



STOCKWELL ELASTOMERICS, INC.

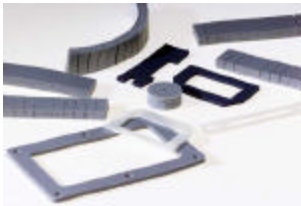
4749 Tolbut Street · Philadelphia, PA 19136
 (800) 523-0123 · (215) 335-3005 · Fax (215) 335-9433
 www.stockwell.com · e-mail: service@stockwell.com



Listing of Pressure Sensitive Adhesives Available on Gaskets, Pads, Slit-to-Width Rolls from Stockwell Elastomerics. SR96 07/03

Acrylic and Rubber Base Adhesive – Film Supported

Adhesive	Description and Helpful Tips
256M Acrylic Adchem	High Tack acrylic adhesive, .002" coated on both sides of 1/2 mil Mylar film - .0045" total. Bonds well to Poron and most organic sponges. Mylar film makes it a good candidate for Kiss Cut requirements. Our most frequently specified adhesive. 60 oz./inch peel, -40 to 225 degrees F temperature range. On narrow gasketing requirements, such as 1/4" thick x 1/4" wide, shear forces under long term compression may cause the Mylar to separate from the acrylic adhesive film. Supplied on white Kraft paper, 54" wide and 44" wide master rolls
254M Acrylic Adchem	Same adhesive as 256M - except thinner. .001" coated on both sides of 1/2 mil Mylar film -.0030" total. Similar bonding properties if supplied on lightweight foams or thin Porons. Main benefit is ready availability on 12 pt board release liner (much heavier than Kraft) for Preco Kiss Cut gaskets having greater rule-inches or intricate geometry. 54" and 44" wide.
9415 Acrylic 3M	A low tack adhesive, also called re-positioning adhesive. As it unwinds from the roll, a high tack adhesive is exposed for laminating to the gasketing material. When the customer, or user, removes the paper release liner, a low tack acrylic adhesive is exposed. This can be useful for intricate pads or gaskets where exact placement is needed, and re-positioning may be necessary. .001" coated on both sides of 1 mil Mylar film - .003" total.
9795B Acrylic 3M	A newly developed adhesive for the cell phone / portable scanning device industry. Contains 1/2 mil. Black film carrier for added opacity. Appears to have superior low temperature capability for ruggedized portable units.
5000M Rubber Adchem	High Initial Adhesion / High Tack Synthetic Rubber based adhesive. .0015" coated on both sides of 1/2 mil Mylar film - .0035" total. Rubber based adhesives are generally specified for low cost, fast stick requirements. The long term aging characteristics are not as good as acrylics, as both UV (sunlight) and oils degrade bond strength. (Replaces 5845M)



Film supported adhesives provide dimensional stability after removal of protective release liner.



Unsupported transfer film adhesives allow for gasketing to be formed into corners and tight bend radii.

Acrylic Transfer Film Adhesive

	Description and Helpful Tips
9485 Acrylic 3M	Medium Initial Tack / High Ultimate Strength - our 'go-to' when in doubt. Our adhesive of choice for silicone sponge and thick Poron cellular urethane. Considered a 350 type adhesive, will perform better on low surface energy substrates such as powder coated metal, polyprop. & polyethylene surfaces than the 200 type acrylic adhesives. Only downside is the 48" wide maximum roll width availability - which creates a mis-match on Poron 54" master rolls. .005" thk adhesive.
467 Acrylic 3M	Low to medium initial tack / high ultimate bond strength, 200 type of acrylic adhesive works best on bare metal surfaces or epoxy coated surfaces. Available 54" wide. Good choice when a thin, .002" thick adhesive is needed for requirements where shear forces are a concern. This 'hard', high solids adhesive will take up to 400 F.
950 Acrylic 3M	High Initial Tack / Soft acrylic adhesive. Better initial stick than 9485, however the long term shear properties are lower than 9485. 3M also refers to as #9472. Available 48" wide. .005" thick gives lots of mass to wet into irregular surfaces.
9473 Acrylic 3M	Considered in the VHB class of premium / shear resistant adhesives. This .010" thick adhesive has a low initial tack - which makes bonding to Poron somewhat problematic. Good nip pressure is needed for initial bond, however the adhesion builds with time.

