

TECHNICAL BULLETIN

Supplemental Product Information

PRODUCT:	654M LSE Double-Coated Acrylic Film
PRIMARY USE:	A high initial tack acrylic adhesive double coated on a PET film with a silicone-coated release liner. 654M bonds to a broad range of substrates including rigid and flexible plastics and LSE substrates. Adheres well to many different types of foam materials including urethane foams.
FOAM BONDING STUDIES:	<p>All foam materials are laminated using heat-assisted lamination techniques and tested immediately. Results are subjective observations:</p> <p>Armacell ECF-400 after 72 hours @ 1500F.....Excellent Armacell (Ensolute®) MLC-Black with heat assist (TS 3909).....Very Good Armacell (Ensolute®) MBO with heat assist (TS 3909).....Excellent Armacell (Ensolute®) IUO with heat assist (TS 3909).....Excellent Armacell (Ensolute®) IUT with heat assist (TS3909).....Very Good to Excellent Foamex LP 180-30CP after 72 hours @ 1500FExcellent Foamex Ether after 72 hours @ 1500F.....Excellent Foamex ECP270-70 after 24 hrs. with heat assist (TS4082).....Fair to Good Foamex Super Seal after 72 hours @ 1500F.....Excellent Foamex Neoprene 3 after 24 hrs. with heat assist (TS 4082)Very Good Foamex ECP180-30EP after 48 hrs. with heat assist (TS4082).Excellent Foamex (ECP150-30EP after 24 hrs. with heat assist (TS4082)Fair Foamex ECP160-50E2 after 24 hrs. with heat assist (TS4082).....Fair to Good Foamex ECP160-50E7 after 24 hrs. with heat assist (TS4082)Fair Foamex SSW after 24 hrs. with heat assist (TS4082)Excellent 2# Ester UL after 72 hours @ 1500FExcellent 1.8# Ether UL after 72 hours @ 1500FExcellent Ester after 72 hours @ 1500F.....Excellent Hybrid Foam after 72 hours @ 1500FExcellent 7# PVC after 72 hours @ 1500FGood Vinyl Nitrile after 72 hours @ 1500FExcellent Otto Block Foam with heat assisted Lamination (TS 4901).....Excellent PVC foam to extruded PVC (TS 4184)Good to Very Good</p>

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654M LSE Double-Coated Acrylic Polyester Film

OTHER BONDING STUDIES:	Polyester Based Powder Coated Paint74 Urethane Based Powder Coated Paint78 Fluoropolymer Based Powder Coated Paint89 20% Talc-Filled Polypropylene75 40% Talc-Filled Polypropylene74 Mica Filled Polypropylene78 Mytex TM Polypropylene77 TPO 140282 TPO D162GM75 Nylon 6686 ABS85 Polycarbonate102 Acrylic Sheet101 Glass84 Aluminum61 Stainless Steel70
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