



The adhesive tape engineers®

# TECHNICAL BULLETIN

## LOW SURFACE ENERGY DOUBLE-SIDED ACRYLIC PET TAPE

PRODUCT:	<b>654M Double-Sided Low Surface Energy (LSE) Tape</b>		
PRIMARY USE:	<p>654M LSE 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.</p> <p><b>Applications:</b>  Automotive Interior Applications                      Headliners  Insulation    Panel Electronics  Foam-to-Foam and Foam-to-Plastic Bonding</p>		
DESCRIPTION:	<p>A high tack, high shear 2 mils per side acrylic LSE adhesive system on a 0.5 mil polyester film carrier  Automotive Fogging Test: Passes SAE J1756 @ 100°C as tested  Odor: Passes SAE J 1351  Contact Adchem Technical Service for additional automotive specifications.</p>		
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
		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	175 oz/inch
	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	

### ADCHEM CORPORATION

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**654M Double-Sided Low Surface Energy (LSE) 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 655-60: 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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