

**LOW SURFACE ENERGY & LOW VOC*
ACRYLIC TRANSFER TAPE**

PRODUCT:	653 LSE & Low VOC* Transfer Tape		
PRIMARY USE:	<p>653 is excellent for bonding to rigid and flexible plastics. Proven performance to a variety of low and high surface energy material including ABS, Powder Coated Paints, TPO, PE, PET and many other low surface energy materials.</p> <p>Applications: Nameplates Automotive interior attachments Attaching to powder coated and other LSE finishes Cost effective option for many Low Surface Energy materials and applications Meets numerous automotive specifications</p>		
DESCRIPTION:	<p>A 3-mil quick initial tack, permanent, unsupported acrylic pressure sensitive film. 653 has high peel and shear properties and is ideal for nameplates, automotive interior applications, and other demanding applications where a thin unsupported adhesive is preferred.</p> <p>Automotive Fogging Test: Passes SAE J1756 @ 100°C as tested Odor: Passes SAE J 1351 Low VOC as defined by the Japanese Ministry of Health, Labor & Welfare. Contact Adchem Technical Service for additional automotive specifications.</p>		
LINER:	74# white poly-coated Kraft		
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	NA
		Adhesive Exposed Side (nominal)	3.0 mils
		Release Liner (nominal)	5.5 mils
	Peel Adhesion	PSTC #101; backed with 1 mil polyester 24 Hour Dwell:	
		Exposed Side	NA
		Liner Side	58 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum 24 Hour Dwell:	
		Exposed Side	NA
		Liner Side	160 oz/inch
	<i>NOTE: Peel tests are performed as per PSTC #101, which states one minute maximum dwell time. In general, for acrylic adhesives, longer residence time yields much higher peel values.</i>		
	Shear Adhesion	PSTC #107; Modified, 1000 gm/sq. in. @ 72° F.	
		Exposed Side	NA
		Liner Side	7+ Days no failure
		PSTC #107, Modified; 500 gm/sq. in. @ 150°F	
Exposed Side		NA	
Liner Side	7+ Days no failure		
*Note: there is no industry wide accepted definition for Low VOC.			

ADCHEM CORPORATION

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TECHNICAL BULLETIN

653 Low Surface Energy & Low VOC* Adhesive Transfer Tape

PHYSICAL PROPERTIES:	Loop Tack	PSTC #16; 125 oz/inch
PRODUCT FEATURES:	• Available in 60" and 54" useable width	
SERVICE TEMPERATURE:	<p>-30°F to 250°F</p> <p>NOTE: This information is provided as a means to help characterize the adhesive's temperature resistance. Note that this data is based on limited testing and under no load. The practical service temperature of this or any adhesive system is dependent on many variables including the substrates being bonded, environmental conditions, and the loading and method of application. The purchaser is responsible for determining the suitability of this or any product for their particular purpose and process. The recommended application temperature is 68°F to 100°F.</p>	
RELATED ADCHEM PRODUCTS:	<p>652-74: 2 mil acrylic transfer 654M-74: Double-Sided PET 654T-74: Double-Sided Tissue 654U-12pt: 4 mil acrylic transfer 655-74: 4.5 mil acrylic transfer</p>	
NOTES:	The use of heat and pressure will help to increase the initial bond of the product to the substrate. Testing is recommended prior to laminating to any material that contains migrating plasticizers.	
SHELF LIFE:	One year from date of shipment when stored under cool, dry conditions.	

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