SUBJECTIVE BONDING STUDY

PRODUCTS TESTED

MONMOUTH DURAFOAM™ P191HD 100% EPDM

SETUP AND TESTING

Adhesive systems (see charts below) were backed with 1 mil PET film (liner-side for double-coated products) and trimmed to 1 inch width. 2 sample sets were laminated to customer-supplied Monmouth DURAFOAM P191HD 100% EPDM. One set laminated at Room Temperature and one set using 160°F Heat Assist with 50% Compression. Sample was conditioned as noted and subjectively evaluated.

SUBJECTIVE RATING SYSTEM

EXCELLENT:	Completely destructive bond and/or substantial force required to remove adhesive from material.
VERY GOOD:	Substantial Destruction to surface of material and/or significant force required to remove adhesive from material.
GOOD:	Partially destructive bond and/or moderate force required to remove adhesive from material.
FAIR:	Non-destructive bond to material but moderate force required to remove adhesive

SYMBOLS	
HEAT ASSIST NECESSARY	Δ Bond demonstrated improvement after accelerated aging noted (time and temp)
HEAT ASSIST BENEFICIAL	*D* Discoloration of adhesive noted after accelerated aging noted
S Indicates Product Series	*OG* Outgassing
LAM Lamination Temperature	*L-* Minor Legging *L* Moderate Legging *L+* Major Legging
RT Room Temperature	

Foam Bonding evaluations are affected by foam thickness and integrity. Adhesion to foam and rubber products are affected by factors including material thickness and density, lamination speed, temperature, and compression. Bond strength observed immediately after lamination is often not a reliable indicator of long term adhesion or compatibility. Results being provided as a guide to product selection; products should be thoroughly tested to application materials applied using intended production equipment and practices and evaluated in conditions reflecting intended use.

MAT'L		MONMOUTH DURAFOAM™ P191HD 100% EPDM
SUBJECTIVE RATING	EXCELLENT	554T 652 ⅄ 653 ⅄ 654M 655 ⅄ 730 ⅄ 4787M 5944M
	VERY GOOD	2016M
	GOOD	2237M

RUBBER-BASED ADHESIVE

HYBRID (ACRYLIC EXPOSED-SIDE, RUBBER LINER-SIDE)

ACRYLIC ADHESIVE

T = TISSUE CARRIER; M = POLYESTER CARRIER, ⅄= UNSUPPORTED (TRANSFER) TAPE

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