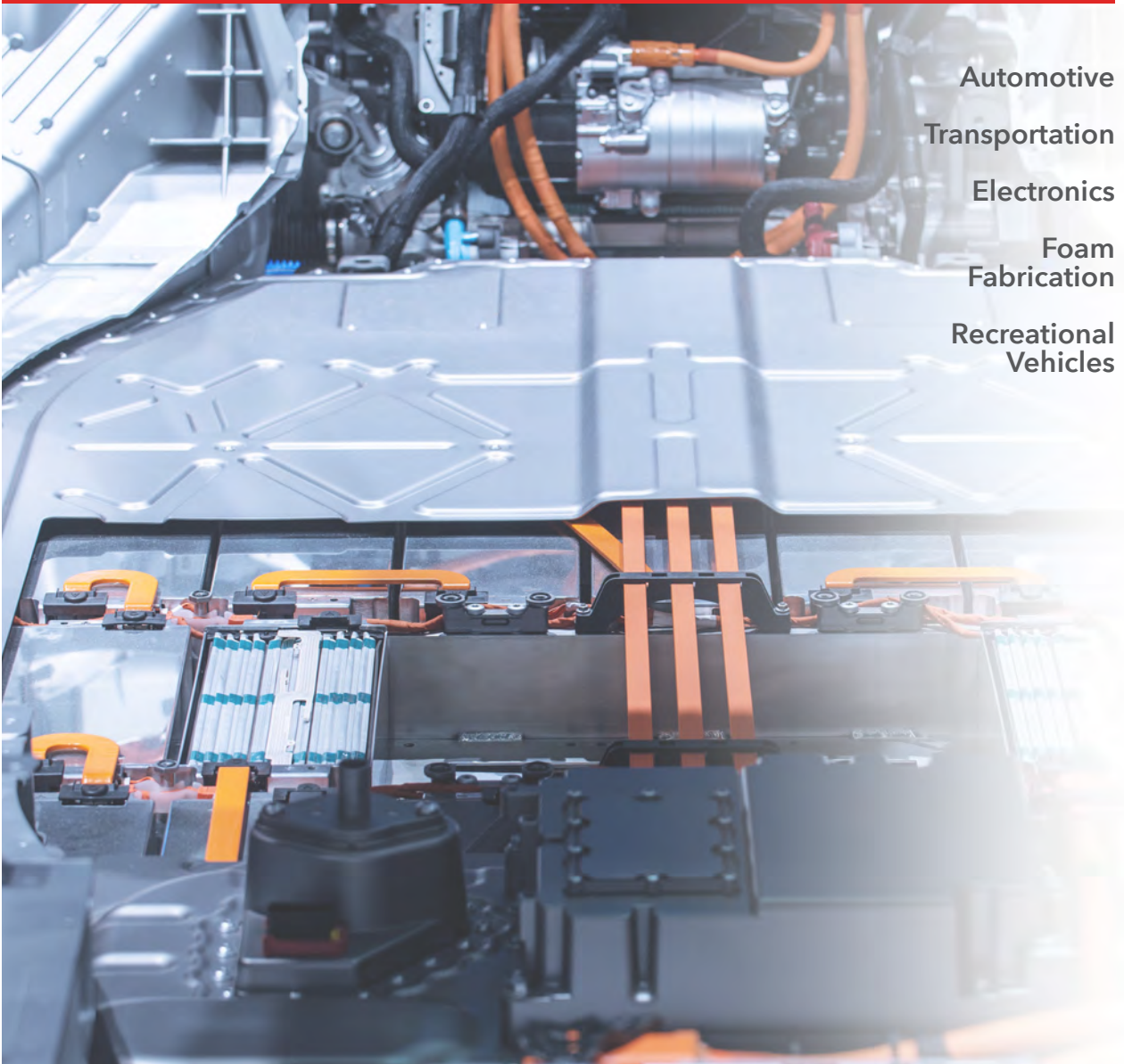


# Materials Guide for EV

## Engineered Tapes & Laminates



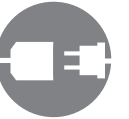
Automotive

Transportation

Electronics

Foam  
Fabrication

Recreational  
Vehicles



Mactac engineered tapes and laminates offer pressure sensitive adhesive solutions for bonding, mounting, and reinforcing specialty materials for the battery market. PSA-backed specialty materials offer thermal management, electrical insulation, NVH dampening, and other properties that can improve pack safety, increase efficiency, reduce weight, and simplify design.

