

LOW SURFACE ENERGY & LOW VOC*
DOUBLE-SIDED ACRYLIC TISSUE TAPE

PRODUCT:	654T Double-Sided Acrylic LSE & Low VOC* Tissue Tape		
PRIMARY USE:	654T is excellent for bonding and laminating to a variety of cloths, corks, papers, rigid and flexible plastics. Ideal for splicing, displays, signs, posters, mirrors, nameplates and decorative wall products. Outstanding option for applications where conformability and tear-ability along with a high tack adhesive is needed.		
DESCRIPTION:	A thin conformable, lightweight tissue coated on both side with a high tack acrylic adhesive. 654T has optimal peel and shear properties – even at high temperatures - and die cuts cleanly 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		
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier and Adhesive (nominal)	5.0 mils
		Release Liner (nominal)	5.5 mils
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>	
		Exposed Side	55 oz/inch
		Liner Side	60 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum <i>24 Hour Dwell:</i>	
		Exposed Side	160 oz/inch
		Liner Side	170 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	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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ADCHEM

The adhesive tape engineers®

TECHNICAL BULLETIN

654T Double-Sided Low Surface Energy & Low VOC* Tissue Tape

PHYSICAL PROPERTIES:	Loop Tack	PSTC #16; Exposed Side Liner Side	100 oz/inch 120 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 654M-74: Double-sided PET 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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