### Low-Surface Energy (LSE) & Low VOC Transfer Tape

**654U-74**

**Liner:** 74# Polycoated Kraft  
**Adhesive:** Acrylic (I626)

**Specifications:** Various Automotive Specs

#### Applications

- Bonding foam to rigid and flexible plastics  
- Laminating and mounting to ABS, powder-coated paints, TPO, PE, PP, PET, and many low-surface energy materials  
- Excellent foam bonding properties  
- Low VOC bonding applications

#### Features

- Acrylic Adhesive  
- 74# Kraft Liner

#### Benefits

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

#### Typical Test Values

<table>
<thead>
<tr>
<th>Test Method</th>
<th>Standard UOM</th>
<th>Metric UOM</th>
<th>Test Method</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thickness (Carrier &amp; Adhesive)</td>
<td>4.0 mils</td>
<td>0.102 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>68 oz/in</td>
<td>7.44 N/cm</td>
<td>PSTC 101 Mod - 1 mil PET</td>
</tr>
<tr>
<td>Loop Tack</td>
<td>98 oz/in</td>
<td>10.72 N/cm</td>
<td>PSTC 16</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>
</tr>
</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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