

- Features & Benefits
- Characteristics
- Adhesion Studies
- Where they fit
- Applications

- 654M: Double-Coated PET 2-mils each side
- 654T: Double-Coated Tissue 5-mils (total thickness including adhesive & tissue)
- 653: 3-mil Transfer Tape

- Combines excellent shear and peel properties.
- Good adhesion to many low surface energy substrates.
- Proven bonding to a variety of foams.
- Moisture-stable 74# poly-coated Kraft.
- A cut above the 250 Series.

- Foamex LP 180-30CP after 72 hours @ 150°F      Excellent
- Foamex Ether after 72 hours @ 150°F      Excellent
- Foamex Super Seal after 72 hours @ 150°      Excellent
- 1.8# Ether UL after 72 hours @ 150°F      Excellent
- Ester after 72 hours @ 150°F      Excellent
- 7# PVC after 72 hours @ 150°F      Good
- Vinyl Nitrile after 72 hours @ 150°F      Excellent

- Powder Coated Painted Surfaces
  - Initial.....58
  - After 24 Hours @ RT..... 78
- TPO (Average of 2 Grades Tested)
  - Initial..... 54
  - After 24 Hours @ RT..... 80
- 40% Talc-Filled Polypropylene
  - Initial..... 50
  - After 24 Hours @ RT..... 80
- Mica-Filled Polypropylene
  - Initial..... 55
  - After 24 Hours @ RT..... 88

- Aluminum
  - Initial..... 60
  - After 24 Hours @ RT..... 60
- Stainless Steel
  - Initial..... 50
  - After 24 Hours @ RT..... 70
- Glass
  - Initial..... 72
  - After 24 Hours @ RT..... 60
- Nylon 66
  - Initial..... 70
  - After 24 Hours @ RT..... 88

- Improved peel with no sacrifice in shear values.
- Slightly more aggressive with higher loop tack
- Improved bonding to many low surface energy substrates.
- Demonstrated bonding to various foams.
- Multiple constructions for greater versatility.
- Refer to charts for specific information.

- Slightly lower peel but improved shear values.
- Slightly less aggressive with lower loop tack
- Improved bonding to many low surface energy substrates.
- Multiple constructions for greater versatility.

	654M-74-54	256M-74-54	353M-74-54
<b>Armacell ECF-400 after 72 hrs @150°F</b>	Excellent	Fair to Poor	Poor
<b>Armacell Ensolite® MLC - Black with Heat Assist</b>	Very Good	Very Good	Very Good
<b>Armacell Ensolite® MBO - with Heat Assist</b>	Excellent	Very Good to Excellent	Very Good to Excellent
<b>Armacell Ensolite® IUO - with Heat Assist</b>	Excellent	Very Good to Excellent	Very Good to Excellent
<b>Armacell Ensolite® IUT - with Heat Assist</b>	Very good to Excellent	Fair to Poor	Good to Very Good

	654M-74-54	256M-74-54	353M-74-54
<b>Polyester based Powder Coated Paint</b>	<b>74 oz./in. width</b>	<b>62 oz./in. width</b>	<b>62 oz./in. width</b>
<b>Urethane Based Powder Coated Paint</b>	<b>78 oz./in. width</b>	<b>70 oz./in. width</b>	<b>75 oz./in. width</b>
<b>Fluoropolymer Based Powder Coated Paint</b>	<b>89 oz./in. width</b>	<b>42 oz./in. width</b>	<b>35 oz./in. width</b>
<b>20% Talc-Filled Polypropylene</b>	<b>75 oz./in. width</b>	<b>38 oz./in. width</b>	<b>50 oz./in. width</b>

654M-74-54    256M-74-54    353M-74-54

**ABS**

**85 oz./in.  
width**

**71 oz./in.  
width**

**55 oz./in.  
width**

**Polycarbonate**

**102 oz./in.  
width**

**91 oz./in.  
width**

**57 oz./in.  
width**

- Test the 650 Family when there is a need for:
  - High temperature performance.
  - Adhesion to low energy substrates.
  - Excellent shear and peel properties.
  - Cost effective bonding.
  - 654T for conformability and tear-ability.