

Test Method:

Mactac tape was applied to both the skin side and the cut side of the foam substrate using 50% Compression and a weighted 5# roller.

All tape was applied at room temperature, and peels were conducted manually at an approximate rate of 12"/sec.

Peel testing was measured at intervals of 30 mins, 24 hours, 72 hours, and 2 weeks at Room temperature.

Accelerated aging - 1 week @ 140°F was performed to simulate long term performance for the PSA on a given foam substrate.

K-Flex is a leading manufacturer of elastomeric foams.



General Gasketing



Appliance



Tapes & Stripping



Marine



Automotive
General Sealing, HVAC,
NVH Applications,
Door Panel Assemblies



Mass Transit



Heavy Machinery



Sports Equipment
& Padding

Adhesives

- MP 593XT** - High-tack, High-shear, Rubber Adhesive
- MP 899FBT** - Rubber Foam Bonding Adhesive
- MP 410** - NEW! High-peel Acrylic Adhesive



Foam Bonding Study: K-Flex Performance Foams

		"++++" = Foam Destruction				"+++" = Very Aggressive				"++" = Aggressive		"+ " = Mild		"- " = Poor	
		"SL P" = Slight Picking <20%				"P" = Picking 20-50%				"CF" = Cohesive Failure		"CF&P = Cohesive Failure & Picking			
		AB-10		GV		41N		42N		HT		41E			
		Nitrile-PVC Blend		SBR-EVA Blend		NBR-PVC-CR Blend		NBR-PVC-CR Blend		EPDM		EPDM			
Formula	Dwell	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut		
Rubber Adhesives	MP-593XT	30 min @ RT	++ (SL P)	+++	-	+++	+ (SL P)	+ (SL P)	++	+ (SL P)	++++	+ (SL P)	+++	+ (SL P)	
	MP-593XT	24 hour @ RT	+ (P)	+(P)	++++	+++	+++	+ (SL P)	++	+ (SL P)	++++	+ (P)	++++	+ (P)	
	MP-593XT	72 hours @ RT	++++	+++	++++	+++	++++	+ (SL P)	+++	+ (SL P)	++++	+ (P)	++++	+ (P)	
	MP-593XT	2 Weeks @ RT	++++	++ (P)	++++	+++	++++	+ (SL P)	+++	+ (SL P)	++++	+ (P)	++++	+ (P)	
	MP-593XT	1 week @ 140°F	+++ (CF)	+ (CF)	++++	+++	+ (CF&P)	+ (CF)	++ (CF)	+ (SL P)	++++	+ (P)	+++ (CF)	- (P)	
	MP-899	30 min @ RT	++++	+ (SL P)	++++	+++	++++	+ (SL P)	++	++	++++	+ (SL P)	+++	+ (SL P)	
	MP-899	24 hour @ RT	++++	+(P)	++++	+++	+++	+ (SL P)	+++ (CF)	+ (SL P)	++++	+ (SL P)	++++	+ (SL P)	
	MP-899	72 hours @ RT	++++	+ (P)	++++	+++	+++ (CF)	+ (SL P)	+++ (CF)	+ (SL P)	++++	+ (P)	++++	+ (P)	
	MP-899	2 Weeks @ RT	++++	+++	++++	+++	+++ (CF)	+ (SL P)	+++ (CF)	+ (SL P)	++++	+++	++++	+++	
	MP-899	1 week @ 140°F	+++ (CF)	+ (CF)	++ (CF/P)	+ (CF/P)	++ (CF)	++ (CF)	++ (CF)	++ (CF)	++++	+ (P)	++ (CF)	++ (CF)	
Acrylic Adhesives	MP410 LCW	30 min @ RT	+(SL P)	+++	+++	+++	+ (SL P)	+ (SL P)	++	+++	+	+ (SL P)	+	+ (SL P)	
	MP410 LCW	24 hour @ RT	+++	+++	+++	++++	+ (SL P)	+ (SL P)	+++	+++ (CF)	+++	+ (SL P)	+	+ (SL P)	
	MP410 LCW	72 hours @ RT	++++	+++	++++	+++	+ (P)	+ (P)	+++	+++ (CF)	+++	+ (P)	+	+ (SL P)	
	MP410 LCW	2 Weeks @ RT	++++	+++	++++	+++	+++	+ (CF&P)	++	+ (CF&P)	++++	+ (P)	++	+ (SL P)	
	MP410 LCW	1 week @ 140°F	++++	+ (SL P)	++++	+++	+ (CF)	- (CF)	- (CF)	- (CF)	++++	+ (P)	++ (CF)	+ (SL P)	
	MP410 HCW	30 min @ RT	++++	+++	++++	+++	+++	+++	++	+++	+ (SL P)	+ (SL P)	+	+ (SL P)	
	MP410 HCW	24 hour @ RT	++++	+++	++++	+++	++++	+++	++	+++	++++	+ (P)	++ (CF)	+ (SL P)	
	MP410 HCW	72 hours @ RT	++++	+++	++++	+++	++++	+++	+++	+++	++++	+++	++ (CF)	+ (SL P)	
	MP410 HCW	2 Weeks @ RT	++++	+++	++++	+++	++++	+++	+++	+++	++++	+++	++ (CF)	+ (P)	
	MP410 HCW	1 week @ 140°F	+++ (CF)	+++ (CF)	++++	+++	+ (CF)	+ (CF)	- (CF)	- (CF)	++++	+++	+ (CF)	+ (SL P)	

