

TECHNICAL BULLETIN

Supplemental Product Information

PRODUCT:	653 LSE Acrylic Adhesive Transfer
PRIMARY USE:	<p>A high initial tack acrylic adhesive coated on a silicone-coated release liner. 653 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.</p> <p>NOTE: Also available on 2 mil-PET liner as a custom product.</p>
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 @ 150°F.....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 @ 150°FExcellent Foamex Ether after 72 hours @ 150°FExcellent Foamex ECP270-70 after 24 hrs. without heat assist (TS4082)..... Excellent Foamex Super Seal after 72 hours @ 150°FExcellent 2# Ester UL after 72 hours @ 150°FExcellent 1.8# Ether UL after 72 hours @ 150°FExcellent Ester after 72 hours @ 150°FExcellent Hybrid Foam after 7 days @ RTExcellent 7# PVC after 72 hours @ 150°FGood Vinyl Nitrile after 72 hours @ 150°FExcellent Woodbridge Bio Foam after 6 days @ RT (TS4138) Good WT Burnett Urethane ECO Foam #L1535RE (TS4180)Excellent Hydrophobic melamine foam with heat assist (TS4197).....Excellent</p>
OTHER BONDING STUDIES*:	<p>Polyester Based Powder Coated Paint80 Urethane Based Powder Coated Paint76 Fluoropolymer Based Powder Coated Paint90 20% Talc-Filled Polypropylene72 40% Talc-Filled Polypropylene84 Mica Filled Polypropylene98 Mytex TM Polypropylene81 TPO 140279 TPO D162GM80 Nylon 6691</p>

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

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653 LSE Acrylic Transfer Adhesive

OTHER BONDING STUDIES*: (Continued)	ABS	96
	Polycarbonate	118
	Acrylic Sheet	124
	Glass	98
	Aluminum	59
	Stainless Steel	73
	PET to PVC Roofing Membrane (TS3964)	75
	PET Non-Woven Pad (TS4188).....	Very Good
	*180° Peel Adhesion [PSTC-101 Modified]; Tested after 24 Hour Dwell backed with 1mil PET film. Units are in oz/inch.	

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