

SilGrip™ PSA230 Pressure Sensitive Adhesive

Product Description

SilGrip PSA230 silicone pressure sensitive adhesive is a toluene solution of polysiloxane gum and resin. It is supplied at 61 percent silicone solids and may be further diluted with aromatic, aliphatic or chlorinated solvents. PSA230 may be blended with SR545 resin dispersion to obtain specific performance properties. PSA230 adhesive offers medium peel adhesion strength, good balance of tack and cohesion strength, and is suitable for applications in coating of film and fabric substrates for manufacturing industrial pressure sensitive tapes.

Key Features and Typical Benefits

- Adhesion to a wide variety of surfaces, including low energy surfaces like silicone, polyolefins, and primed fluoropolymers.
- Resistance to moisture, weathering (ozone, sunlight), chemical (acids, alkalis, oils) and biological (fungus) attacks.
- Medium peel adhesion force strength, good balance of tack and cohesive properties.
- Viscosity is suitable for various applications
- Good clean removability performance for in-process protection/masking tape applications⁽³⁾

Typical Physical Properties

Property	Value†
Silicone Solid, %	61
Haze	Lightly hazed
Color	Colorless to light amber
Viscosity at 23 °C (73 °F), cps (Brookfield RVF, #6, Spindle @ 5 rpm)	90,000
Flash Point (ASTM D93) (PMCC), °C (°F)	5 (41)
Solvent	Toluene

†Typical properties are average data and are not to be used as or to develop specifications.

Typical Cured Adhesive Properties

Property	Value†
Peel Adhesion ⁽¹⁾ , grams/inch	450
Thermal Residue ⁽²⁾ at 260 °C (Hot peel and cool peel)	No residue

†Typical properties are average data and are not to be used as or to develop specifications.

- 1) 20 µm dry adhesive thickness, 38 µm PET film, 2.0 % benzoyl peroxide, curing cycle: 120 seconds at 85°C, 120 sec at 177 °C, stainless steel, 12 inches/minute, 180° angle.
- 2) 40 µm dry adhesive thickness, 1 mil polyimide film, 2.0 % benzoyl peroxide, curing cycle: 10 minutes air dry, 180 sec at 177 °C, stainless steel, 12 inches/minute.
- 3) Based on test findings of no residue after repeated heating cycles to 500 °F for 30 minutes.

NOTE: The properties of a cured silicone adhesive are affected by several factors such as type and amount of catalyst, cure cycle, adhesive thickness and backing type and thickness. Higher catalyst concentration will increase cohesive strength of the adhesive and improve shear strength, but it will reduce its adhesive strength resulting in lower tack and peel values.

Processing Recommendations

Application

SilGrip PSA230 silicone pressure sensitive adhesive is supplied at a viscosity that can accommodate most conventional tape coating equipment. If necessary, it may be thinned with toluene, xylene, or other compatible solvents. After the adhesive is applied to the substrate, it is exposed to a two-step process: solvent removal and curing.

Solvent Removal

To achieve optimum adhesive properties, it is essential to optimize the drying step of the process in order to ensure that the solvent is removed from the adhesive film before the curing step of the process starts. Improper drying will result in residual solvent entrapment within the adhesive. If the adhesive is then exposed to temperatures higher than 93.5 °C (200 °F), decomposing peroxide catalyst can cause cross-linking reaction between solvent and adhesive through methyl groups on siloxane chains and on solvent molecules and adversely affect the properties of the adhesive.

Typical temperature range for the drying step of the process is 83 °C (180 °F) to 90 °C (194 °F). A typical drying cycle is 2 minutes at 90 °C (194 °F).

Curing Process

Once the solvent is removed from the adhesive film, the peroxide cure should be initiated by exposure to heat. A typical curing cycle is 2 minutes at 165 °C (329 °F). Longer exposure time and higher temperature, up to 204 °C (400 °F), can generally be used without adverse effects. The exact conditions required to achieve a complete cure will primarily depend on oven length and efficiency, peroxide type, and type of substrate used, and should be established during experimental trials on the machine.

Catalysts

High purity 98% benzoyl peroxide in the quantity of 1 to 4% based on silicone solids has been found to provide the most consistent results in curing of silicone pressure sensitive adhesives. In applications requiring low temperature cure, 2,4-dichlorobenzoyl peroxide, which is activated at 132 °C (270 °F), can be used. It should be noted that 2,4-dichlorobenzoyl peroxide may generate polychlorinated biphenyls during the curing process. Please refer to Code of Federal Regulations, title 40, part 761 regarding incidental PCB byproducts if 2,4-dichlorobenzoyl peroxide is used.

The peroxide should be dispersed in solvent before it is mixed with the adhesive. Thorough mixing of the peroxide and adhesive to achieve homogeneous dispersion is essential for consistency of finished product.

Priming

In certain applications, the anchorage of the adhesive to the backing may be insufficient and the coating of a primer prior to the adhesive coating may be required.

A typical formulation⁽⁵⁾ for a primer is provided in Table 1 below. The formulation may need to be adjusted depending on required bath life, coating equipment and backing material. The primer may be coated by direct gravure, wire wound rod or other coating technique suitable for solvent based coatings, and must be cured prior to adhesive application. The curing conditions will depend on equipment capabilities, substrate type and formulation used and should be established during experimental trials on the machine.

Table 1. Typical Primer⁽³⁾ Formulation

Component	Parts by Weight
SS4191A	13.30
SS4191B	0.16
SS4192c	0.50
SS4259c	0.30
Solvent ⁽⁴⁾	85.74

(3) For more information, refer to SS4191 silicone release coating system, or consult with a Momentive Performance Material Technical Sales Representative.

(4) Typical solvents: toluene, heptane, toluene/heptane mixtures.

(5) Product formulations are included as illustrative examples only. Momentive makes no representation or warranty of any kind with regard to any such formulations, including, without limitation, concerning the efficacy or safety of any product manufactured using such formulations.

Patent Status

Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute the permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

Product Safety, Handling and Storage

Customers should review the latest Safety Data Sheet (SDS) and label for product safety information, safe handling instructions, personal protective equipment if necessary, emergency service contact information, and any special storage conditions required for safety. Momentive Performance Materials (MPM) maintains an around-the-clock emergency service for its products. SDS are available at www.momentive.com or, upon request, from any MPM representative. For product storage and handling procedures to maintain the product quality within our stated specifications, please review Certificates of Analysis, which are available in the Order Center. Use of other materials in conjunction with MPM products (for example, primers) may require additional precautions. Please review and follow the safety information provided by the manufacturer of such other materials.

Limitations

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