# Mactac® Adhesion Testing on Armacell Foam Grades

		FC0 NBR/PVC		AHC NBR/PVC		IG3 NBR/PVC/CR		IVC NBR/PVC/CR		OER NBR/PVC	IV2 NBR/PVC/CR		
Formula	Dwell	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut	skin	Skin	Cut	
Rubber Adhesives	LV790	30 min @ RT	++++	++++	-	+	+	-	-	-	++++	-	-
		24 hour @ RT	++++	++++	-	+	++	+	-	-	++++	-	-
		72 hours @ RT	++++	++++	-	+	+++ (CF, SL P)	+	+	-	++++	-	+
		2 Weeks @ RT	++++	++++	-	+	+++ (SL P)	+	+	+	++++	-	+
		1 week @ 140°F	++++	++++	+++ (CF)	++ (SL P)	+++ (CF)	+	+++ (SL P)	++ (SL P)	++++	+++ (P)	+
	LV780	30 min @ RT	++++	++++	++	++	+++ (CF)	++ (SL P)	+	+++ (P)	++++	+	++ (SL P)
		24 hour @ RT	++++	++++	++	+++ (CF)	+++	++ (SL P)	++	++ (SL P)	++++	++	++ (SL P)
		72 hours @ RT	++++	++++	++	+++ (CF)	+++ (CF)	++ (SL P)	++	+++ (CF)	++++	++	++ (SL P)
		2 Weeks @ RT	++++	++++	++	+++ (P)	++++	+++ (CF)	++	++++	++++	++	++++
		1 week @ 140°F	++++	++++	+++ (CF)	+++ (CF)	+++ (CF)	+++ (CF)	+++ (CF)	+++ (CF)	++++	++ (CF)	+++ (CF)
LV750	30 min @ RT	++++	++ (P)	-	-	+	-	-	+	++++	-	-	
	24 hour @ RT	++++	++ (P)	-	-	+	-	+	+	++++	+	-	
	72 hours @ RT	++++	++ (P)	+	-	++ (SL P)	-	+	+	++++	+	-	
	2 Weeks @ RT	++++	++++	+	-	+++	-	+	+	++++	+	-	
	1 week @ 140°F	++++	++++	+++	+	+++	+	++	+	++++	+++ (SL P)	+	
Acrylic Adhesives	LV820 2.0 mil	30 min @ RT	++++	++++	++	+++	+	++ (SL P)	+	+++ (CF, P)	++++	++	+++ (CF, P)
		24 hour @ RT	++++	++++	+++	+++ (CF, SL P)	++	++ (SL P)	+++ (CF, SL P)	+++ (CF, P)	++++	+++ (SL P)	++++ (CF)
		72 hours @ RT	++++	++++	+++	+++ (CF, SL P)	+++ (SL P)	++ (SL P)	++++ (CF)	+++ (P)	++++	+++ (SL P)	++++ (CF)
		2 Weeks @ RT	++++	++++	+++ (SL P)	++++	+++ (SL P)	++ (SL P)	++++	++++	++++	+++ (CF, SL P)	++++ (CF)
		1 week @ 140°F	++++	++++	+++ (CF)	++ (CF)	++ (CF)	+	++++	+++ (CF, P)	++++	+++ (CF, P)	+++ (CF, SL P)
	LV820 4.0 mil	30 min @ RT	++++	++++	+++	+++ (CF, SL P)	++	+++ (SL P)	+++	+++ (CF, P)	++++	+++	++++ (CF)
		24 hour @ RT	++++	++++	+++ (CF)	+++ (CF, AT)	+++	+++ (SL P)	++++	+++ (P)	++++	++++	++++ (CF)
		72 hours @ RT	++++	++++	+++ (CF, AT)	+++ (CF, P)	+++ (CF, P)	+++ (CF, SL P)	++++ (CF)	++++	++++	++++	++++ (CF)
		2 Weeks @ RT	++++	++++	+++ (AT)	+++ (CF)	+++ (CF)	+++ (CF, P)	++++	++++	++++	+++ (AT)	++++ (CF)
		1 week @ 140°F	++++	++++	+++ (CF)	+++ (CF)	+++ (CF)	+++ (CF, SL P)	++++	+++ (CF, P)	++++	+++ (CF, P)	+++ (CF, P)
	LV840	30 min @ RT	++++	++++	++	++	+	+	++	++ (P)	++++	++	+++ (CF, P)
		24 hour @ RT	++++	++++	++	++ (SL P)	++	+	+++ (CF, SL P)	++ (SL P)	++++	++ (SL P)	++ (CF, P)
		72 hours @ RT	++++	++++	++	++ (SL P)	+++ (SL P)	+	++++ (CF)	++ (SL P)	++++	+++ (CF, SL P)	++ (CF, P)
		2 Weeks @ RT	++++	++++	++	++++	+++ (SL P)	++++ (CF)	++++	+++ (P)	++++	+++ (CF, P)	++++
		1 week @ 140°F	++++	++++	+++ (CF, SL P)	++ (CF, AT)	++	+	+++ (SL P)	+++ (P)	++++	++++	+++ (SL P)
LV860	30 min @ RT	++++	++++	+	+++	+	++ (SL P)	+	+++ (P)	++++	+	+++ (P)	
	24 hour @ RT	++++	++++	+	++++	+++	++ (SL P)	++	+++ (P)	++++	++ (SL P)	++++	
	72 hours @ RT	++++	++++	+++ (CF)	++++	+++ (CF, P)	++ (SL P)	++++ (CF)	++++	++++	+++ (CF, SL P)	++++	
	2 Weeks @ RT	++++	++++	+++ (CF)	++++	+++ (CF, P)	+++ (P)	++++	++++	++++	++++	++++	
	1 week @ 140°F	++++	++++	+++ (CF)	++ (CF)	+++ (CF)	+	+++ (SL P)	++++	++++	++++	+++ (SL P)	
LV850	30 min @ RT	++++	+++ (P)	-	++	+	++	+	+++ (SL P)	++++	-	+	
	24 hour @ RT	++++	+++ (P)	+	++++	+	++ (SL P)	++	+++ (SL P)	++++	++	+++ (P)	
	72 hours @ RT	++++	+++ (P)	+	++++	+++ (CF)	++ (SL P)	++	++++	++++	+++ (P)	+++ (P)	
	2 Weeks @ RT	++++	++++	+	++++	+++ (CF, P)	++ (SL P)	+++ (SL P)	++++	++++	++++	++++	
	1 week @ 140°F	++++	++++	+++	++++	+++ (CF, P)	++ (SL P)	+++ (P)	++++	++++	+++ (CF, P)	++	

