



The adhesive tape engineers®  
**TECHNICAL BULLETIN**

**LOW SURFACE ENERGY & LOW VOC\***  
**DOUBLE-SIDED ACRYLIC 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. <b>Applications:</b> Automotive Interior Applications		

\*Note: There is no industry wide accepted definition for Low VOC.

**ADCHEM CORPORATION**

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[www.adchem.com](http://www.adchem.com)

Data presented are typical properties taken from a limited number of production runs and should not be used for specification purposes. Adchem Corporation makes no warranty, expressed or implied, and specifically disclaims and disavows any implied warranty of merchantability and of fitness for a particular purpose. Accordingly, all Adchem products are sold with the understanding that purchasers will be solely responsible for determining the suitability of the materials for any purpose.

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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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