

# Product Construction Sheet

FLX051754 - FLEXcon® SA6104 LR

**GENERAL DESCRIPTION:**

This is a 4.0 mil (102 micron) high performance, engineering grade permanent pressure sensitive silicone adhesive backed with a differential semi-bleached kraft release liner on one side and an ultra smooth polyester release liner on second side. This adhesive is ideal for lower temperature disc brakes, noise and vibration damping applications.

**NOTE:**

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

PRODUCT DATA	VALUE			TEST METHOD
<b>PHYSICAL PROPERTIES</b>				
Thickness	Polyester Liner: 2.0	(51)	+/- 10 %	ASTM D 3652 (Modified for use with non-tape product)
mil (micron)	Adhesive: 3.9-4.1	(99-104)	+/- 0.3 (8)	
	Differential kraft Liner: 4.0	(102)	+/- 10 %	

<b>ADHESION PROPERTIES*</b>			
	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)

Laminated to 2.0 mil clear polyester

Stainless Steel			
A) 15 minute	107	(1177)	
B) 3 day 160° F (71° C)	115	(1265)	
C) 3 day RT	116	(1276)	88 (968)
3 day RT Acrylic	105	(1155)	
3 day RT Glass	109	(1199)	
3 day RT Polypropylene	102	(1122)	

Laminated to 2.0 mil aluminum foil

Stainless Steel			
D) 15 minute			52 (572)
E) 3 day 160° F (71° C)			71 (781)
F) 3 day RT	92	(1012)	50 (550)
3 day RT Acrylic			52 (572)
3 day RT Glass			52 (572)
3 day RT Polypropylene			54 (594)

	<u>Laminated to 2.0 mil clear polyester</u>	<u>Laminated to 2.0 mil aluminum foil</u>	
Expected Shear (hours)	100	30	ASTM D 3654 Method A (1 hr. dwell, 1 sq. in, 4 lb. load)
Tack (g)	1300	1440	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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**Product Performance and Suitability**

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

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 PRODUCT DATA

OBSERVATION  
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HUMIDITY RESISTANCE

Test Method: On SS panel @ 100°F and 95% RH vs. 24 hr. on SS panel @ RT. (24 hr. dwell time on SS panel before humidity exposure and 24 hr. recovery time before adhesion test)

7 days + 24 hr. recovery                      No visual change, 15% adhesion gain

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 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                      Edge penetration, 55% adhesion loss  
 (Unleaded)

1 hour @ RT in MEK                              Edge penetration, 55% adhesion loss  
 (Methyl Ethyl Ketone)

72 hours @ 120°F (49°C) in Oil              No visual change, 35% adhesion loss  
 (SAE 10W-30)

72 hours @ RT in Salt Water                  No visual change, no adhesion loss  
 (6% by weight)

100 hours @ RT in Water                      No visual change, 5% adhesion gain

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 EXPECTED EXTERIOR LIFE                      Depends on substrates, adhesive is suitable for outdoor use  
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SERVICE TEMPERATURE                      -300°F to 500°F (-185°C to 260°C)  
 Short term exposure temperature 800°F (427°C) for <1 hr.  
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MINIMUM APPLICATION TEMPERATURE      50°F (10°C)  
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STORAGE STABILITY                              Six months stored at 70°F (21°C) and 50% RH  
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