## Key

++++	Foam Destruction	SL P	Slight Picking 20%
+++	Very Aggressive	P	Picking 20-50%
++	Aggressive	CF	Cohesive Failure
+	Mild	CF & P	Cohesive Failure & Picking
-	Poor		

# Mactac® Adhesion Testing on Armacell Foam Grades

		1800 NBR/PVC		MLC-2 NBR/PVC		APH NBR/PVC		ALC NBR/PVC		IG1 NBR/PVC/CR		
Formula	Dwell	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut	
Rubber Adhesives	LV790	30 min @ RT	++++	++ (P)	++	+++ (P)	++++	++ (P)	-	-	+	+(SL P)
		24 hour @ RT	++++	++ (P)	++++	+++ (P)	++++	++ (p)	-	-	+	+(SL P)
		72 hours @ RT	++++	++ (P)	++++	++++	++++	++++	-	-	++ (SL P)	+(SL P)
		2 Weeks @ RT	++++	++ (P)	++++	++++	++++	++++	-	-	+(SL P)	+(SL P)
		1 week @ 140°F	++++	++++	++++	++++	++++	++++	+(SL P)	+(SL P)	++++ (CF)	+(SLP)
	LV780	30 min @ RT	++++	++++	+++ (P)	++++	++++	++++	+	++	++++	++++
		24 hour @ RT	++++	++++	++++ (CF)	++++	++++	++++	++	++	++++	+++ (P)
		72 hours @ RT	++++	++++	++++ (CF)	++++	++++	++++	++	+++ (CF)	++++	++++
		2 Weeks @ RT	++++	++++	++++	++++	++++	++++	++	+++ (SL P)	++++	++++
		1 week @ 140°F	++++	++++	+++ (CF)	++++	++++	++++	+++ (CF)	+++ (CF)	+++ (CF)	+++ (CF)
	LV750	30 min @ RT	++++	++ (P)	++	++++	++++	+++ (P)	-	-	+	+(SL P)
		24 hour @ RT	++++	++ (P)	++ (P)	++++	++++	+++ (P)	-	-	++ (P)	++ (SL P)
		72 hours @ RT	++++	++ (P)	++++	++++	++++	++++	-	-	++ (P)	++ (SL P)
		2 Weeks @ RT	++++	++++	++++	++++	++++	++++	-	-	++ (P)	++ (SL P)
		1 week @ 140°F	++++	++ (P)	++++	++++	++++	++++	+	-	++++	++++
Acrylic Adhesives	LV820 2.0 mil	30 min @ RT	++ (P)	++ (P)	+++	++++	++++	++++	+	++	++ (SL P)	++ (P)
		24 hour @ RT	++++	+++ (P)	+++ (SL P)	++++	++++	++++	++ (CF)	+++ (CF, SL P)	++ (SL P)	++ (P)
		72 hours @ RT	++++	+++ (P)	++++	++++	++++	++++	++ (CF)	+++ (CF, SL P)	++ (SL P)	++ (P)
		2 Weeks @ RT	++++	++++	++++ (CF)	++++	++++	++++	++ (CF)	+++ (AT)	++ (SL P)	++++
		1 week @ 140°F	++++	++++	++++	++++	++++	++++	++ (CF)	++ (CF)	++ (CF)	++++
	LV820 4.0 mil	30 min @ RT	++++	++++	+++ (CF)	++++	++++	++++	++	+++	+++ (SL P)	++++
		24 hour @ RT	++++	++++	++++ (CF)	++++	++++	++++	+++ (CF)	+++ (AT, SL P)	++++	++++
		72 hours @ RT	++++	++++	++++ (AT)	++++	++++	++++	+++ (CF)	+++ (AT, SL P)	++++	++++
		2 Weeks @ RT	++++	++++	++++ (AT)	++++	++++	++++	+++ (CF, SL P)	++++ (AT)	++++	++++
		1 week @ 140°F	++++	++++	++++	++++	++++	++++	+++ (CF)	+++ (CF, SL P)	+++ (CF)	++++
	LV840	30 min @ RT	++ (SL P)	+(SL P)	++	++++	+++ (P)	++ (SL P)	+	++	+	+
		24 hour @ RT	++++	+(SL P)	++	++++	+++ (P)	+++ (P)	++	++ (SL P)	+	+
		72 hours @ RT	++++	+(SL P)	+++ (CF, SL P)	++++	++++	+++ (P)	++	++ (SL P)	++ (P)	+(SL P)
		2 Weeks @ RT	++++	++ (P)	++++	++++	++++	++++	+++ (CF)	++ (SL P)	++	++++
		1 week @ 140°F	++++	++ (P)	++++	++++	++++	++++	++ (SL P)	++ (SL P)	+(SL P)	++++
LV860	30 min @ RT	++++	++ (P)	++	++++	++++	++++	+	+	+	++ (SL P)	
	24 hour @ RT	++++	++ (P)	++	++++	++++	++++	++	+++ (CF, SL P)	+	+++ (P)	
	72 hours @ RT	++++	++ (P)	++++	++++	++++	++++	+++	+++ (CF, SL P)	+	+++ (P)	
	2 Weeks @ RT	++++	++++	++++	++++	++++	++++	+++ (CF, SL P)	++++	+	++++	
	1 week @ 140°F	++++	++++	++++	++++	++++	++++	++ (CF, SL P)	++ (CF, SL P)	+(SL P)	++++	
LV850	30 min @ RT	+	++ (SL P)	+	++++	++ (SL P)	++ (SL P)	+	+	+	++ (SL P)	
	24 hour @ RT	++ (P)	++ (SL P)	++	++++	++++	+++ (P)	+	+++ (CF, SL P)	+	++ (SL P)	
	72 hours @ RT	++++	++ (SL P)	++++	++++	++++	+++ (P)	++	+++ (CF, SL P)	++ (P)	++ (P)	
	2 Weeks @ RT	++++	++++	++++	++++	++++	++++	++ (CF)	++++	+(SL P)	++++	
	1 week @ 140°F	++++	++++	++++	++++	++++	++++	+	+++ (CF, P)	+(SL P)	++++	

