



Technical Data Sheet

DOWSIL™ 7268 Adhesive

FEATURES & BENEFITS

- High initial tack
- Adhesion to 240°C (464°F)

COMPOSITION

- Polydimethylsiloxane gum and resin dispersion; high-viscosity liquid

Pressure sensitive adhesive

APPLICATIONS

- Masking and plating tapes
- Applications requiring a balance of properties emphasizing high tack

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications.

Property	Unit	Result
Physical form		High viscosity liquid
Appearance		Clear to some hazy
Active ingredients	%	58–62
Diluent		Xylene/Toluene
Specific gravity		0.98
Viscosity at 25°C (77°F)	cp	40,000–100,000
Flash point, closed cup	°C	7.5
	°F	45.5

DESCRIPTION

DOWSIL™ 7268 Adhesive is a dispersion of polydimethylsiloxane gum and resin diluted with xylene and toluene to an average 60% silicone solids content.

HOW TO USE

DOWSIL 7268 Adhesive can be applied, as supplied, to backing materials by conventional tap coating equipment. It can be further diluted with compatible solvents or blend with other silicone pressure sensitive adhesives or acrylic adhesive before being coated.

When using any solvent, always provide adequate ventilation. Follow the solvent manufacturer's safe handling precautions as well as local, state and federal guidelines.

Catalysts

To achieve a good balance of tack, adhesive strength and cohesive strength over a wide range of operating temperatures, proper cure is essential. One of the factors affecting cure is the catalyst.

Catalysts such as benzoyl peroxide¹ may be used with DOWSIL 7268 Adhesive to either accelerate the rate of cure or to allow lower curing temperatures. The use of catalysts also increases the cohesive strength of the adhesive mass and promotes anchorage to the backing material.

¹Benzoyl peroxide: Luperox® A98, formerly Lucidol® 98 from Afofina Chemicals North America, Cadox® BFF 50 powder or BP 55 paste from Akzo Chemie of America, Noury Chemical Division.

Peroxide concentration can be varied from 0.5% to 3.0% (based on adhesive solids), depending upon such factors as backing material, coating equipment, cure cycle and the properties desired. Increasing peroxide concentration in DOWSIL 7268 Adhesive will decrease the tack and adhesive strength, but will increase the cohesive strength of the product.

The most consistent results are achieved by using the powdered, 98% benzoyl peroxide. Complete blending of peroxide and adhesive is best obtained by first making a 10% solution of the peroxide in toluene.

NOTE: Solvent dispersions of peroxides should be used within a day or two after mixing, as the peroxide loses its activity quite rapidly in solvent. Thorough dispersion of the adhesive and peroxide during mixing is necessary to achieve uniform results in the finished product.

Solvent Removal

To cure DOWSIL 7268 Adhesive following its application to the backing material, first remove the solvent. Recommended temperatures for removal range from 66 to 93°C (150 to 200°F). Higher removal temperatures can cause the peroxide to decompose prematurely and crosslink the solvent into the adhesive. This can reduce the properties of the finished tape. The length of time for solvent removal should be sufficient to ensure that no solvent is present in the adhesive when it enters the curing zone.

Curing the Adhesive

After the solvent is removed, a tacky, uniform film of adhesive is left on the backing. This film's adhesive and cohesive strengths, as well as the tack, can be further developed by a heat cure. The amount of cure depends on a number of factors, including the type of catalyst or equipment and backing material.

A cure of 1 minute at 66°C (150°F) for solvent removal, followed by 2 minutes at 177 to 204°C (350 to 400°F) is used for adhesive that contains benzoyl peroxide.

If equipment and type of backing material permit the use of higher curing temperatures, the cure time may be shortened. Higher cure temperatures develop cohesive strength of the adhesive in less time than at lower temperatures. The ultimate adhesive strength of the fully cured material is essentially the same whether cured at higher or lower temperatures. The only difference is the time required to reach complete cure.

Anchorage to backing

To achieve maximum anchorage of the adhesive to the backing, a primer may be required. Contact your local technical support for assistance in selecting a primer formulation.

HANDLING

PRECAUTIONS

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE ON THE DOW WEBSITE AT WWW.CONSUMER.DOW.COM, OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.

USABLE LIFE AND STORAGE

When stored at or below 32°C (90°F) in the original unopened containers, this product has a usable life of 12 months from the date of production.

PACKAGING INFORMATION

This product is available in a variety of container sizes.

LIMITATIONS

Shipping: DOT Classification: flammable.

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

HEALTH AND ENVIRONMENTAL INFORMATION

To support customers in their product safety needs, Dow has an extensive Product Stewardship organization and a team of product safety and regulatory compliance specialists available in each area.

For further information, please see our website, www.consumer.dow.com or consult your local Dow representative.

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DOWSIL™ 7268 Adhesive

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