

**TECHNICAL BULLETIN**

**MEDICAL APPLICATION TAPE**

PRODUCT:	<b>9254M Medical Grade Double-Coated Polyester Film</b>			
DESCRIPTION:	A high tack, moderate shear acrylic adhesive system coated on both sides of a high quality polyester film. Resistance to high temperature and UV exposure.			
PRIMARY USE:	This product exhibits all the positive results associated with a high quality, multi-purpose acrylic system with exceptionally high peel and high initial tack. Adhesion is excellent to a wide variety of surfaces, such as papers, rigid and flexible plastics, non-woven materials, and foams. Excellent short- and long-term skin adhesion.			
LINER:	Standard liners are 55# white Densified Kraft and 74# white poly-coated Kraft.			
BIOLOGICAL PROPERTIES:	<p>NO CYTOTOXICITY* NON-IRRITATING* HYPOALLERGENIC*</p> <p>*Adchem's suppliers have provided us with information on adhesives used for skin contact that have been tested per the guidelines for cytotoxicity; skin irritation and sensitization as provided in ISO 10993. These test results suggest a positive outcome for skin contact applications, but it is device manufacturer's responsibility to test the finished article to the relevant sections of ISO 10993 that are applicable to the medical device.</p>			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	0.5 mils	
		Adhesive Exposed Side (nominal)	1.3 mils	
		Adhesive Liner Side (nominal)	1.3 mils	
		55# Release Liner (nominal)	3.2 mils	
		74# Release Liner (nominal)	3.5 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>Immediate:</i>		
		Exposed Side		44oz/inch
		Liner Side		44oz/inch
		PSTC #101; backed with 4 mil dead soft aluminum foil <i>Immediate:</i>		
		Exposed Side		70 oz./inch
		Liner Side		70 oz./inch
		PSTC #101; backed with 4 mil dead soft aluminum foil <i>24 Hours:</i>		
		Exposed Side		75 oz./inch
		Liner Side		75 oz./inch
NOTE: Peel tests are performed as per PSTC #101, which states one minute maximum dwell time. In general, for acrylic adhesives, longer residence time yields much higher peel values.				

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TYPICAL PHYSICAL PROPERTIES (Cont.)	Shear Adhesion	PSTC #107; Modified 500gms./sq.in	
		Exposed Side	7+ Days
		Liner Side	7+ Days
PRODUCT FEATURES:	<ul style="list-style-type: none"> <li>• Excellent peel, shear and tack.</li> <li>• Bonds well to most surfaces.</li> <li>• Die cuts cleanly.</li> <li>• Bonds well to papers.</li> </ul>		
SERVICE TEMPERATURE:	<p>-30°F to 220°F</p> <p>NOTE: This information is provided as a means to help characterize the adhesive's temperature resistance. Note that this data is based on limited testing and under no load. The practical service temperature of this or any adhesive system is dependent on many variables including the substrates being bonded, environmental conditions, and the loading and method of application. The purchaser is responsible for determining the suitability of this or any product for their particular purpose and process. The recommended application temperature is 68°F to 100°F.</p>		
NOTES:	<p>The use of heat and pressure will help to increase the initial bond of the product to the substrate. Testing is recommended prior to laminating to any material that contains migrating plasticizers.</p>		
SHELF LIFE:	<p>One year from date of shipment when stored under cool, dry conditions.</p>		

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