## Key

++++	Foam Destruction	SLP	Slight Picking 20%
+++	Very Aggressive	P	Picking 20-50%
++	Aggressive	CF	Cohesive Failure
+	Mild	CF & P	Cohesive Failure & Picking
-	Poor		

# Mactac® Adhesion Testing on Armacell Foam Grades

		GIC NBR/PVC		IV3 NBR/PVC/CR		IV1 NBR/PVC/CR		IG2 NBR/PVC/CR		IGB NBR/PVC/CR		
Formula	Dwell	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut	Skin	Cut	
Rubber Adhesives	LV790	30 min @ RT	+	++ (P)	-	-	-	-	-	-	++	+(SL P)
		24 hour @ RT	++ (SL P)	++++	-	-	-	+	+	-	+++	+
		72 hours @ RT	++ (SL P)	++ (P)	-	-	-	+(SL P)	+(SL P)	+	++++	++ (SL P)
		2 Weeks @ RT	++++	++ (P)	-	-	-	+(SL P)	+(SL P)	+	++++	++ (SL P)
		1 week @ 140°F	++++	++++	+	+	+(SL P)	++ (P)	++ (CF)	++ (SL P)	+++ (CF, SL P)	++ (SL P)
	LV780	30 min @ RT	+++ (SL P)	++++	+	+	+	++++	++	+++ (SL P)	+++ (SL P)	+++ (P)
		24 hour @ RT	++++	++++	+	+	+	++++	+++ (CF)	+++ (SL P)	++++	+++ (P)
		72 hours @ RT	++++	++++	+	++	++ (CF, SL P)	++++	+++ (CF)	+++ (SL P)	++++	+++ (P)
		2 Weeks @ RT	++++	++++	+	+++ (P)	+++ (CF, SL P)	++++	+++ (CF)	++++	++++	+++ (P)
		1 week @ 140°F	++++	++++	+++ (CF)	+++ (CF)	+++ (CF)	+++ (CF)	+++ (CF)	+++ (CF)	+++ (CF)	+++ (CF)
	LV750	30 min @ RT	+	+(SL P)	-	-	-	-	+	-	++	+
		24 hour @ RT	+(P)	++ (P)	-	-	+	-	+	+	++	+
		72 hours @ RT	+(P)	++ (P)	-	-	+	+	+	+	++ (SL P)	+
		2 Weeks @ RT	++ (P)	++ (P)	-	-	+	+(SL P)	+	+	++ (SL P)	+
		1 week @ 140°F	++++	+++ (P)	+	+	++ (SL P)	+(SL P)	++	++	++ (CF, SL P)	++ (SL P)
Acrylic Adhesives	LV820 2.0 mil	30 min @ RT	++ (SL P)	+++ (P)	+	++	++ (SL P)	++++	++	++ (SL P)	+	++ (SL P)
		24 hour @ RT	++++	++++	++ (CF)	+++ (CF, SL P)	+++ (CF, SL P)	++++	+	++ (SL P)	++	++ (P)
		72 hours @ RT	++++	++++	++ (CF)	+++ (CF, SL P)	+++ (CF, P)	++++	+	++ (SL P)	++	++ (P)
		2 Weeks @ RT	++++	++++	++ (CF)	++++	++++	++++	+	++ (P)	++	++ (P)
		1 week @ 140°F	++++	++++	++ (CF)	+(CF)	+++ (CF, P)	+++ (CF, SL P)	+(CF)	+(CF)	++ (CF)	++ (CF)
	LV820 4.0 mil	30 min @ RT	+++ (P)	++++	++	+++ (SL P)	+++ (SL P)	++++	++	+++ (P)	++	+++ (P)
		24 hour @ RT	++++	++++	+++ (CF)	+++ (CF, P)	++++	++++	++	+++ (P)	+++	+++ (P)
		72 hours @ RT	++++	++++	+++ (CF)	+++ (CF, P)	++++	++++	+++	+++ (P)	+++ (CF, P)	++++
		2 Weeks @ RT	++++	++++	+++ (CF)	++++ (AT)	++++	++++	+++	++++	+++ (CF, P)	++++
		1 week @ 140°F	++++	++++	+++ (CF)	+++ (CF)	+++ (CF, P)	+++ (CF, SL P)	++ (CF)	++ (CF)	+++ (CF)	++ (CF)
	LV840	30 min @ RT	++ (SL P)	++ (P)	+	++	++	++++	+	++	++	+
		24 hour @ RT	++++	+++ (P)	+	++	++ (SL P)	++++	+	++	++	++ (SL P)
		72 hours @ RT	++++	+++ (P)	+	++	++++	++++	+	++	++	++ (SL P)
		2 Weeks @ RT	++++	++++	+	+++ (P)	++++	++++	+	+(SL P)	++	++ (SL P)
		1 week @ 140°F	++++	++++	++ (SL P)	++ (SL P)	+++ (P)	++++	+	+	+(CF)	-
LV860	30 min @ RT	++ (SL P)	++++	+	++	+	++++	+	++ (SL P)	+	++ (SL P)	
	24 hour @ RT	++++	++++	+	+++ (P)	++ (SL P)	++++	+	++ (SL P)	++	+++ (SL P)	
	72 hours @ RT	++++	++++	++	+++ (P)	++++	++++	+	++ (SL P)	++	++ (SL P)	
	2 Weeks @ RT	++++	++++	++ (CF)	++++	++++	++++	+	++ (P)	++ (SL P)	++ (SL P)	
	1 week @ 140°F	++++	++++	+++ (CF)	+(CF)	++++	+++ (CF, P)	+	++	+(CF)	+	
LV850	30 min @ RT	+(SL P)	++ (SL P)	-	++ (SL P)	+	++++	+	+	+	+	
	24 hour @ RT	++ (SL P)	+++ (P)	+	++ (SL P)	++	++++	+	++	+	++ (SL P)	
	72 hours @ RT	++++	++++	+	++ (SL P)	+++ (P)	++++	+	++ (SL P)	+	++ (SL P)	
	2 Weeks @ RT	++++	++++	++	+++ (P)	+++ (P)	++++	+	++ (SL P)	+	++ (SL P)	
	1 week @ 140°F	++++	++++	++	+++ (SL P)	++ (SL P)	++++	+	+	++	+	

