

adhesives for 2mil polyesters and 4 mil vinyl

These charts are based on relative adhesion within each given surface energy category.

Metals	Surface Energy Dynes/cm
Copper	1103
Aluminum	840
Zinc	753
Tin	526
Lead	543

HSE Plastics	Surface Energy Dynes/cm
Kapton®	50
Phenolic	47
Nylon	46
Alkyd Enamel	45
Polyester	43
Epoxy Paint	43
Polyurethane	43
ABS	42
Polycarbonate	42
PVC	39
Noryl	38
Acrylic	38

LSE Plastics	Surface Energy Dynes/cm
PVA	37
Polystyrene	36
Acetal	36
EVA	33
Polyethylene	31
Polypropylene	29
Tedlar®	28
PTFE	18
Powder Coatings	**

**Broad range of surface energy.

Features		Where to Use		Material Numbers	
V-156	9	V-156	7	V-156	7
V-156 (.001) Extra Aggressive Adhesive: <ul style="list-style-type: none"> Designed for cold application temperatures such as warning/caution labels used in OEM plants that are not heated in winter months. Excellent for unusual applications such as wood Very high tack for quick adhesion to most hard to stick to surfaces. Heat Resistance: -40F-257F 		<ul style="list-style-type: none"> Use when labels need to be applied at temperatures under 50°F. 		Materials this adhesive is available on: <ul style="list-style-type: none"> .004 Matte Vinyl 	
V-344	9	V-344	7	V-344	5
V-344 (.001) Permanent Acrylic Adhesive: <ul style="list-style-type: none"> Has high tack and high shear properties Designed for metals and high surface energy plastics Good chemical resistance and resist cold flow and ooze Heat Resistance: -40F-302F 		<ul style="list-style-type: none"> Use on bare metals, painted metals and high surface energy plastics 		Materials this adhesive is available on: <ul style="list-style-type: none"> .004 White Vinyl .002 White Polyester .002 Shiny Silver .002 Matte Silver .002 Brushed Silver 	
V-606	6	V-606	6	V-606	5
V-606 (.002) Permanent Acrylic Adhesive: <ul style="list-style-type: none"> Has medium tack and high shear properties Designed for metals, high surface energy and low surface energy plastics Good chemical resistance and resist cold flow and ooze Designed specifically for "Powder Coated" paints Heat Resistance: -40F-302F 		<ul style="list-style-type: none"> Use for Powder Coat paints 		Materials this adhesive is available on: <ul style="list-style-type: none"> .004 Vinyl .002 White Polyester .002 Shiny Silver .002 Matte Silver .002 Brushed Silver 	
3M 350	9	3M 350	10	3M 350	10
350 High Performance Acrylic: (Best all-around adhesive) <ul style="list-style-type: none"> Up to 450°F short-term heat resistance. Excellent solvent resistance and adhesion to LSE materials. Heat Resistance: -40F-450F 		<ul style="list-style-type: none"> 3M's best all-around adhesive. Can be used on any surface 		Use these Product Numbers to specify on your blueprints: <ul style="list-style-type: none"> 3M7868 .002 white polyester (.001) 3M7871 .002 white polyester (.002) 3M7051 .004 white vinyl (.001) 3M7904 .004 white vinyl (.002) 	
STRUCTURED	9	STRUCTURED	10	STRUCTURED	10
350 High Performance Acrylic: (Best all-around adhesive) <ul style="list-style-type: none"> Designed for outgassing applications Designed to prevent any bubbles in application 3M's best all-around adhesive 		<ul style="list-style-type: none"> Use for outgassing applications Eliminates bubbles during application 		Materials this adhesive is available on: <ul style="list-style-type: none"> 7051SA .004 White Vinyl 7220SA .002 White Polyester 7214SA .002 Brushed Silver Polyester 72155SA .002 Bright Silver Polyester 	

Note: .001 thick adhesives are designed for smooth or slightly textured surfaces.
.002 thick adhesives are designed for medium to heavily textured surfaces.