

# Membrane Switch - Mounting Adhesive

## .004" (4.0 Mil) Sheet Form Laminating Adhesive

*FLEXcon® SWITCHmark® spacer components, overlaminates and laminating adhesives are specifically engineered for demanding membrane switch applications. Specially formulated pressure-sensitive adhesives are designed to bond well to a variety of surfaces. The adhesive also allows the necessary rework time to minimize waste in assembly from misaligned components.*

*Markets Include:  
Membrane Switch  
Aerospace  
Appliance  
Automotive  
Durable Goods  
Consumer Electronics  
Heavy Equipment  
Industrial Equipment  
Medical Device*

*For more information on FLEXcon's pressure-sensitive film solutions for Membrane Switches, contact your local Sales Representative or our Performance Products Business Team at (508) 885-8440.*

*Product ID #: FLX000476*



Product:

**FLEXcon®  
SWITCHmark® 4-0-0 S**

Benefits:

- High-performance permanent pressure-sensitive acrylic adhesive bonds well to high-surface energy plastics, metal and paint\*
- Superior mechanical properties ensure long-term membrane switch performance without delamination (ASTM F 1578-00)
- Adhesive offers excellent high-temperature, humidity and chemical resistance
- Product can be repositioned within the first few minutes of application allowing easy correction of assembly mistakes
- Adhesive is compatible with a wide range of solvent and UV ink systems, including conductive, decorative and dielectric inks
- 80 lb. backside printed with black diagonal stripes bleached polycoated mando release liner on one side
- SWITCHmark release liner with black diagonal stripes ensures easy product identification and mistake proofing during production and switch assembly
- Backed with a layflat 90 lb. polycoated white release liner on the other side
- Moisture stable, layflat release liner is ideal for sheet-form converting
- Ideal for creating custom spacer components, attaching graphic layers or mounting the membrane switch to application substrates
- Product is available in rolls and sheets
- Product is RoHS compliant
- Adhesive system has UL recognition under UL746C, Polymeric Adhesive Systems, Electrical Equipment - Component and UL969, Marking & Labeling Systems Materials Component 302°F (150°C)

\*Recommendations: Application surfaces must be above 50°F (10°C). Surfaces must be clean and dry to obtain best adhesion results. Firm and even laminating pressure helps promote better adhesive contact and improves bond strength. Always laminate to exclude air entrapment. When diecutting, the 80 lb. printed mando liner should be used as the diecutting base. For SWITCHmark® inquiries in the United States and Canada, please contact Insulectro Distribution at (603) 629-4412. For other inquiries, please contact your FLEXcon Sales Representative or call FLEXcon at (508) 885-8296.



# FLEXcon® SWITCHmark® 4-0-0 S

PRODUCT DATA	VALUE		TEST METHOD
Physical Properties			
Thickness (Mils[microns])	90 PFW	6.9 (175) +/- 10%	ASTM D 3652 (Modified for use with non-tape products)
	Adhesive	3.9-4.1 (99-104) +/- 0.2 (5)	
	SPEC 80B PFM (black stripes)	4.8 (122) +/- 10%	
Adhesion Properties			
Ultimate Peel from	Average		ASTM D 903 (Modified for 72 hour dwell time)
	Oz/In	(N/m)	
ABS	58	(638)	
Alkyd Enamel Paint	57	(627)	
Aluminum	72	(792)	
Conductive Solvent Screen Ink - Acheson Colloids 479SS	67	(737)	
Decorative Solvent Screen Ink - Coates Screen C-99 Series	60	(660)	
Decorative UV Screen Ink - Coates Screen PD Series	63	(693)	
Decorative UV Screen Ink - Nazdar 3400 Series	72	(792)	
Decorative UV Screen Ink - Nor-Cote Int'l MSK Series	59	(649)	
Dielectric UV Screen Ink - Acheson Colloids 452SS	70	(770)	
Polycarbonate	77	(847)	
Polyester	71	(781)	
PVC	76	(836)	
Stainless Steel	77	(847)	
Expected Shear			ASTM D 3654 Method A a. 1 hr. dwell b. 1 sq. in. surface c. 4 lb. load
Room Temp (hours)	100+		
Tack (gm/sq cm)	440		ASTM D 2979
Expected Exterior Life	Two years		
Service Temperature Range	-40°F to 302°F (-40°C to 150°C) with polyester film		
Minimum Application Temperature	50°F (10°C)		
Storage Stability	Two years stored at 70°F (21°C) and 50% RH		

## Product Performance and Suitability

All of the descriptive information, the typical performance data, and recommendations for the use of FLEXcon products shall be used only as a guide and do not reflect the specification or specification range for any particular property of the product. Furnishing such information is merely an attempt to assist you after you have indicated your contemplated use and shall in no event constitute a warranty of any kind by FLEXcon. All purchasers of FLEXcon products shall be responsible for independently determining the suitability of the material for the purpose for which it is purchased. No distributor, salesman, or representative of FLEXcon is authorized to give any warranty, guaranty, or make any representation in addition or contrary to the above.

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