



The adhesive tape engineers®

TECHNICAL BULLETIN

LOW SURFACE ENERGY ACRYLIC TRANSFER TAPE

PRODUCT:	655 Low Surface Energy (LSE) Transfer Tape		
PRIMARY USE:	<p>655 LSE is excellent for bonding to rigid and flexible plastics as well as to a variety of foams. Proven performance to a variety of low and high energy materials including, ABS, Foil, Film, TPO, TFPP, Nylon and glass</p> <p>Applications: Automotive interior attachments Glass to Rear View Mirror Wire and Cable Mounting Vibration and Sound damping with fabrics and foams</p>		
DESCRIPTION:	<p>A 4.5 mil high initial tack, permanent unsupported acrylic pressure-sensitive film. 655 has high peel and shear properties and is ideal for automotive interior applications Automotive Fogging Test: Passes SAE J1756 @ 100°C as tested Odor: Passes SAE J 1351</p> <p>Contact Adchem Technical Service for additional automotive specifications.</p>		
LINER:	Available in 54" & 60" useable width on 74# White Kraft liner.		
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	NA
		Adhesive Exposed Side (nominal)	4.5 mils
		Release Liner (nominal) 74#	5.5 mils
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>	
		Exposed Side	NA
		Liner Side	58 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum <i>24 Hour Dwell:</i>	
		Exposed Side	NA
		Liner Side	180 oz/inch
	Shear Adhesion	PSTC #107; Modified, 1000 gm/sq. in. @ 72° F.	
		Exposed Side	NA
		Liner Side	7+ Days no failure
		PSTC #107, Modified; 500 gm/sq. in. @ 150°F	
		Exposed Side	NA
Liner Side	7+ Days no failure		

ADCHEM CORPORATION

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655 Low Surface Energy (LSE) Transfer Tape

PHYSICAL PROPERTIES:	Loop Tack	PSTC #16; 140 oz/inch
PRODUCT FEATURES:	<ul style="list-style-type: none"> Available in 54" & 60" useable width on 74# liner. 	
SERVICE TEMPERATURE:	<p>-30°F to 250°F</p> <p>NOTE: This information is provided as a means to help characterize the adhesive's temperature resistance. Note that this data is based on limited testing and under no load. The practical service temperature of this or any adhesive system is dependent on many variables including the substrates being bonded, environmental conditions, and the loading and method of application. The purchaser is responsible for determining the suitability of this or any product for their particular purpose and process. The recommended application temperature is 68°F to 100°F.</p>	
RELATED ADCHEM PRODUCTS:	<p>652-74: 2 mil acrylic transfer 653-74: 3 mil acrylic transfer 654M-74: Double-sided PET 654T-74: Double-sided Tissue</p>	
NOTES:	<p>The use of heat and pressure will help to increase the initial bond of the product to the substrate. Testing is recommended prior to laminating to any material that contains migrating plasticizers.</p>	
SHELF LIFE:	<p>One year from date of shipment when stored under cool, dry conditions.</p>	

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