

TECHNICAL DATASHEET: 654M Acrylic Double Sided LSE & Low VOC Tape

PRODUCT DESCRIPTION

A high tack, high shear 2 mils per side acrylic LSE adhesive system on a 0.5 mil PET film carrier.

TYPICAL APPLICATIONS

- Bonding to substrates including ABS, TPO, powder coated paints, PE, PP and numerous types of foams
- Automotive interior applications
- Insulation
- Foam-to-foam and foam-to-plastic bonding
- Headliners
- Panel Electronics

PRODUCT FEATURES & BENEFITS

- Passes automotive fogging test: SAE J-1756 @ 100°C as tested.
- Passes odor test: SAE J-1351
- Quick initial tack
- Low flogging, low flammability
- High peel and shear properties
- Excellent high and low temperature resistance
- Carrier provides dimensional stability and facilitates precise die-cutting
- Liner is conformable and has good dimensional stability

TECHNICAL DATA	VALUE	TEST METHOD / STANDARD
ADHESIVE THICKNESS, EXPOSED SIDE	2 mils	
ADHESIVE THICKNESS, LINER SIDE	2 mils	
CARRIER THICKNESS	0.5 mils	PSTC-133
LINER THICKNESS	5.5 mils	PSTC-133
TOTAL THICKNESS	10 mils	PSTC-133
ADHESIVE TYPE, COVERED SIDE	Acrylic (I626)	
ADHESIVE TYPE, EXPOSED SIDE	Acrylic (I626)	
ADHESIVE SYSTEM	Permanent Adhesive	
ADHESIVE SIDE	Double Sided Adhesive	
ADHESIVE BACKING/CARRIER	PET Film	
COLOR	Clear	
LINER	74# poly-coated kraft	
ADHESION TO STEEL, EXPOSED SIDE (1 MIL PET)	50 oz/in	PSTC-101 - MODIFIED
ADHESION TO STEEL, EXPOSED SIDE, (2 MIL ALUMINUM FOIL)	165 oz/in	PSTC-101 - MODIFIED
ADHESION TO STEEL, LINER SIDE (1 MIL PET)	65 oz/in	PSTC-101 - MODIFIED
ADHESION TO STEEL, LINER SIDE (2 MIL ALUMINUM FOIL)	180 oz/in	PSTC-101 - MODIFIED
LOOP TACK, EXPOSED SIDE	120 oz/inch	PSTC-16
LOOP TACK, LINER SIDE	115 oz/inch	PSTC-16
SHEAR ADHESION	>7 days	PSTC-107 - MODIFIED

Specifications are believed to be accurate at the time of publication and are subject to change without notice. It is the responsibility of the end-user to test and determine suitability of this material for a particular application. **REV. 0**