

LOW SURFACE ENERGY & LOW VOC* DOUBLE-SIDED ACYRLIC PET TAPE

PRODUCT:	654M Double-Sided LSE & Low VOC* Tape			
PRIMARY USE:	654M is an exceptional option when high tack, higher temperatures and high shear properties are needed. It bonds extremely well to many Low and High Surface Energy substrates including ABS, TPO, Powder Coated Paints, PE, PP and numerous types of foams. The PET carrier facilitates precise die-cutting and dimensional stability.			
	Applications: Automotive Interior Applications Headliners Insulation Panel Electronics Foam-to-Foam and Foam-to-Plastic Bonding			
DESCRIPTION:	A high tack, high shear 2 mils per side acrylic LSE adhesive system on a 0.5 mil polyester film carrier 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.			
LINER:	74# white poly-coated Kraft			
	Thickness	Carrier	0.5 mils	
		Adhesive Exposed Side (nominal)	2.0 mils	
		Adhesive Liner Side (nominal)	2.0 mils	
		Release Liner (nominal)	5.5 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester 24 Hour Dwell:		
		Exposed Side	55 oz/inch	
TYPICAL PHYSICAL		Liner Side	60 oz/inch	
		PSTC #101; backed with 2 mil dead soft aluminum 24 Hour Dwell:		
PROPERTIES:		Exposed Side	160 oz/inch	
		Liner Side	175 oz/inch	
		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.		
	Shear Adhesion	PSTC #107; Modified, 1000 gm/sq. in. @ 72° F.		
		Exposed Side	7+ Days no failure	
		Liner Side	7+ Days no failure	
		PSTC #107, Modified; 500 gm/sq. in. @ 150°F		
		Exposed Side	7+ Days no failure	
		Liner Side	7+ Days no failure	
*Note: There is no industry wide accepted definition for Low VOC.				

ADCHEM CORPORATION

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654M Double-Sided Low Surface Energy & Low VOC* Tape

PHYSICAL PROPERTIES:	Loop Tack	PSTC #16; Exposed Side Liner Side	120 oz/inch 115 oz/inch		
PRODUCT FEATURES:	Available in 54" useable width				
SERVICE TEMPERATURE:	-30°F to 250°F 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.				
RELATED ADCHEM PRODUCTS:	652-74: 2 mil acrylic transfer 653-74: 3 mil acrylic transfer 654T-74: Double-sided Tissue 654U-12pt: 4 mil acrylic transfer 655-74: 4.5 mil acrylic transfer				
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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