



Laminating Adhesives/Data Page

FOD # 0190

Scotch™ 9784 Laminating Adhesive

Product Construction

Liner:	4.0 mils	(102 microns)	58# Polycoated Kraft
Adhesive:	4.0 mils	(102 microns)	#300MP “Hi-Strength” Acrylic
Liner:	3.0 mils	(76 microns)	High Density Polyethylene

Features

- Very smooth adhesive
- High Bond to plastics
- HDPE Liner for
 1. See-through inspection
 2. One-piece removal
- Meets automotive specifications

Applications

- Automotive backlit graphic panels
- Graphic panels with intricate die cutting
- Embossed or formed nameplates being bonded to plastic

Physical Properties

(Typical values – not for specification use)

Initial Adhesion:	<u>Surface</u>	<u>Oz./In.</u>	<u>N/100 mm</u>
Dynamic Peel, ASTM D3330 Modified (90 degree peel), 20 minute dwell, 12"/min. (305mm/min.) (2 mil aluminum backing)	Stainless Steel	45	49
	Aluminum	65	71
	Polycarbonate	53	58
	Polypropylene	41	45

Environmental Performance

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

Bond Build-up:	The bond strength of Scotch #300MP “Hi-Strength” Acrylic adhesive increases as a function of time and temperature.
Chemical Resistance:	Very good resistance to gasoline, oil, sodium chloride solution and mild acids and alkalies.
Water. Resistance:	Immersion in water has no appreciable effect on the bond strength.
Shelf Life:	Scotch 9784 Laminating Adhesive can be certified to retain adhesive properties for one year from date of purchase if properly stored at normal room temperature conditions of 72 F (22 C) and 50% relative humidity.

Special Considerations/Application Tips

General:	<p>Proper preparation of application surfaces is essential to assure high quality, long lasting applications of Scotch #300MP “Hi-Strength” Acrylic Laminating Adhesives.</p> <p>Assume all surfaces to which the laminating adhesive will be applied are contaminated – metals may be oily or dusty, plastics may be coated with mold release agents, dirt, etc. Any surface contaminant will adversely affect adhesion and must be removed prior to application by solvent wiping.</p>
Solvent Wiping:	<p>A. Wet the application surface with a mild solvent such as isopropyl alcohol (rubbing alcohol) or heptane and wipe thoroughly.</p> <p>B. Dry the surface with a lint free cloth before the solvent evaporates from the surface.</p>
Temperature:	<p>The laminating adhesive can be applied when application surface temperatures are above 60 F (15.6 C).</p> <p>Substrates may be heated in order to raise the surface temperature above the minimum specified. This may be accomplished by portable heater or heat lamps.</p>
Techniques:	<p>A. Bond strength can be improved with firm application pressure so as to develop intimate contact of adhesive to the bonding surface.</p> <p>B. Initial bond strength can be improved by applying heat along with firm pressure, thus allowing the adhesive to flow into the texture of the bonding surface for maximum adhesive-to-surface contact.</p>
Storage:	Storage of Scotch #300MP “Hi-Strength” Acrylic Adhesives in polyethylene bags is highly recommended.

Caution

When using solvent, it is essential that proper precautionary measures for handling such materials be observed. These include, but are not restricted to:

1. Work only in a well ventilated area.
2. Keep away from heat, sparks and open flame.
3. No smoking in the work area.
4. Avoid breathing vapors.
5. Avoid eye and skin contact.
6. Keep solvent containers closed when not in use.
7. Consult the manufacturer's Material Safety Data Sheet for proper handling and storage of solvents.

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