



Double Lined Laminating Adhesive 7965MP

Product Data Sheet

Updated : April 2004
Supersedes : July 2000

Physical Properties

Not for specification purposes

Release Liner	0.165mm 86# Polycoated Kraft
Adhesive	0.127mm #200 "High Performance" Acrylic
Liner	0.10mm 58# Polycoated Kraft
Shelf Life	12 months from date of manufacture by 3M if stored at room temperature condition in cool, dry and sun protected room.

Features:

- Long term environmentally stable bond.
- Smooth adhesive for high quality appearance on thin graphic overlays.
- High cohesive strength to withstand repeated stresses from switch activation.
- High temperature, humidity, and chemical resistance.
- Lay-flat liner provides greater stiffness and rigidity.
- Thick adhesive provides higher bond strength on rough or smooth surfaces.

Applications

- Attachment of graphic overlay to membrane switch or keyboard.
- Attachment of membrane switch to product housing.
- Lamination to polyester for membrane spacers.

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Properties and Performance Not for specification purposes	Temperature Range	Low : -40°F (-40C) High Long Term (days/weeks) : 300°F (149°C). High Short Term (minutes/hours) : 400°F (204°C).
	Chemical Resistance	Solvent resistance is excellent when this product is properly applied to impervious materials. The adhesive resists softening through edge contact with mild acids, alkalis, oil, gasoline, Kerosene, JP-4 fuel and many other solvents. Not recommended for total immersion.
	Dielectric Strength (ASTM D149)	0.95 KV/mil
	Insulation Resistance (ASTM P257)	N.A. ohms
	Volume Resistivity (ASTM D257)	2.2×10^{15} ohm-cm
	Surface Resistivity (ASTM D257)	1.3×10^{14} ohms/square
	Moisture & Humidity Resistance	No adverse effect on the bond after exposure to 100% Relative Humidity at 100°F.
	Bond Build Up	The bond strength of Scotch #200 Hi-Performance Acrylic adhesive increases as a function of time and temperature.
	U.V. Resistance	Adhesive is very resistant to oxidisation and ozone when exposed to air or sunlight (U.V.).

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180° Peel 12"/minute 1 mil polyester to stainless steel (ASTM D903)
N/10mm

3M test 90° peel 12"/minute 8 mil aluminium to various surfaces		
	72 hour Dwell N/10mm	Ultimate Bond N/10mm
Stainless Steel		
Epoxy		
Polyester		
Polycarbonate		
ABS		

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Application Techniques

- Bond strength is dependent upon the amount of adhesive surface contact developed. Firm application pressure develops better adhesive contact and thus improves bond strength.
- To obtain optimum adhesion, the bonding surfaces must be clean, dry and smooth. Some typical surface cleaning solvents are isopropyl alcohol or heptane. Use proper safety precautions for handling solvents.
- Ideal tape application temperature range is 70°F to 100°F.
- Application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



Tapes & Adhesives Group

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