

Product Construction Sheet

FLX013997 - FLEXcon® SILICONE ADHESIVE SA6102

GENERAL DESCRIPTION:

This is a 2.0 mil (51 micron) high performance, engineering grade permanent pressure sensitive silicone adhesive backed with a semi-bleached kraft release liner on one side and a clear ultra smooth polyester release liner on second side. This adhesive is ideal for lower temperature disc brakes, vibration and noise damping applications.

NOTE:

When converting this product on press, hard start of the machine is recommended.

PRODUCT DATA	VALUE	TEST METHOD
PHYSICAL PROPERTIES		
Thickness mil (micron)	Polyester Liner: 2.0 (51) +/- 10 % Adhesive: 1.9-2.1 (48-53) +/- 0.2 (5) kraft Liner: 4.0 (102) +/- 10 %	ASTM D 3652 (Modified for use with non-tape product)

ADHESION PROPERTIES*

	180° angle 12"/min. Average oz/in (N/m)	90° angle 12"/min. Average oz/in (N/m)	ASTM D 3330 (Modified for dwell time)
<u>Laminated to 2.0 mil clear polyester</u>			
Stainless Steel			
A) 15 minute	59 (649)		
B) 3 day 160° F (71° C)	92 (1012)		
C) 3 day RT	73 (803)	54 (594)	
3 day RT Acrylic	75 (825)		
3 day RT Glass	80 (880)		
3 day RT Polypropylene	67 (737)		
<u>Laminated to 2.0 mil aluminum foil</u>			
Stainless Steel			
D) 15 minute		59 (682)	
E) 3 day 160° F (71° C)		76 (715)	
F) 3 day RT	75 (825)	56 (627)	
3 day RT Acrylic		59 (671)	
3 day RT Glass		58 (660)	
3 day RT Polypropylene		55 (627)	
Expected Shear (hours)	<u>Laminated to 2.0 mil clear polyester</u> 80	<u>Laminated to 2.0 mil aluminum foil</u> 20	ASTM D 3654 Method A (1 hr. dwell, 1 sq. in, 4 lb. load)
Tack (g)	1180	1000	ASTM D 2979

* For guidance only, not to be used for setting specifications. Due to the custom nature of this product, the data presented are based on three or less production runs.

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04/26/2017

Product Performance and Suitability

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For humidity and chemical resistance, transfer tape was laminated to 2.0 mil clear polyester film.

PRODUCT DATA	OBSERVATION
HUMIDITY RESISTANCE	
Test Method: On SS panel at 100°F and 95% RH vs. 24 hr on SS panel at RT. (24 hr dwell time on SS panel before humidity exposure and 24 hour recovery time before adhesion test)	
7 day + 24 hr recovery	No visual change, no adhesion loss
CHEMICAL RESISTANCE	
Test Method:	
Control: 24 hour @ RT on SS panel (24 hr dwell time before immersion and 24 hour recovery time before adhesion test).	
1 hour @ RT in Gasoline (Unleaded)	Edge penetration, 35% adhesion loss
1 hour @ RT in MEK (Methyl Ethyl Ketone)	Edge penetration, 25% adhesion loss
72 hour @ 120°F (49°C) in Oil (SAE 10W-30)	No visual change, 10% adhesion gain
72 hour @ RT in Salt Water (6% by weight)	No visual change, 5% adhesion gain
100 hour @ RT in Water	No visual change, 5% adhesion gain
EXPECTED EXTERIOR LIFE	Depends on substrates, adhesive is suitable for outdoor use
SERVICE TEMPERATURE	-300°F to 500°F (-185°C to 260°C) Short term exposure temperature 800°F (427°C) for <1 hr
MINIMUM APPLICATION TEMPERATURE	50°F (10°C)
STORAGE STABILITY	One year stored at 70°F (21°C) and 50% RH

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