

# INTEGRAL™ 625

Polyolefin Adhesive Film

The Dow Chemical Company

## Message:

INTEGRAL™625 is a double-layer adhesive film used for composite processing. The product can be used for bonding with metal sheets. This high-thickness two-layer film can be strongly bonded with zinc (galvanized) and aluminum (aluminized) metals. This kind of film brings anti-corrosion and anti-wear protection to metal and is applied to metal coil or strip. In addition, it can also be applied to various substrates. This kind of film is not suitable for long-term exposure or high temperature occasions.

new experimental films are still under development. Please contact your Dow sales representative for your specific application.

General features:

thermal activation temperature: 215 °F (102°C)

Composite maximum metal temperature: 350-450 °F (176-232°C)

Yield: 203 sq ft/lb/mil (41.7 m²/kg/25 µm)

Available color: black

Thickness range: 2.0-12.0 mil (51-305 µm)

width range: 10-60 in (254-1524mm)

General Information			
Appearance	Black		
Forms	Films		
Hardness	Nominal Value	Test Method	
Durometer Hardness (shaw d, 0.254mm)	46	ASTM D2240	
Mechanical	Nominal Value	Unit	Test Method
Coefficient of Friction	0.55		ASTM D1894
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	250	µm	
Film Thickness - Recommended / Available	2.0-12.0 mil (51-305 µ)		
Secant Modulus - 2% Secant, MD (250 µm)	169	MPa	ASTM D882
Tensile Strength - MD (Break, 250 µm)	20.7	MPa	ASTM D882
Tensile Elongation - MD (Break, 250 µm)	550	%	ASTM D882
Elmendorf Tear Strength - MD (250 µm)	2800 - 3200	g	ASTM D1922
Film width	254 - 1520	mm	
Yield (25.0 µm)	41.7	m²/kg	
Lamination peak metal temperature	177 - 232	°C	
Thermal activation temperature	102	°C	
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength (0.254 mm)	87	kV/mm	ASTM D149
Additional Information			

耐受大多数酸碱,ASTM D1308,1400 小时,73°F:无变化粘接,ASTM D903,73°F:110 磅/英寸不透性,ASTM A742,48 小时,试剂暴露:无变化耐受潮湿 SO2 侵袭,Kesternich DIN 50018.2.OL,40 个循环:无侵袭或粘接损失盐雾额定值:ASTM B117,1000 小时:最低 8°Cleveland 冷凝湿度箱,ASTM D2247,暴露 6 个月,130°F:无侵袭或粘接损失耐候性,ASTM D3361,300 小时:无开裂或分层

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