## Key

++++	Foam Destruction	SL P	Slight Picking 20%
+++	Very Aggressive	P	Picking 20-50%
++	Aggressive	CF	Cohesive Failure
+	Mild	CF & P	Cohesive Failure & Picking
-	Poor		

# Mactac® Adhesion Testing on ARPlank Foam Grades

		Formula	Dwell	EPP 28	EPP 19	EPE 23	EPE 46
Rubber Adhesives	LV790		30 min @ RT	+	+	++ (SL P)	++
			24 hour @ RT	+	+	++ (SL P)	++ (SL P)
			72 hours @ RT	++	+	++ (SL P)	+++ (SL P)
			2 Weeks @ RT	++ (SL P)	++ (SL P)	++ (SL P)	+++ (SL P)
			1 week @ 140°F	++ (SL P)	++ (SL P)	++ (P)	++++
	LV780		30 min @ RT	++ (P)	++ (SL P)	++++	+++ (SL P)
			24 hour @ RT	++ (CF, SL P)	+++ (CF, P)	++++	+++ (CF, SL P)
			72 hours @ RT	++++	+++ (CF, P)	++++	+++ (CF, SL P)
			2 Weeks @ RT	++++	++++	++++	++++ (CF)
			1 week @ 140°F	++++	++++	++++	++++
	LV750		30 min @ RT	+	+	++	++
			24 hour @ RT	+	+	++	++
			72 hours @ RT	+	+	++	++
			2 Weeks @ RT	+	+	++	++
			1 week @ 140°F	++	++ (SL P)	++ (SL P)	++++
Acrylic Adhesives	LV820 2.0 mil		30 min @ RT	+	+	++++	+
			24 hour @ RT	+	+	++++	+(P)
			72 hours @ RT	+(SL P)	++(SL P)	++++	++(SL P)
			2 Weeks @ RT	+(SL P)	++(SL P)	++++	++++
			1 week @ 140°F	+(SL P)	++(SL P)	++++	++++ (CF)
	LV820 4.0 mil		30 min @ RT	++(SL P)	+++ (SL P)	++++	+++
			24 hour @ RT	+++ (P)	+++ (P)	++++	+++ (AT, P)
			72 hours @ RT	+++ (P)	+++ (P)	++++	+++ (AT, P)
			2 Weeks @ RT	++++	++++	++++	++++ (AT)
			1 week @ 140°F	++++	++++	++++	++++ (AT)
	LV840		30 min @ RT	+	-	+(SL P)	+
			24 hour @ RT	+	-	+(SL P)	+(SL P)
			72 hours @ RT	+	-	+(SL P)	+(SL P)
			2 Weeks @ RT	+	-	++(SL P)	+++ (P)
			1 week @ 140°F	+	+	++ (P)	+++ (P)
LV860		30 min @ RT	+++ (SL P)	+(SL P)	++++	+++ (P)	
		24 hour @ RT	+++ (SL P)	+(SL P)	++++	+++ (CF, P)	
		72 hours @ RT	+++ (SL P)	+(SL P)	++++	++++	
		2 Weeks @ RT	+++ (P)	++(SL P)	++++	++++	
		1 week @ 140°F	+++ (P)	++(SL P)	++++	++++	
LV850		30 min @ RT	+	+	++ (SL P)	++	
		24 hour @ RT	+	+	++ (SL P)	++ (P)	
		72 hours @ RT	++ (SL P)	+(SL P)	+++ (P)	++++	
		2 Weeks @ RT	++ (SL P)	+(SL P)	++++	++++	
		1 week @ 140°F	++ (P)	+(SL P)	++++	++++	

