic or fabricated parts to surfaces such as wood, fabric, plastic, rubber and textured materials.

Physical Properties

(Typical values – not for specification use)

ASTM D-3330 (modified) 90 degree peel, 12 in./min. (305mm/min.) 2 mil aluminum foil

		20 Minute Dwell	
Surface	**Product**	**Oz./In.**	**N/100 mm**
Stainless Steel	9692	31	34
	9695	48	52

		3 Days at Room Temperature		3 Days at 158 Degrees F	
Surface	**Product**	**Oz./In.**	**N/100 mm**	**Oz./In.**	**N/100 mm**
Stainless Steel	9692	46	50	89	97
	9695	113	124	127	139
Aluminum	9692	55	60	90	98
	9695	83	91	100	109
Polycarbonate	9692	48	52	27	30
	9695	72	79	33	36
Polypropylene	9692	29	32	29	32
	9695	46	50	39	43

Environmental Performance

The properties defined are based on the attachment of impervious materials (such as aluminum) to an aluminum test surface.

Bond Build-up:	The bond strength of #300MP "Hi-Strength" acrylic adhesive increases as a function of time and temperature and has very high initial adhesion.
Humidity Resistance:	High humidity has minimal effect on adhesive performance. Bond strengths are generally higher after exposure for 7 days at 90 degrees F (32 degrees C) and 90% relative humidity.
Water Resistance:	Immersion in water has no appreciable effect on the bond strength. After 100 hours at room temperature, the bond actually shows an increase in strength.
Temperature Cycling Resistance:	Bond strength generally increases after cycling four times through: 4 hours at 158 degrees F (70 degrees C) 4 hours at –20 degrees F (–29 degrees C) 16 hours at 73 degrees F (22 degrees C)
Chemical Resistance:	When properly applied, nameplate and decorative trim parts attached with #300MP adhesive will hold securely after exposure to numerous chemicals including oil, mild acids and alkalis.
Heat Resistance:	The #300MP adhesive is usable for short periods (minutes, hours) at temperatures up to 250 degrees F (121 degrees C) and for intermittent longer periods of time (days, weeks) up to 150 degrees F (66 degrees C).
Shelf Life:	Product retains its performance and properties for one year from date of purchase if properly stored at room temperature conditions of 72 degrees F (22 degrees C) and 50% relative humidity. Storage in plastic bag is recommended.

Special Considerations

For maximum bond strength the surface should be thoroughly cleaned and dried. Typical cleaning solvents are heptane or isopropyl alcohol. Consult manufacturer's Material Safety Data Sheet for proper handling and storage instructions.

Bond strength also can be improved by applying firm pressure and moderate heat, from 100 degrees F (38 degrees C) to 130 degrees F (54 degrees C), which causes the adhesive to develop intimate contact with the bonding surface.

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