

TECHNICAL BULLETIN

FILM SUPPORTED TAPE

PRODUCT:	668M-74 Double-Coated Polyester Film			
PRIMARY USE:	Recommended for applications where a heavy adhesive mass is beneficial and requires resistance to plasticizers such as vinyl products used in flooring, wall coverings, synthetic leather, and sheet or roll goods.*			
DESCRIPTION:	A heavy mass of high tack acrylic adhesive coated on both sides of a ½ mil polyester film.			
LINER:	74# white poly-coated Kraft.			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	0.5 mils	
		Adhesive Exposed Side (nominal)	3.5 mils	
		Adhesive Liner Side (nominal)	3.5 mils	
		Liner (nominal)	5.5 mils	
	Peel Adhesion	PSTC #101 Method C; backed with 1 mil polyester <i>24 Hour/Dwell –</i>		
		Exposed Side		54 oz/inch
		Liner Side		48 oz/inch
		PSTC #101 Method C; backed with 2 mil dead soft aluminum foil <i>24 Hour/Dwell –</i>		
		Exposed Side		120 oz/inch
		Liner Side		125 oz/inch
	Shear Adhesion	PSTC #107 Procedure A, Modified; 1000 gm/sq.in. @ 72°F <i>One minute maximum dwell time:</i>		
		Exposed Side		6 Days
		Liner Side		6 Days
	Loop Track	PSTC #16		
		Exposed Side		80 oz/inch
Liner Side			50 oz/inch	

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668M-74 Double-Coated Polyester Film

PRODUCT FEATURES:	<ul style="list-style-type: none"> • High total tape thickness with ½ mil PET carrier. • Resists plasticizer migration.* • Good adhesion to a wide variety of substrates. • Excellent tack. 		
SERVICE TEMPERATURE:	<p>-30°F to 220°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>		
NOTE:	<p>The use of heat and pressure will help to increase the initial bond of the product to the substrate. Surfaces to be bonded to should be clean, dry and free from grease and oil. Testing is recommended prior to laminating to any material that contains migrating plasticizers.</p>		
BONDING STUDIES:*	CONDITIONING ▼	VINYL	ADCHEM 668M
	24 HOUR DWELL @ ROOM TEMPERATURE	HIGHLY PLASTICIZED VINYL	40 oz. [CLEAN; NO TRANSFER]
		LESS PLASTICIZED VINYL	80 oz. [COH 1-SIDE]
	24 HOUR DWELL RT; 72 HRS @ 150° 24 HR. DWELL RT;	HIGHLY PLASTICIZED VINYL	25 oz. [CLEAN; NO TRANSFER]
		LESS PLASTICIZED VINYL	95 oz. [COH 1-SIDE]
<p>Samples prepared by laminating ~ 1 1/8" wide pieces of vinyl material front to back with 1" wide 668M. T-Peel @ 12"/minute.</p> <p>*In controlled lab testing 668M has shown better tolerance than other acrylic and rubber based systems to monomerically plasticized vinyl films. However, commercially available flexible vinyl films can differ in composition from the films used in the controlled testing. Therefore, Adchem disclaims liability under actual use conditions and suggests that the adhesive be tested and approved under actual use conditions by the end user.</p>			
SHELF LIFE:	One year from date of shipment when stored under cool, dry conditions.		

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