## Key

++++ Foam Destruction  
 +++ Very Aggressive  
 ++ Aggressive  
 + Mild  
 - Poor

SL P Slight Picking 20%  
 P Picking 20-50%  
 CF Cohesive Failure  
 CF & P Cohesive Failure & Picking

# Mactac® Adhesion Testing on World Wide Foam Grades

		Foam Dunnage				Foam in Battery			
Formula	Dwell	SC-30 XLPE	SC-41 XLPE	SC-61 XLPE	XP-18UL FIRE RETARDANT XLPE	3091 EPDM	XE-20 XLPE CHEMICAL ROLL	XEV-20 XLPE	
Rubber Adhesives	LV790	30 min @ RT	++ (P)	++ (P)	+ (SL P)	++ (SL P)	++ (P)	+++ (P)	++ (P)
		24 hour @ RT	++ (P)	++ (P)	+ (SL P)	+++ (SL P)	++ (P)	++ (SL P)	++ (P)
		72 hours @ RT	++ (P)	++ (P)	+ (SL P)	++++	++ (P)	++ (SL P)	++ (P)
		2 Weeks @ RT	+++ (P)	++ (P)	+ (SL P)	++++	++++	++ (SL P)	++ (P)
		1 week @ 140°F	++++	+++ (P)	+ (SL P)	++++	++ (P)	++ (SL P)	++ (SL P)
	LV780	30 min @ RT	++++	+++ (P)	++ (SL P)	++++	++++	++++	++++
		24 hour @ RT	++++	++++	++	++++	++++	++++	++++
		72 hours @ RT	++++	++++	+++ (P)	++++	++++	++++	++++
		2 Weeks @ RT	++++	++++	+++ (P)	++++	++++	++++	++++
		1 week @ 140°F	++++	++++	+++ (P)	++++	++++ (CF)	++++	++++
	LV750	30 min @ RT	+ (SL P)	++ (P)	+ (SL P)	+ (SL P)	+ (SL P)	++ (SL P)	+ (SL P)
		24 hour @ RT	++ (P)	+ (SL P)	+ (SL P)	++ (SL P)	+ (SL P)	+ (SL P)	+ (SL P)
		72 hours @ RT	++ (P)	+ (SL P)	+ (SL P)	++ (SL P)	++++	+ (SL P)	+ (P)
		2 Weeks @ RT	++ (P)	++ (SL P)	+ (SL P)	++++	++++	+ (SL P)	++ (P)
		1 week @ 140°F	++ (P)	+ (SL P)	+ (SL P)	++++	++ (P)	+ (SL P)	+ (SL P)
Acrylic Adhesives	LV820 2.0 mil	30 min @ RT	++++	+	-	++++	++++	-	+++ (P)
		24 hour @ RT	++++	+	-	++++	++++	-	+++ (P)
		72 hours @ RT	++++	+ (SL P)	-	++++	++++	-	+++ (P)
		2 Weeks @ RT	++++	+ (SL P)	-	++++	++++	-	+++ (P)
		1 week @ 140°F	++++	+ (SL P)	+ (SL P)	++++	++++	+ (SL P)	+++ (P)
	LV820 4.0 mil	30 min @ RT	++++	+ (SL P)	+	++++	++++	+	++++
		24 hour @ RT	++++	+ (SL P)	+	++++	++++	+	++++
		72 hours @ RT	++++	++++	+	++++	++++	++ (P)	++++
		2 Weeks @ RT	++++	++++	++	++++	++++	++ (P)	++++
		1 week @ 140°F	++++	++++	++ (SL P)	++++	++++	++ (P)	++++
	LV840	30 min @ RT	++++	-	-	++++	++ (P)	-	++ (SL P)
		24 hour @ RT	++++	-	-	++++	++ (P)	-	++ (SL P)
		72 hours @ RT	++++	-	-	++++	++++	-	+ (SL P)
		2 Weeks @ RT	++++	-	-	++++	++++	-	+ (SL P)
		1 week @ 140°F	++++	+	+	++++	++++	-	+ (SL P)
LV860	30 min @ RT	++++	+ (SL P)	+ (SL P)	++++	++++	+ (SL P)	+++ (P)	
	24 hour @ RT	++++	+	+ (SL P)	++++	++++	+ (SL P)	+++ (P)	
	72 hours @ RT	++++	++ (P)	+ (SL P)	++++	++++	++ (P)	+++ (P)	
	2 Weeks @ RT	++++	++ (P)	+ (SL P)	++++	++++	++ (P)	+++ (P)	
	1 week @ 140°F	++++	++ (P)	+ (SL P)	++++	++++	++ (P)	+++ (P)	
LV850	30 min @ RT	++++	+ (SL P)	+ (SL P)	++++	++++	+ (SL P)	++ (P)	
	24 hour @ RT	++++	+ (SL P)	+ (SL P)	++++	++++	+ (SL P)	++ (P)	
	72 hours @ RT	++++	+ (SL P)	+ (SL P)	++++	++++	++ (P)	++ (P)	
	2 Weeks @ RT	++++	+ (SL P)	+ (SL P)	++++	++++	++ (P)	++ (P)	
	1 week @ 140°F	++++	+ (SL P)	+ (SL P)	++++	++++	++ (P)	++ (SL P)	

