

3M

Double Coated PET Tape

6653S(Temporary)

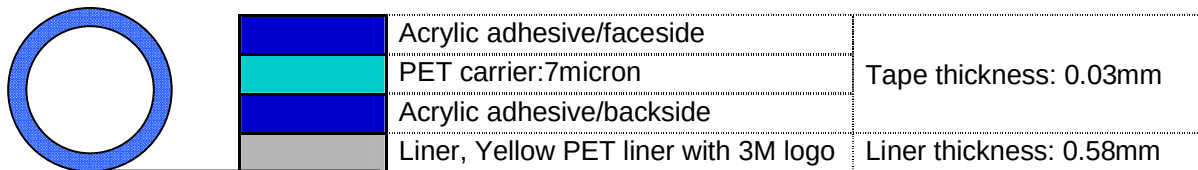
Technical Data

Dec. 2011

Product description

6653S: 3M™ Double Coated PET Tape for dimensional stability and improved handling with ease of die cutting and laminating. The both sides are high adhesion adhesive which make the tape suitable for converting and assembly operation and provides good adhesion to a variety of surfaces.

Product construction



Note 1: Faceside adhesive is on the interior of the roll, exposed when unwound.

Note 2: Backside adhesive is on the exterior of the roll, exposed when liner is removed.

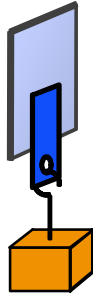
Performance properties

● 180 peel strength on different substrates (N/mm)

Test method: ASTM D3330; Backside substrate: 2mil polyester film; Test speed: 304.8 mm/min

	SS	PP	PC	ABS	Al	Glass
Dwell 20 mins	0.6	0.4	0.6	0.6	0.5	0.6
Dwell 3 days	0.67	0.44	0.64	0.67	0.67	0.67

- **Holding power** Test method: ASTM D3654 (1 inch² sample size); Backside substrate: 2mil polyester film



1000 grams weight at 72 F (22 °C)

≥ 5000 min

- **UV resistance** Medium
- **Relative solvent resistance** Medium

Application information

● application techniques

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure helps develop better adhesive contact and improves bond strength. To obtain optimum adhesion, the bonding surfaces must be clean, dry and well unified. Some typical surface cleaning solvents are isopropyl alcohol or heptane.

Note: Carefully read and follow the manufacturer's precautions and directions for use when working with solvents. Ideal tape application temperature range is 70°F to 100°F (21°C to 38°C). Initial tape application to surfaces at temperatures below 50°F (10°C) is not recommended because the adhesive becomes too firm to adhere readily. However, once properly applied, low temperature holding is generally satisfactory.

● application ideas

Nameplate bonding
Plastic film lamination/bonding
Foam bonding
Process bonding

● application equipment

To apply adhesives in a wide web format, lamination equipment is required to ensure acceptable quality. To learn more about working with pressure-sensitive adhesives please refer to technical bulletin, Lamination Techniques for Converters of Laminating Adhesives.

For additional dispenser information, contact your local 3M sales representative.

Shelf Life & storage condition

Shelf life of tape in roll form is 18 months from date of manufacture when stored in original cartons at 23+/-2°C and 50+/-10% relative humidity.

Certification/Recognition

MSDS: 3M has prepared a MSDS for the products which are subject to the MSDS requirements of the Occupational Safety and Health Administration's Hazard Communication Standard, 29 C.F.R.

TSCA: The product is defined as articles under the Toxic Substances Control Act and therefore, is exempt from inventory listing requirements.

Important Notice

3M MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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If the 3M product is proved to be defective, the exclusive remedy, at 3M'S option, shall be to refund the purchase price of or to repair or replace the defective 3M product. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including, but not limited to, contract, negligence, warranty, or strict liability.

ISO 9002

This Engineered Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

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