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		40P		K43N		40E		G		41P		41PA			
		Nitrile-PVC Blend		NBR-PVC-CR Blend		EPDM		Nitrile-PVC Blend		Nitrile-PVC Blend		Nitrile-PVC Blend			
Formula	Dwell	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut		
Rubber Adhesives	MP-593XT	30 min @ RT	++++	+ (SL P)	-	+	++++	- (SL P)	++++	+ (SL P)	-	+ (P)	+++	+ (SL P)	
	MP-593XT	24 hour @ RT	++++	+ (SL P)	+	+	++++	+ (SL P)	++++	+ (SL P)	++++	+ (P)	+	+ (P)	
	MP-593XT	72 hours @ RT	++++	+ (SL P)	+ (CF)	- (SL P)	++++	+ (SL P)	++++	+ (SL P)	++++	+ (P)	++	+ (P)	
	MP-593XT	2 Weeks @ RT	++++	+ (SL P)	+ (CF)	- (SL P)	++++	+ (P)	++++	+ (P)	++++	+ (P)	++	+ (P)	
	MP-593XT	1 week @ 140°F	++++	+++	++ (CF)	- (CF)	++++	+ (P)	++++	+ (P)	+++	+ (P)	+++ (CF)	+++ (CF)	
	MP-899	30 min @ RT	++++	+ (SL P)	+	-	++++	+ (SL P)	++++	+ (SL P)	++++	+ (SL P)	-	+ (SL P)	
	MP-899	24 hour @ RT	++++	+ (SL P)	++ (CF)	+ (SL P)	++++	+ (SL P)	++++	+ (P)	++++	+ (P)	+ (P)	+ (SL P)	
	MP-899	72 hours @ RT	++++	+ (SL P)	++ (CF)	+	++++	+ (SL P)	++++	+ (P)	++++	+ (P)	+++	+ (P)	
	MP-899	2 Weeks @ RT	++++	+++	++ (CF)	+ (CF/P)	++++	+ (SL P)	++++	++ (CF)	++++	+++	+++	+ (P)	
	MP-899	1 week @ 140°F	++++	+++	++ (CF)	++ (CF)	++++	+ (CF)	+++	+ (CF)	+++ (CF)	++ (CF)	+ (CF)	+ (CF/P)	
Acrylic Adhesives	MP410 LCW	30 min @ RT	++++	+ (SL P)	+	-	+ (SL P)	+ (SL P)	++++	+ (SL P)	+++	+++	+ (SL P)	+ (SL P)	
	MP410 LCW	24 hour @ RT	++++	+ (SL P)	+ (CF)	+ (CF)	+ (SL P)	+ (SL P)	++++	+ (SL P)	+++	+++	+ (SL P)	+ (SL P)	
	MP410 LCW	72 hours @ RT	++++	+ (P)	+ (CF)	+ (CF)	+ (SL P)	+ (SL P)	++++	+ (P)	++++	+++	++++	+ (P)	
	MP410 LCW	2 Weeks @ RT	++++	+ (P)	+ (CF)	+ (CF)	+ (P)	+ (SL P)	++++	+ (P)	++++	+++	++++	+ (P)	
	MP410 LCW	1 week @ 140°F	++++	+++	+ (CF)	- (CF)	++++	+ (SL P)	+++	+ (CF)	++++	+++	++++	+ (CF&P)	
	MP410 HCW	30 min	++++	+ (SL P)	++	+	+ (SL P)	+ (SL P)	++++	+ (SL P)	+ (SL P)	+ (SL P)	+	+++	
	MP410 HCW	24 hour	++++	+ (P)	++	+ (CF)	+++	+ (SL P)	++++	+ (SL P)	+++	+ (P)	+++	+++	
	MP410 HCW	72 hours	++++	+++	++ (CF)	+ (CF)	+++	+ (P)	++++	+ (P)	++++	+++	++++	+++	
	MP410 HCW	2 Weeks	++++	+++	++ (CF)	+ (CF)	+++	+ (P)	++++	+++	++++	+++	++++	+++	
	MP410 HCW	1 week @ 140°F	++++	++++	- (CF)	- (CF)	++++	+ (P)	+ (CF&P)	- (CF)	++++	+ (CF)	+++ (CF)	+ (CF)	

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Mactac is ISO9000-2000 certified.
Mactac is a member of the following organizations:

- Gasket Fabricators Association
- National Association of Graphic and Product Identification Manufacturers, Inc. (GPI)
- Pressure Sensitive Tape Council (PSTC)

