

**TECHNICAL BULLETIN**

**FILM SUPPORTED TAPE**

PRODUCT:	<b>256M Double-Coated Polyester Film</b>			
PRIMARY USE:	For bonding and laminating to a wide variety of cloths, vinyl's, corks, paper, rigid and flexible plastics. For mounting displays, signs, posters, mirrors, nameplates, and decorative wall products. Especially suited for splicing various types of paper products. Applications where resistance to ultra-violet light and excellent performance during temperature extremes is required. The 256M also exhibits resistance to some plasticizers.			
DESCRIPTION:	A high-tack, moderate shear acrylic adhesive film coated on both sides of a high quality polyester film. Adhesion is excellent to many surfaces. Same adhesive system as 254M. Exhibits excellent balance of properties.			
LINER:	Standard liners are 55# white densified Kraft, 74# white Poly-coated Kraft and 12-pt natural Poly-coated Kraft.			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	0.5 mils	
		Adhesive Exposed Side (nominal)	2.0 mils	
		Adhesive Liner Side (nominal)	2.0 mils	
		55 # Liner (nominal)	3.2 mils	
		74 # Liner (nominal)	5.5 mils	
		12 Pt Liner (nominal)	11.3 mils	
	Peel Adhesion	PSTC #101 Method C; backed with 1 mil polyester <i>Immediate:</i>		
		Exposed Side		56 oz/inch
		Liner Side		56 oz/inch
		<i>24 Hour dwell:</i>		
		Exposed Side		70 oz/inch
		Liner Side		70 oz/inch
		PSTC #101 Method C; backed with 4 mil dead soft aluminum foil <i>Immediate:</i>		
		Exposed Side		75 oz/inch
		Liner Side.		75 oz/inch
NOTE: Peel tests are performed as per PSTC #101, which states one minute maximum dwell time. In general, for acrylic adhesives, longer residence time yields much higher peel values.				

**ADCHEM CORPORATION**  
1852 Old Country Road  
Riverhead, NY 11901  
P: 631-727-6000  
[www.adchem.com](http://www.adchem.com)

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**256M Double-Coated Polyester Film**

TYPICAL PHYSICAL PROPERTIES:	Shear Adhesion	PSTC #107; Procedure A, Modified, 500 gm/sq. in. @ 72° F.	
		Exposed Side	7+ Days
		Liner Side	7+ Days
GENERAL USE:	For bonding and laminating to a wide variety of cloths, vinyl's, corks, paper, rigid and flexible plastics and for mounting displays.		
PRODUCT FEATURES:	<ul style="list-style-type: none"> <li>• Excellent tack.</li> <li>• Bonds well to many surfaces.</li> <li>• Die cuts cleanly.</li> <li>• Excellent peel.</li> <li>• Moderate shear.</li> <li>• Bonds well to most papers (splicing).</li> </ul>		
SERVICE TEMPERATURE:	<p>-30°F to 220°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>		
NOTES:	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.		
RELATED ADCHEM PRODUCTS:	<p>Other double-coated acrylic products include:</p> <p>254M – Lower caliper version of 256M.</p> <p>353M – Alternate acrylic adhesive for low surface energy substrates.</p> <p>654M – High temperature, high shear for LSE substrates.</p>		
SHELF LIFE:	One year from date of shipment when stored under cool, dry conditions.		

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