

PORON® Polyurethanes

General Adhesives Applications Guide

Rogers offer the following guidelines when combining PORON® Polyurethanes with adhesive:

- Apply adhesive to either surface of the PORON material and determine which provides the desired level of adhesion.
- Bonding results may differ when the adhesive is applied to buffed, unprinted, or otherwise treated PORON polyurethane surfaces.
- Minimize stretch and pressure to prevent material stress.
- Surface energy ranges from high to low. As a rule of thumb, the higher the surface energy, the greater the strength of adhesion.
- For further technical information about a specific adhesive, please contact the manufacturer directly to help determine which adhesive will be most suitable for your application.

General Adhesion

COMPANY	ADHESIVE	PSA TYPE	TO BOND TO	APPLICATIONS
Covalence Adhesives	6KM6 & 8	Heat Sealable Rubber Double-Coated Tape	Foams	Heat seal applications, excellent aging characteristics
Covalence Adhesives	1173B	Acrylic Double-Coated Tape	Foams	Excellent Anchorage to PE, rubber sponge, and other foams
Covalence Adhesives	3000-3 & -5	Acrylic Transfer Tape	Foams & HSE Plastics	High heat and humidity resistance
Covalence Adhesives	2253A, B, & C	Acrylic Transfer Adhesives	Foams & HSE Plastics	High heat and humidity resistance
Covalence Adhesives	2588C	Acrylic Double-Coated Tape	Urethane/Other Foams & PVC	High degree of plasticizer migration resistance
Covalence Adhesives	T1423 & T1453	Acrylic Adhesive Transfer Tape	Most	High and Low Temperature resistance. High heat & humidity resistance
Dielectric Polymers, Inc	Neltape 140A89	Unsupported Transfer Film	Most	General Use
FLEXcon	V-478	Acrylic Adhesive Transfer Tape	Powder Coated	General Use
FLEXcon	V-778	Acrylic Adhesive Transfer Tape	TPO Materials	General Use
FLEXcon	A-326	Acrylic Adhesive Transfer Tape	Metals, HSE, LSE	General Use
Loctite	PRISM 411	Cyanoacrylate	Most	General use

High Surface Energy

COMPANY	ADHESIVE	PSA TYPE	TO BOND TO	APPLICATIONS
3M	100 VHB	Acrylic Adhesive Transfer Tape	HSE	High shear strength, high temperature resistance
3M	100 High Temp	Acrylic Adhesive Transfer Tape	HSE	High temperature, low outgassing
3M	200, 200 MP High Performance	Acrylic Adhesive Transfer Tape	HSE	Medium / high temperature resistance
3M	220	Acrylic Adhesive Transfer Tape	HSE	Economical acrylic
3M	300MP High Strength	Acrylic Adhesive Transfer Tape	HSE	Low fogging for automotive interiors
3M	9456	Acrylic Double Coated Tape	HSE	Tissue supported for better conformability
Adchem	256M	Acrylic Double Coated PET FILM	HSE	UV resistant, excellent performance in extreme temperatures
Adchem	747, 730-60#	Acrylic Transfer Tape	HSE	Adheres well to many types of foam
Avery Dennison	HP Family	High Temperature High Shear Acrylic	Metals / HSE / Plastics	Automotive Exterior / Emblem Mounting Membrane Switch & Name Plates
MACtac	IB-2100 series	Acrylic-Based Double Coated Tape	HSE	PET carrier, resists some plasticizers

Medium Surface Energy

COMPANY	ADHESIVE	PSA TYPE	TO BOND TO	APPLICATIONS
Avery Dennison	UP Family	Standard Acrylic	Metals / MSE / Plastics	Gasketing, Plasticizer Resistant
Avery Dennison	ECO Family	Solvent Free Acrylic	Metals / MSE / Plastics	Gaskets / Automotive Interior
MACtac	IF-2012 series	Acrylic Transfer Tape	MSE	Bonds plastic to metal or trim

Low Surface Energy

COMPANY	ADHESIVE	PSA TYPE	TO BOND TO	APPLICATIONS
Adchem	7332 Series (12pt board liner)	Acrylic Transfer Tape	LSE	Bonds well to ether, ester, and low perm urethane foams
Avery Dennison	SR Family	Solvent Rubber	LSE	General Purpose Gasketing
Avery Dennison	MA Family	Modified Acrylic	LSE	Thin layer / Gasketing / High Precision Die Cut
Avery Dennison	LA Family	Modified Acrylic	LSE	Gasketing / Component Mount Mobile Electronics
3M	300 LSE High Strength	Acrylic Double Coated / Adhesive Transfer Tapes	HSE/LSE	Adheres to LSE surfaces
MActac	IB-1101	Rubber-Based Double Coated Tape	HSE/LSE	Adheres to LSE surfaces

Special Adhesion Types

COMPANY	ADHESIVE	PSA TYPE	TO BOND TO	APPLICATIONS
3M	9415 PC	Acrylic w/ PET carrier	Repositionable	Repositioning
Adchem	5000M	Rubber-Based Double Coated PET Film	Porous / Textured	Adheres well to porous and textured surfaces
Lohmann	Lohmamont MP6001B	Acrylic Adhesive on Polyester backing	Removable	Removable Adhesive Cover Liner
Polymask, a 3M company	2A12C	Acrylic Adhesive on Polyethylene backing	Removable	Removable Adhesive Cover Liner
Polymask, a 3M company	2A25C	Acrylic Adhesive on multi-polymer backing	Removable	Removable Adhesive Cover Liner

HSE – High Surface Energy substrates
LSE – Low Surface Energy substrates

MSE – Medium Surface Energy substrates
PET – Polyester

Company Contact Information:

COMPANY	WEBSITE	TELEPHONE	CONTACT
3M	www.3m.com	800-362-3550	Customer Service Center
Adchem	www.adchem.com	631-727-6000	Customer Service Center
Avery Dennison	www.steu.averydennison.com	+ 32 (0) 14 40 87 54	Nancy Janssens
Covalence Adhesives	www.covcorp.com	800-248-7659 x1672	Elizabeth Curran
Dielectric Polymers, Inc.	www.dipoly.com	800-628-9007	Customer Service Representative
FLEXcon	www.flexcon.com	508-885-8440	Performance Product Business Team
Loctite Corp.	www.loctite.com	800-LOCTITE (562-8483)	Customer Service Center
Lohmann	www.lohmann-tapes.com	859-334-4900	Linda Kourkounakis
MACtac	www.mactac.com	800-321-0011	Technical Products Customer Service
PolyMask, a 3M company	www.3m.com	800-241-2031	Customer Service Representative

For further technical information regarding adhesives applications or processing issues for PORON polyurethane materials please contact:

Rogers Solutions Center	800-935-2940
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