



Laminating Adhesives/Data Page

FOD # 0182

Scotch™ 7951 Laminating Adhesive

Product Construction

Adhesive:	2.0 mils	(51 microns)	#300MP “Hi-Strength” Acrylic
Liners:	1) 4.0 mils	(102 microns)	58# Polycoated Kraft
	2) 4.0 mils	(102 microns)	58# Polycoated Kraft

Features

- Long-term environmentally stable bond
- Smooth adhesive for high quality appearance on thin graphic overlays
- High bond adhesive for application to plastic surfaces, including low surface energy plastics
- Double lined for selective die cutting

Applications

- Attachment of graphic overlays to membrane switches
- Attachment of membrane switches to product housing
- Attachment of decorative overlays which require window areas void of adhesive

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 D-3330	Stainless Steel	31	34
Modified (90 degree peel),	Aluminum	43	47
20 min. dwell, 12"/min.	Polycarbonate	38	42
(2 mil aluminum backing)	Polypropylene	33	36

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 alkalis.
Water Resistance:	Immersion in water has no appreciable effect on the bond strength.
Shelf Life:	Scotch 7951 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

General:	<p>Proper preparation of application surfaces is essential to assure high quality, long lasting bond of Scotch #300MP “Hi-Strength” Acrylic Laminating Adhesive.</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>Wet the application surface with a mild solvent such as isopropyl alcohol (rubbing alcohol) or heptane and wipe thoroughly.</p> <p>Dry the surface with a lint free cloth before the solvent evaporates from the surface.</p>
Temperature:	<p>Scotch 7951 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 a portable heater or heat lamps.</p>
Techniques:	<p>Bond strength can be improved with firm application pressure so as to develop intimate contact of adhesive to the bonding surface.</p> <p>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 brand #300MP “Hi-Strength” Acrylic Adhesive in polyethylene bags is highly recommended.

Note: Safety

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 prolonged 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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