



The adhesive tape engineers®

## TECHNICAL BULLETIN

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

PRODUCT:	<b>655 LSE &amp; Low VOC* Acrylic Transfer Tape</b>		
PRIMARY USE:	655 is excellent for bonding to rigid and flexible plastics as well as to a variety of foams. Proven performance to a variety of low and high energy materials including, ABS, Foil, Film, TPO, TFPP, Nylon and glass <b>Applications:</b> Automotive interior attachments Glass to Rear View Mirror Wire and Cable Mounting Vibration and Sound damping with fabrics and foams		
DESCRIPTION:	A 4.5 mil high initial tack, permanent unsupported acrylic pressure-sensitive film. 655 has high peel and shear properties and is ideal for automotive interior applications 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	NA
		Adhesive Exposed Side (nominal)	4.5 mils
		Release Liner (nominal) 74#	5.5 mils
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>	
		Exposed Side	NA
		Liner Side	58 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum <i>24 Hour Dwell:</i>	
		Exposed Side	NA
		Liner Side	180 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	
Liner Side		7+ Days no failure	
*Note: There is no industry wide accepted definition for Low VOC.			

#### ADCHEM CORPORATION

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**655 Low Surface Energy & Low VOC\* Transfer Tape**

PHYSICAL PROPERTIES:	Loop Tack	PSTC #16; 140 oz/inch
PRODUCT FEATURES:	• Available in 54" useable width on 74# liner.	
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 654T-74: Double-sided Tissue 654U-12pt: 4 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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