

TECHNICAL BULLETIN
FILM SUPPORTED TAPE

PRODUCT:	254M Double-Coated Polyester Film			
PRIMARY USE:	This product exhibits all the positive results associated with a high quality general purpose acrylic system. 254M has excellent resistance to oils, plasticizers, ultraviolet light. 254M withstands higher temperatures than rubber based adhesive systems. Also exhibits resistance to some plasticizers. Adhesion is excellent to a very wide variety of substrates.			
DESCRIPTION:	A high tack, moderate shear acrylic adhesive film coated on both sides of a polyester film.			
LINER:	Standard liner is a 55# white Densified Kraft. Also available with 74# white poly-coated Kraft. Other liners available on special order, i.e., 12pt. natural poly-coated Kraft and 80# white Densified Kraft.			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	0.5 mils	
		Adhesive Exposed Side (nominal)	1.3 mils	
		Adhesive Liner Side (nominal)	1.3 mils	
		55# Release Liner (nominal)	3.5 mils	
		74# Release Liner (nominal)	5.5 mils	
		12 pt Board Liner (nominal)	11.3 mils	
	Peel Adhesion	PSTC #101 Method C; backed with 1 mil polyester <i>Initial:</i>		
		Exposed Side		40 oz/inch
		Liner Side		40 oz/inch
		<i>24 Hour Dwell:</i>		
		Exposed Side		60 oz/inch
		Liner Side		60 oz/inch
		PSTC #101 Method C; backed with 4 mil dead soft aluminum foil <i>Initial -</i>		
		Exposed Side		70 oz/inch
	Liner Side		70 oz/inch	
	Shear Adhesion	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.		
		PSTC #107, Procedure A, Modified; 500 gm/sq. in. @ 72°F		
		Exposed Side		7 Days
	Liner Side		7 Days	

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Data presented are typical properties taken from a limited number of production runs and should not be used for specification purposes. Adchem Corporation makes no warranty, expressed or implied, and specifically disclaims and disavows any implied warranty of merchantability and of fitness for a particular purpose. Accordingly, all Adchem products are sold with the understanding that purchasers will be solely responsible for determining the suitability of the materials for any purpose.

TECHNICAL BULLETIN

254M Double-Coated Polyester Film

GENERAL USE:	For bonding and laminating to a wide variety of cloths, vinyl's, corks, paper, rigid and flexible plastics. For mounting displays.
PRODUCT FEATURES:	<ul style="list-style-type: none"> • Excellent peel and shear. • Bonds well to most papers (splicing). • Excellent tack. • Die cuts cleanly. • Bonds well to most surfaces.
SERVICE TEMPERATURE:	-30°F to 220°F 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.
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:	Other double coated acrylic products include: 256M – Higher caliper version of 254M. 353M – Alternate aggressive adhesive system good for LSE surfaces. 654M - Very good for LSE surfaces combined with good elevated temperature Performance.
SHELF LIFE:	One year from date of shipment when stored under cool, dry conditions.

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