



# 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



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## Current Listing of Pressure Sensitive Adhesives

Stockwell Elastomerics, Inc. has teamed up with 3M, Adchem and additional pressure sensitive adhesive manufacturers to provide a broad selection of pressure sensitive acrylic, rubber based and silicone based pressure sensitive adhesives applied to gaskets and cushioning pads. The majority of gaskets have adhesive backings to aid assembly.

**Stockwell's most frequently specified General Purpose Adhesives** - all 3 adhesives bond readily to bare metals such as aluminum, copper, and stainless steel, and to engineering plastics such as ABS, filled PVC, polyimide, polyester and polyurethane. Surface energy should be > 40 Dynes/cm). Stockwell recommends providing samples for evaluation on the particular application.

Name	Adhesive Type	Bond Strength (oz/in)	Total Thickness	Comments and Characteristics
256M	Acrylic (Supported)	70	.0045"	<b>High Tack Acrylic adhesive</b> - Its total thickness includes a .0005" thick polyester carrier for dimensional support.
467	Acrylic (Transfer) 3M 200MP	77	.002"	<b>Low tack / High bond strength</b> acrylic adhesive is recommended when a thin adhesive is needed for requirements with potential shear forces.
9485	Acrylic (Transfer) 3M 350	150	.005"	<b>Medium initial tack / High bond strength</b> acrylic adhesive is the best choice when a strong transfer film adhesive is required to bond Poron® and silicone sponge gaskets onto enclosures.

### Specialty Pressure Sensitive Adhesives (PSAs) - to solve bonding and design challenges

Name	Adhesive Type	Bond Strength (oz/in)	Total Thickness	Comments and Characteristics
9490LE	Acrylic (Low Surface Energy) 3M 300 LSE	124/142	.0067"	<b>Low Surface Energy PSA</b> - This supported adhesive is designed for tough-to-stick-to surfaces such as polypropylene, PTFE, and some powder coatings.
6038PC	Acrylic (Low Fog and High Strength) 3M 300MP	210	.008"	<b>Low Fog and High Strength</b> - This thick acrylic transfer adhesive offers a strong bond to many surfaces including low surface energy plastics.
9731	Acrylic / Silicone (Combination adhesive) 3M 350 - acrylic	121/48	.0055"	<b>Combination PSAs</b> are commonly specified for bonding to silicone materials and molded gaskets. Ask about our proprietary bonding of acrylic adhesives to silicone materials.
9415	Acrylic (High / Low Tack)	50/5	.002"	<b>Repositionable PSA</b> - The low tack surface is exposed when the release liner is removed from delicate foam gaskets, allowing for repositioning before mechanically fastening to a surface.
9713	Acrylic (Electrically Conductive)	55	.003"	<b>Electrically Conductive PSA</b> - This XYZ conductive adhesive is excellent for use with EMI gasket materials such as nickel-graphite filled silicone rubber gaskets.
DP-1001	Silicone (High Temperature)	35/58	.005"	<b>Extreme Temperature PSA</b> - This double-coated silicone adhesive is specified for silicone gaskets requiring an adhesive backing that withstands temperatures from -100°F to +500°F.
TR3	Acrylic (Thermally Conductive)	30	.003"	<b>Thermally Conductive PSA</b> - This ceramic filled transfer adhesive is specifically designed to aid in the transfer of heat (0.04 W/m-K).

**Other Pressure Sensitive Adhesives (PSAs) - inventoried by Stockwell Elastomerics to solve bonding and design challenges**

Name	Adhesive Type	Bond Strength (oz/in)	Total Thickness	Comments and Characteristics
254M	Acrylic (Supported)	60	.003"	<b>254M adhesive is similar to 256M</b> , however thinner and supplied on a heavier release liner to aid in kiss-cutting of larger gaskets and pads.
468	Acrylic (Transfer) 3M 200MP	118	.0052"	<b>468 adhesive is similar to 467</b> , but thicker. It is available in 54" wide rolls, matching the width of a Poron® master roll.
9795B	Acrylic (Supported) 3M 420	78	.0056"	The <b>black polyester carrier</b> gives the 9795B adhesive its black appearance. This adhesive can be used on gaskets for light seals on displays.
9472	Acrylic (Transfer) 3M 300	98	.005"	This <b>3M 300 series adhesive</b> has high initial tack and may be suitable for some low surface energy surfaces.
5000M	Rubber (Supported)	130	.0035"	<b>Rubber base</b> adhesives are specified for applications where high initial tack is important, and long-term aging characteristics are secondary.

**Very High Bond (VHB) Strength Film Adhesives - are laminated onto gasketing materials such as Poron® cellular urethane, silicone rubber and similar high performance elastomers**

Name	Adhesive Type	Bond Strength (oz/in)	Total Thickness	Comments and Characteristics
9473	VHB (Transfer) 3M 100MP	144	.010"	The 9473 <b>premium adhesive is shear resistant</b> ; it has low initial tack and high ultimate strength.

**Very High Bond (VHB) Strength Adhesive Foams from 3M Corporation - are mostly die cut into lens gaskets, mounting gaskets and pads. These materials require a release liner on both sides prior to die cutting. VHB foams can be water jet cut into finished shapes**

Name	Adhesive Type	Bond Strength (oz/in)	Total Thickness	Comments and Characteristics
4926	VHB (Acrylic Foam) 4941 family	192	.015"	Acrylic adhesive surface on both sides of <b>conformable adhesive foam</b> – 4926 provides excellent adhesion to a broad range of high and medium surface energy substrates, UL 746C.
5925	VHB (Acrylic Foam) 5952 family	272	.025"	Acrylic adhesive surface on both sides of <b>very conformable adhesive foam</b> – 5925 adheres to the broadest range of substrates, including most powder coated paints, UL 746C.
4949	VHB (Acrylic Foam) 4950 family	400	.045"	General purpose adhesive on both sides of <b>firm adhesive foam</b> - This family is typically used on metal, glass, and high surface energy plastic substrates.

For more information, please call 215-335-3005 (toll-free 800-523-0123) or e-mail [service@stockwell.com](mailto:service@stockwell.com).

