

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.

Armacell is a manufacturer of high-performance, elastomeric closed-cell foam.



General Gasketing



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 Destruction		"+++ " = Very Aggressive		"++" = Agressive		"+ " = Mild		"- " = Poor	
				"SL P" = Slight Picking <20%		"P" = Picking (25-50%)		"CF" = Cohesive Failure		"AT" = Adhesive Transfer		"CF&P = Cohesive Failure & Picking	
				GIC	AFM Med.	ICF400	.5 ECF400	1.25 ECF400	1400	MLC2TAN	MLC2BLK		
				Nitrile-PVC Blend	Nitrile-PVC Blend	Nitrile-PVC Blend	EPDM	EPDM	Neoprene	Nitrile-PVC Blend	Nitrile-PVC Blend		
Formula	Dwell	Skin	Embossed	Skin	Skin	Skin	Skin	Skin	Skin	Skin	Skin		
Rubber Adhesives	MP-593XT	30 min @ RT	-	+ (P)	+ (P)	+ (P)	+ (P)	+ (P)	++	+	+		
	MP-593XT	24 hour @ RT	+ (P)	+ (P)	+ (P)	++++	++++	++++	+++	+	+		
	MP-593XT	72 hours @ RT	+ (P)	+ (P)	+ (P)	++++	++++	++++	+++	+	+		
	MP-593XT	2 Weeks @ RT	+ (P)	+ (P)	+++	++++	++++	++++	+++	+	+		
	MP-593XT	1 week @ 140°F	+++	+ (CF)	++++	++++	++++	++++	++ (CF)	+++	+++		
	MP-899	30 min @ RT	+++	+ (P)	++++	++++	++++	++++	+++	++	+++		
	MP-899	24 hour @ RT	+++	-	++++	++++	++++	++++	+++	++	+++		
	MP-899	72 hours @ RT	+++	-	++++	++++	++++	++++	+++	++	+++		
	MP-899	2 Weeks @ RT	+++	-	++++	++++	++++	++++	+++	++	+++		
	MP-899	1 week @ 140°F	+++ (CF)	- (CF)	- (CF)	++++	++ (CF)	++ (CF)	- (CF)	- (CF)	+++	+++	
Acrylic Adhesives	MP410 LCW	30 min @ RT	+	-	+ (P)	+	+	+	+	+	+		
	MP410 LCW	24 hour @ RT	+ (P)	+ (P)	++++	+	+	+	+ (P)	++	+++		
	MP410 LCW	72 hours @ RT	+++	+ (P)	++++	+	+	+	+ (P)	++++	++++		
	MP410 LCW	2 Weeks @ RT	+++	+ (P)	++++	+	+	+	+ (P)	+++	++++		
	MP410 LCW	1 week @ 140°F	++++	+ (CF)	++++	+	+	+ (SL P)	+ (CF)	++++	++++		
	MP410 HCW	30 min @ RT	+	+++	+ (P)	+	+	+	+ (P)	+	+++		
	MP410 HCW	24 hour @ RT	+++	+++	++++	+	+	+	+ (P)	++++	++++		
	MP410 HCW	72 hours @ RT	+++	++ (P)	++++	+	+	+	+++	++++	++++		
	MP410 HCW	2 Weeks @ RT	+++	++ (P)	++++	+	+	+	+++ (AT)	++++	++++		
	MP410 HCW	1 week @ 140°F	++++	++ (CF)	++++	+	+	+ (P)	+ (CF)	++++	++++		

Migration @ 140°F

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				"SL P" = Slight Picking <20%		"P" = Picking (25-50%)		"CF" = Cohesive Failure		"AT" = Adhesive Transfer		"CF&P = Cohesive Failure & Picking	
				TAN LCS	IV1	IR41	IV3	OER	EG1	FCO	SFO		
				Nitrile-PVC Blend	NBR-PVC-CR Blend	NBR-PVC-CR Blend	NBR-PVC-CR Blend	Nitrile-PVC Blend	EPDM	Nitrile-PVC Blend	Nitrile-PVC Blend		
Formula	Dwell	Skin	Skin	Skin	Skin	Skin	Skin	Skin	Skin	Skin	Skin		
Rubber Adhesives	MP-593XT	30 min @ RT	-	-	++++	-	++++	++++	++++	++++	++++		
	MP-593XT	24 hour @ RT	-	-	++++	-	++++	++++	++++	++++	++++		
	MP-593XT	72 hours @ RT	-	-	++++	-	++++	++++	++++	++++	++++		
	MP-593XT	2 Weeks @ RT	-	-	++++	-	++++	++++	++++	++++	++++		
	MP-593XT	1 week @ 140°F	++ (CF)	++++	++++	+ (CF)	++++	++++	++++	++++	++++		
	MP-899	30 min @ RT	+	+ (P)	++++	+	++++	++++	++++	++++	++++		
	MP-899	24 hour @ RT	+	+ (P)	++++	+	++++	++++	++++	++++	++++		
	MP-899	72 hours @ RT	+	+ (P)	++++	+	++++	++++	++++	++++	++++		
	MP-899	2 Weeks @ RT	+	+ (P)	++++	+	++++	++++	++++	++++	++++		
	MP-899	1 week @ 140°F	++ (CF)	+ (CF)	++++	- (CF)	++++	++++	++++	++++	++++		
Acrylic Adhesives	MP410 LCW	30 min @ RT	+	+ (P)	+ (P)	+	++++	++++	++++	++++	++++		
	MP410 LCW	24 hour @ RT	+	+++	++++	++	++++	++++	++++	++++	++++		
	MP410 LCW	72 hours @ RT	+	++++	++++	++ (AT)	++++	++++	++++	++++	++++		
	MP410 LCW	2 Weeks @ RT	+ (CF)	++++	++++	++ (AT)	++++	++++	++++	++++	++++		
	MP410 LCW	1 week @ 140°F	+ (CF)	++++	++++	++ (CF/AT)	++++	++++	++++	++++	++++		
	MP410 HCW	30 min	++	+ (P)	+++	++	++++	++++	++++	++++	++++		
	MP410 HCW	24 hour	++	++++	++++	++	++++	++++	++++	++++	++++		
	MP410 HCW	72 hours	++	++++	++++	++ (CF)	++++	++++	++++	++++	++++		
	MP410 HCW	2 Weeks	++ (CF/AT)	++++	++++	++ (CF)	++++	++++	++++	++++	++++		
	MP410 HCW	1 week @ 140°F	+ (CF)	++++	++++	++ (CF)	++++	++++	++++	++++	++++		

Migration @ 140°F

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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)

