

INTEGRAL™ 640

Polyolefin Adhesive Film

The Dow Chemical Company

Message:

INTEGRAL™ 640 Polyolefin Adhesive Film is a heat-activated adhesive film specifically formulated for bonded to steel on both sides of the film. It can also be used as a tie layer to bond two substrates together.

New experimental films are continually being developed. Please discuss your particular application needs with your Dow.

General Characteristics:

Heat Activation Point: 215 °F (102 °C)

Yield: 208 ft²/lb/mil (42.6 m²/kg/25 µm)

Available Colors: Green, blue and clear

Gauge Range: 2.0-4.0 mil (51-102 µm)

Width Range: 15-65 inches (380-1650 mm)

General Information			
Appearance	Blue		
	Green		
Forms	Film		
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	56	µm	
Film Thickness - Recommended / Available	2.0-4.0 mil (51-102 µ)		
Secant Modulus			ASTM D882
1% Secant, MD : 56 µm	263	MPa	
2% Secant, MD : 56 µm	188	MPa	
1% Secant, TD : 56 µm	268	MPa	
2% Secant, TD : 56 µm	198	MPa	
Tensile Strength			ASTM D882
MD : Yield, 56 µm	10.3	MPa	
TD : Yield, 56 µm	9.65	MPa	
MD : Break, 56 µm	22.1	MPa	
TD : Break, 56 µm	20.0	MPa	
Tensile Elongation			ASTM D882
MD : Yield, 56 µm	18	%	
TD : Yield, 56 µm	16	%	
MD : Break, 56 µm	390	%	
TD : Break, 56 µm	600	%	
Elmendorf Tear Strength			ASTM D1922
MD : 56 µm	300	g	
TD : 56 µm	310	g	
Film Width	38.10 to 165.10	cm	
Yield (25.0 µm)	42.6	m ² /kg	
Heat Activation Temperature	102	°C	

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

