

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.

Monarch is a manufacturer of high-performance, elastomeric closed-cell foam for use in the following markets:



Gaskets
& Seals



Heavy
Machinery



Sports Equipment
& Padding



Marine



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



Mass Transit

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		"++" = Aggressive	"+" = Mild	"-_" = Poor	
			"SL P" = Slight Picking (5-20%)		"P" = Picking (25-50%)	"CF" = Cohesive Failure		"CF&P = Cohesive Failure & Picking		
			3092	3944	2003	3043	4051	6231		
			EPDM	EPDM	Neoprene	EPDM	ECH	Nitrile-PVC Blend		
			Formula	Dwell	Skin	Skin	Skin	Skin	Skin	Skin
Rubber Adhesives	MP-593XT	30 min @ RT	+	+	+	+	+++	+		
	MP-593XT	24 hour @ RT	+ (SL P)	++	-	+ (SL P)	+++	++		
	MP-593XT	72 hours @ RT	+++	++	-	+	+++	++		
	MP-593XT	2 Weeks @ RT	+++	+++	-	+	+++	+++		
	MP-593XT	1 week @ 140°F	+ (SL P)	+++	++	+++ (CF)	+++	++		
	MP-899	30 min @ RT	+ (SL P)	+++	+	+++	++++	-		
	MP-899	24 hour @ RT	+ (P)	++++	+	+++	++++	+		
	MP-899	72 hours @ RT	+ (P)	++++	+	++++	++++	+		
	MP-899	2 Weeks @ RT	+++	++++	+	++++	+++	+		
	MP-899	1 week @ 140°F	+++	++ (CF)	++ (CF)	+ (CF)	++ (CF)	+++ (CF)		
Acrylic Adhesives	MP410 LCW	30 min @ RT	+ (SL P)	+	-	+ (SL P)	+++	-		
	MP410 LCW	24 hour @ RT	+ (SL P)	+ (SL P)	+	+ (SL P)	++++	+		
	MP410 LCW	72 hours @ RT	+ (P)	+ (SL P)	+	+ (SL P)	+++	+		
	MP410 LCW	2 Weeks @ RT	+ (P)	++	++	+++	+++	++		
	MP410 LCW	1 week @ 140°F	+ (SL P)	+++	- (CF)	+ (CF&P)	+ (CF)	- (CF)		
	MP410 HCW	30 min @ RT	+ (SL P)	+	+	+ (SL 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	+ (SL P)	++ (CF)	++ (CF)	+ (CF)	++ (CF)	+ (CF)		
				Migration @140°F	Migration @140°F	Migration @140°F	Migration @140°F	Migration @140°F		

		"++++" = Foam Destruction		"+++" = Very Aggressive		"++" = Aggressive		"+" = Mild		"- " = Poor	
		"SL P" = Slight Picking (5-20%)		"P" = Picking (25-50%)		"CF" = Cohesive Failure		"CF&P = Cohesive Failure & Picking			
		2055	5031	6032	5013	8082	8001				
		Neoprene	EPDM-CR-SBR Blend	Nitrile-PVC Blend	EPDM-CR-SBR Blend	EPDM	EPDM				
		Formula	Dwell	Skin	Skin	Skin	Skin	Skin	Skin		
Rubber Adhesives	MP-593XT	30 min @ RT	+	+	+	+	+	+ (SL P)	+ (SL P)		
	MP-593XT	24 hour @ RT	+	-	+ (SL P)	+	+	+ (P)	+ (SL P)		
	MP-593XT	72 hours @ RT	++	+ (SL P)	+ (SL P)	+	+	+ (P)	+ (SL P)		
	MP-593XT	2 Weeks @ RT	++	+ (P)	+	+	+	+++	+++		
	MP-593XT	1 week @ 140°F	+++	+ (P)	+ (SL P)	+++	+++	+++	+ (CF&P)		
	MP-899	30 min @ RT	+ (SL P)	+ (SL P)	+ (SL P)	+ (SL P)	+++	+++	+++		
	MP-899	24 hour @ RT	+++	+ (P)	+ (SL P)	+ (P)	+++	+++	+++		
	MP-899	72 hours @ RT	+++	+ (P)	+ (SL P)	+++	+++	++++	+++		
	MP-899	2 Weeks @ RT	+++	+++	+ (P)	+++	+++	++++	+++		
	MP-899	1 week @ 140°F	+ (CF)	+ (CF)	+ (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)	+ (SL P)	+	+ (P)	+ (SL P)		
	MP410 LCW	72 hours @ RT	+++	+	+ (SL P)	+ (P)	+	+ (P)	+ (P)		
	MP410 LCW	2 Weeks @ RT	+++	+ (P)	+ (P)	+++	+++	+++	+++		
	MP410 LCW	1 week @ 140°F	+ (CF&AT)	+ (SL P)	+ (CF)	- (CF)	+	+ (P)	+++		
	MP410 HCW	30 min	++	+ (SL P)	++	++	++	++	++		
	MP410 HCW	24 hour	+++	+++	+++	+++	+++	+++	++ (SL P)		
	MP410 HCW	72 hours	+++	+++	+++	+++	+++	+++	++++		
	MP410 HCW	2 Weeks	+++	+++	+++	+++	+++	++++	++++		
	MP410 HCW	1 week @ 140°F	+ (CF)	+ (CF)	+ (CF)	+ (CF)	+	+ (P)	++++		
		Migration @140°F		Migration @140°F		Migration @140°F		Migration @140°F			

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)