## Key

++++	Foam Destruction	SLP	Slight Picking 20%
+++	Very Aggressive	P	Picking 20-50%
++	Aggressive	CF	Cohesive Failure
+	Mild	CF & P	Cohesive Failure & Picking
-	Poor		

# Mactac® Adhesion Testing on Rogers Corporation Foam Grades

		Formula	Dwell	40V0 - 12236 - 04 23 - 7 - 45 CAST UL-V0 PU	40V0 - 12236 - 04 23 - 7 - 45 TOP UL-V0 PU	43-20PCF PORON	43-16PCF PORON	4701-41-15500- 04 PORON	4701-30-15500- 04 PORON	4790-92-15500- 04 P ORON
Rubber Adhesives	LV790	30 min @ RT	-	+	(SL P)	+	-	-	-	+
		24 hour @ RT	-	+	(SL P)	+	-	-	-	++ (P)
		72 hours @ RT	+	+	(SL P)	+	-	-	-	++++
		2 Weeks @ RT	+	++ (P)	+	-	-	++ (P)	++++	
		1 week @ 140°F	++++	++++	++++	++++	++++	++++	++++	
	LV780	30 min @ RT	++++	++++	+++ (CF)	+++ (SL P)	++++	++++	++++	
		24 hour @ RT	++++	++++	+++ (CF, SL P)	+++ (SL P)	++++	++++	++++	
		72 hours @ RT	++++	++++	+++ (CF, SL P)	+++ (SL P)	+	++++	++++	
		2 Weeks @ RT	++++	++++	++++	++++	+	++++	++++	
		1 week @ 140°F	++++	++++	++++	++++	+(SL P))	++++	++++	
	LV750	30 min @ RT	-	-	+	-	-	-	++++	
		24 hour @ RT	-	+	(SL P)	+	-	-	-	
		72 hours @ RT	+	+	(SL P)	+	-	-	-	
		2 Weeks @ RT	+(SL P)	++ (P)	++	+	-	-	-	
		1 week @ 140°F	-	+(SL P)	++++	++++	-	++++	++++	
Acrylic Adhesives	LV820 2.0 mil	30 min @ RT	++++	++++	+++	+++ (SL P)	++	++++	++++	
		24 hour @ RT	++++	++++	+++	+++ (SL P)	++++	++++	++++	
		72 hours @ RT	++++	++++	+++	+++ (P)	++++	++++	++++	
		2 Weeks @ RT	++++	++++	+++ (SL P)	++++	++++	++++	++++	
		1 week @ 140°F	++++	++++	+++ (AT)	++++	++++	++++	++++	
	LV820 4.0 mil	30 min @ RT	++++	++++	+++	+++ (SL P)	+++	++++	++++	
		24 hour @ RT	++++	++++	+++	+++ (SL P)	++++	++++	++++	
		72 hours @ RT	++++	++++	+++	+++ (P)	++++	++++	++++	
		2 Weeks @ RT	++++	++++	+++ (CF)	+++ (AT, P)	++++	++++	++++	
		1 week @ 140°F	++++	++++	+++ (AT)	++++	++++	++++	++++	
	LV840	30 min @ RT	++++	++++	++	+++ (P)	++	++++	++++	
		24 hour @ RT	++++	++++	++	+++ (P)	+++ (P)	++++	++++	
		72 hours @ RT	++++	++++	++	+++ (P)	++++	++++	++++	
		2 Weeks @ RT	++++	++++	++	+++ (P)	++++	++++	++++	
		1 week @ 140°F	++++	++++	++++	++++	++++	++++	++++	
	LV860	30 min @ RT	++++	++++	++	++	+	++++	++++	
		24 hour @ RT	++++	++++	++	++	+	++++	++++	
		72 hours @ RT	++++	++++	+++	++ (SL P)	+	++++	++++	
		2 Weeks @ RT	++++	++++	+++	++ (P)	++	++++	++++	
		1 week @ 140°F	++++	++++	++++	++++	++++	++++	++++	
LV850	30 min @ RT	++++	+++ (P)	+	+	-	+	+		
	24 hour @ RT	++++	++++	++	++	-	++ (P)	++++		
	72 hours @ RT	++++	++++	++	++	-	++++	++++		
	2 Weeks @ RT	++++	++++	++	++ (SL P)	+	++++	++++		
	1 week @ 140°F	++++	++++	++++	++++	++++	++++	++++		