Silicone Polymer and Silicone/Acrylic Adhesive – Film Supported

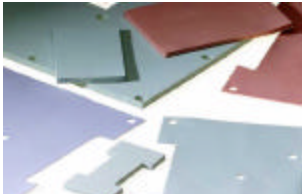
Adhesive	Description and Helpful Tips
8458 Silicone Adhes. Res.	Silicone polymer adhesive for hot and cold temperature conditions. .0015" coated on both sides of 1 mil Ultem film - .004" total. 40 oz./inch peel, temperature range -100 to 450 F. 26" wide master rolls, we apply to solid, sponge and foam silicone rubber products. Supplied with treated plastic release liner both sides.
D644 Silicone Specialty Tape	An alternative silicone polymer adhesive, approximately 1/3 the cost of #8458. Instead of an Ultem support film, it incorporates lower cost 1 mil Mylar film. -80 to 350 F. temp range. Presently 22" wide master rolls, 36" wide availability by 2002? May replace #8458 in some applications where extreme high temperature is not required. Self wound roll.
9731 Silicone/ Acrylic 3M	Combination adhesive. Removing the clear release liner exposes silicone polymer adhesive that bonds directly to LIM molded components (flat surfaces) and silicone foams such as F12 and Bisco foams without primer. Expensive. Removing the brown paper release liner exposes an acrylic adhesive backing. .0055" total thickness.
DLC-503 Silicone/ Acrylic Diehle	A lower cost combination adhesive. Not as good as 9731, especially in processing as the carrier stretches during unwind - making use of full widths difficult.



ESD and EMI materials can be provided with electrically conductive adhesive backing.

Electrically and Thermally Conductive Adhesive

Adhesive	Description and Helpful Tips
AR-8002 Acrylic Adhes. Res.	Carbon Filled, electrically conductive acrylic adhesive. The acrylic adhesive contains carbon particles, which do not tarnish or corrode, providing for long term conductivity in harsh environments. Primarily laminated to SCR7020-CON conductive neoprene for ESD pads. Provided 27" wide. .005" thick adhesive contains an adhesive impregnated non-woven fabric.
9713 Acrylic 3M	Conductive adhesive containing 'chopped fibers' of metal and metallized fabric. This new adhesive construction has a longer shelf life than 8002, since the adhesive itself does not contain particles. This is our adhesive of choice for lamination to conductive silicones for EMI shielding. Available in 14" and 24" wide master rolls. Not to be confused with 3M 9731 silicone/acrylic!
TR3 Acrylic St. Gobain	Thermally conductive acrylic adhesive, 2 mil thick transfer film. Compounded for UL94 flame rating. Supplied to us in 40" wide master rolls. We laminate to R10404-M thermally conductive sponge and Furo409 and CF1818 thermally conductive silicone coated fiberglass.



Thermally conductive materials can be provided with TR3 thermally conductive acrylic adhesive.

Tacky Carriers used to prevent stretching while cutting thin silicone materials

Adhesive	Description and Helpful Tips
2037D Acrylic Tyco/ Betham	Thin acrylic carrier adhesive applied to 12 point dense cardboard stock. Only to be used as a carrier - to facilitate Preco die cutting of stretchy closed cell silicone sponge and thin, low durometer solid silicones that can be die cut faster on a carrier. Carriers provide dimensional stability during the die cutting process. 2037D is never to be used on Bisco Silicone foam, F12 or Poron cellular urethane 37" wide. Carriers are only used for plain (non-adhesive backed) requirements.
CT1008 Custom Coating	Thin rubber based / low tack adhesive applied to a crepe-like paper. We apply it to Bisco Silicone Foam or Poron cellular urethane - then add a backer of 5000M on top of the crepe paper to provide better handling and cutting. We kiss cut down to the crepe and then pick the gaskets or pads to provide clean cut through parts. 48" wide Master rolls. Carriers are only used for plain (non-adhesive backed) requirements.

Call us to find out more or e-mail us at service@stockwell.com for assistance.