654T

Tissue-Supported LSE & Low VOC Double-Coated Tape

Liner: 74# Polycoated Kraft
Adhesive: Acrylic (1626)
Carrier: Tissue

Specifications:
- Passes Automotive Fogging Test: SAE J1756 @ 100 °C as tested
- Passes Odor Test SAE J1351
- Meets numerous other Auto Specs

Applications
- Automotive interior applications
- Insulation
- Foam-to-foam or foam-to-plastic bonding
- LSE and Low VOC
- Headliners
- Panel electronics
- Substrates including ABS, TPO, powder coated paints, PE, PP, and foams

Features
- Acrylic Adhesive
- Tissue Supported
- 74# Kraft Liner

Benefits
- Quick initial tack
- Low fogging, low flammability
- High peel and shear properties
- Excellent high and low temperature performance
- Facilitates clean die-cuts
- Conformable and good dimensional stability

Typical Test Values

<table>
<thead>
<tr>
<th></th>
<th>Standard UOM</th>
<th>Metric UOM</th>
<th>Test Method</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thickness (Carrier &amp; Adhesive)</td>
<td>5.0 mils</td>
<td>0.127 mm</td>
<td>PSTC 133</td>
</tr>
<tr>
<td>Liner Thickness</td>
<td>5.5 mils</td>
<td>0.140 mm</td>
<td>PSTC 133</td>
</tr>
<tr>
<td>Adhesion to Steel (Air Side)</td>
<td>55 oz/in</td>
<td>6.02 N/cm</td>
<td>PSTC 101 Mod - 1 mil PET</td>
</tr>
<tr>
<td>Adhesion to Steel (Liner Side)</td>
<td>60 oz/in</td>
<td>6.56 N/cm</td>
<td>PSTC 101 Mod - 1 mil PET</td>
</tr>
<tr>
<td>Adhesion to Steel (Air Side)</td>
<td>160 oz/in</td>
<td>17.50 N/cm</td>
<td>PSTC 101 Mod - 2 mil Alu Foil</td>
</tr>
<tr>
<td>Adhesion to Steel (Liner Side)</td>
<td>170 oz/in</td>
<td>18.60 N/cm</td>
<td>PSTC 101 Mod - 2 mil Alu Foil</td>
</tr>
<tr>
<td>Shear Strength</td>
<td>&gt;7 Days</td>
<td></td>
<td>PSTC 107 Mod</td>
</tr>
<tr>
<td>Laminating Temperature</td>
<td>68 to 100 °F</td>
<td>20 to 38 °C</td>
<td></td>
</tr>
<tr>
<td>Service Temperature</td>
<td>-30 to 375 °F</td>
<td>-34 to 191 °C</td>
<td></td>
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</tbody>
</table>

Recommended Storage Conditions: 40-60% Humidity, 60 °F - 80 °F
Standard Shelf Life: 12 months from date of shipment

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