## Key

++++ Foam Destruction  
 +++ Very Aggressive  
 ++ Aggressive  
 + Mild  
 - Poor

SLP Slight Picking 20%  
 P Picking 20-50%  
 CF Cohesive Failure  
 CF & P Cohesive Failure & Picking

# Mactac® Adhesion Testing on Bergad Foam Grades

		Formula	Dwell	4811V	2604V	6032	5018	2130	3015
Rubber Adhesives	LV790	30 min @ RT	-	-	-	-	-	-	-
		24 hour @ RT	-	-	-	-	-	-	-
		72 hours @ RT	-	-	-	-	-	-	-
		2 Weeks @ RT	-	-	-	-	-	-	-
		1 week @ 140°F	-	-	-	-	-	-	-
	LV780	30 min @ RT	++ (SL P)	+	-	++ (SL P)	++	++ (SL P)	++ (SL P)
		24 hour @ RT	-	+ (SL P)	-	++ (SL P)	++++	+	+
		72 hours @ RT	-	+ (SL P)	-	+++ (P)	++ (SL P)	+	+
		2 Weeks @ RT	-	++ (P)	-	+++ (P)	+	+	
		1 week @ 140°F	-	+++ (P)	+ (SL P)	++++	++++	++ (CF, P)	
	LV750	30 min @ RT	-	-	-	-	-	-	-
		24 hour @ RT	-	-	-	-	-	-	-
		72 hours @ RT	-	-	-	-	-	-	-
		2 Weeks @ RT	-	-	-	-	-	-	-
		1 week @ 140°F	-	-	-	-	-	-	-
Acrylic Adhesives	LV820 2.0 mil	30 min @ RT	++++	++++	++++	++++	+	(SL P)	++++
		24 hour @ RT	++++	++++	++++	++++	++++	++++ (CF)	++++
		72 hours @ RT	++++	++++	++++	++++	++++	++++	++++
		2 Weeks @ RT	++++	++++	++++	++++	++++	++++	++++
		1 week @ 140°F	++++	++++	++++	++++	++++	++ (CF, P)	++++
	LV820 4.0 mil	30 min @ RT	++++	++++	++++	++++	++++	++++	++++
		24 hour @ RT	++++	++++	++++	++++	++++	++++ (CF_)	++++
		72 hours @ RT	++++	++++	++++	++++	++++	++++	++++
		2 Weeks @ RT	++++	++++	++++	++++	++++	++++	++++
		1 week @ 140°F	++++	++++	++++	++++	++++	++++	++++
	LV840	30 min @ RT	++++	++++	+++ (P)	++++	++ (CF, SL P)	++++	
		24 hour @ RT	++++	++++	+++ (P)	++++	+++ (CF, SL P)	++++	
		72 hours @ RT	++++	++++	+++ (P)	++++	+++ (SL P)	++++	
		2 Weeks @ RT	++++	++++	++ (SL P)	++++	++ (SL P)	++++	
		1 week @ 140°F	++++	++++	++ (SL P)	++++	+++ (CF, SL P)	++++	
	LV860	30 min @ RT	++++	++++	++ (SL P)	++++	++ (CF, SL P)	++++	
		24 hour @ RT	++++	++++	++ (SL P)	++++	++ (CF, SL P)	++++	
		72 hours @ RT	++++	++++	++ (SL P)	++++	++ (SL P)	++++	
		2 Weeks @ RT	++++	++++	++ (SL P)	++++	++ (SL P)	++++	
		1 week @ 140°F	++++	++++	++ (SL P)	++++	++ (CF, SL P)	+++ (P)	
LV850	30 min @ RT	+++ (SL P)	++ (SL P)	+	++ (SL P)	+	(SL P)	+	
	24 hour @ RT	+++ (SL P)	++ (SL P)	+	+++ (SL P)	+	(SL P)	+	
	72 hours @ RT	+++ (SL P)	++ (SL P)	+	++ (SL P)	+	(SL P)	++ (SL P)	
	2 Weeks @ RT	++ (SL P)	++ (SL P)	+	++ (SL P)	+	(SL P)	++ (SL P)	
	1 week @ 140°F	++++	++ (SL P)	+	++ (SL P)	+	(SL P)	+	

## Key

++++	Foam Destruction	SL P	Slight Picking 20%
+++	Very Aggressive	P	Picking 20-50%
++	Aggressive	CF	Cohesive Failure
+	Mild	CF & P	Cohesive Failure & Picking
-	Poor		

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