

TECHNICAL BULLETIN

Supplemental Product Information

PRODUCT:	654T LSE Double-Coated Tissue
PRIMARY USE:	A high initial tack acrylic adhesive double coated on a PET film with a silicone-coated release liner. 654M bonds to a wide variety of substrates including rigid and flexible plastics and LSE substrates. Adheres well to many different types of foam materials including urethane foams.
FOAM BONDING STUDIES:	<p>All foam materials are laminated using heat-assisted lamination techniques and tested immediately. Results are subjective observations:</p> <p>Armacell ECF-400 after 72 hours @ 1500F.....Excellent Armacell (Ensolute®) MLC-Black with heat assist (TS 3909).....Excellent Armacell (Ensolute®) MBO with heat assist (TS 3909).....Excellent Armacell (Ensolute®) IUO with heat assist (TS 3909).....Excellent Armacell (Ensolute®) IUT with heat assist (TS3909).....Very Good to Excellent Foamex LP 180-30CP after 72 hours @ 1500FExcellent Foamex Ether after 72 hours @ 1500F.....Excellent Foamex ECP270-70 after 24 hrs. without heat assist (TS4082).....Excellent Foamex Super Seal after 72 hours @ 1500F.....Excellent Foamex Neoprene 3 after 48 hrs. without heat assist (TS 4082)Excellent Foamex ECP180-30EP after 24 hrs. with heat assist (TS4082).Very Good Foamex (ECP150-30EP after 24 hrs. with heat assist (TS4082)Fair Foamex ECP160-50E2 after 24 hrs. with heat assist (TS4082).....Fair to Good Foamex ECP160-50E7 after 24 hrs. with heat assist (TS4082)Fair Foamex SSW after 24 hrs. with heat assist (TS4082)Excellent 2# Ester UL after 72 hours @ 1500FExcellent 1.8# Ether UL after 72 hours @ 1500FExcellent Ester after 72 hours @ 1500F.....Excellent Hybrid Foam after 72 hours @ 1500FExcellent 7# PVC after 72 hours @ 1500FGood Vinyl Nitrile after 72 hours @ 1500FExcellent Woodbridge "BioFoam" (TS4138)Fair</p>

ADCHEM CORPORATION
 1852 Old Country Road
 Riverhead, NY 11901
 P: 631-727-6000
www.adchem.com

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OTHER BONDING STUDIES:	Polyester Based Powder Coated Paint	73
	Urethane Based Powder Coated Paint	73
	Fluoropolymer Based Powder Coated Paint	69
	20% Talc-Filled Polypropylene	78
	40% Talc-Filled Polypropylene	80
	Mica Filled Polypropylene	88
	Mytex TM Polypropylene	80
	TPO 1402	81
	TPO D162GM	78
	Nylon 66	87
	ABS	54
	Polycarbonate	66
	Acrylic Sheet	94
	Glass	85
	Aluminum	62
Stainless Steel	66	
Glossy Black PVC Film 5 days @ 1500F & 24 hours @ RT (TS3842)	45	
White PVC Film 5 days @ 1500F & 24 hours @ RT (TS 3842)	32	

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