

**TECHNICAL BULLETIN**

**LOW VOC\* FILM SUPPORTED TAPE**

PRODUCT:	6940M Double-Coated Polyester Film			
PRIMARY USE:	A high initial tack acrylic adhesive double-coated on a PET film with a silicone-coated release liner. 654M bonds to a variety of substrates including rigid and flexible plastics and LSE substrates. Adheres well to many different types of foam materials including urethane foams.			
DESCRIPTION:	A high tack, moderate high shear acrylic adhesive film coated on both sides of a high quality polyester film. Low VOC as defined by the Japanese Ministry of Health Labor and Welfare.			
LINER:	74 # white poly-coated Kraft			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	0.5 mils	
		Adhesive Exposed Side (nominal)	2.0 mils	
		Adhesive Liner Side (nominal)	2.0 mils	
		74# Release Liner (nominal)	5.5 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>		
		Exposed Side		50 oz/inch
		Liner Side		55 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum foil <i>24 Hour Dwell:</i>		
		Exposed Side		155 oz/inch
		Liner Side		170 oz/inch
	Shear Adhesion	PSTC #107; Modified, 1000 gm/sq. in. @ 72° F.		
		Exposed Side		7+ Days
		Liner Side		7+ Days
	*NOTE: There is no industry wide accepted definition for Low VOC			

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**6940M-74-54 Double-Coated Polyester Film**

TYPICAL PHYSICAL PROPERTIES:	Loop Tack	PSTC #16;	
		Exposed Side	115 oz/inch
		Liner Side	110 oz/inch
PRODUCT FEATURES:	<ul style="list-style-type: none"> <li>• High tack acrylic adhesive.</li> <li>• Bonds well to a variety of substrates.</li> <li>• Excellent peel and shear properties.</li> <li>• Die cuts cleanly.</li> <li>• Low VOC.</li> </ul>		
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>		
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.		
RELATED ADCHEM PRODUCTS:	Other products with the same Low VOC adhesive system include: 6940T-74-54 – Double-coated tissue. 6943-74-54 – 3-mil transfer tape.		
SHELF LIFE:	One year from date of shipment when stored under cool, dry conditions.		

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