



DuPont™ Betafuse™ 654 Laminating Adhesive

One-Part, Moisture-Cure, Urethane Adhesive

FEATURES/BENEFITS

Description

DuPont™ Betafuse™ 654 Laminating Adhesive is a one-part, moisture-cure, urethane adhesive designed for application with a roll coater or bead applicator. Betafuse™ 654 is one product in the full line of Betafuse™ Laminating Adhesives designed for semi-continuous and continuous laminators.

Ease of Use

Betafuse™ 654 is easy to handle, use and apply. Some features include:

- Solvent-free liquid with good flow and transfer properties
- Bonds strongly to a wide variety of materials
- Excellent resistance to heat, cold, and moisture

Common applications for Betafuse™ adhesives include:

- Structural insulated panel (SIP) adhesion
- Garage doors
- Walk-in coolers & freezers
- Architectural panels
- Sunroom panels
- RV lamination
- Miscellaneous panel lamination

Available Sizes

Betafuse™ 654 is sold in totes holding 2400 lbs (1089kg) of product.

PROPERTIES

Betafuse™ 654 Laminating Adhesive exhibits physical properties as indicated in Tables 1 and 2 when tested as represented. Review all instructions and (Material) Safety Data Sheet ((M)SDS) before use. Please contact DuPont at 1-866-583-2583 when additional guidance is required for writing specifications that include this product.

TABLE 1: Typical Physical Properties for Betafuse™ 654 Laminating Adhesive

Property	Typical Value
Appearance	Syrupy liquid
Color	Light straw
Solids, %	100
Viscosity (Brookfield RVT, #4 Spindle, 10 rpm), cPs @ 25°C	4500 nominal
Working and cure time	Refer to Table 2
Density	9.59 lbs/gal (1.15 kg/L)
Flash point (Setaflash), °F	>200 (93°C)

TABLE 2: Cure Schedule* for Betafuse™ 654 Laminating Adhesive

Application rate of 12 g/sq.ft. adhesive (129 g/sq.m.) and 2 g/sq.ft. water (22 g/sq.m.)

Temperature	Maximum Working Time	Press Time
60°F (16°C)	23 Minutes	56 Minutes
65°F (18°C)	21 Minutes	51 Minutes
70°F (21°C)	19 Minutes	47 Minutes
75°F (24°C)	17 Minutes	42 Minutes
80°F (27°C)	16 Minutes	38 Minutes
85°F (29°C)	14 Minutes	35 Minutes
90°F (32°C)	13 Minutes	31 Minutes
95°F (35°C)	11 Minutes	28 Minutes
100°F (38°C)	10 Minutes	24 Minutes

* Panels must be under pressure within the stated maximum working time. This information is based on a continuous thin film and is to be used as a guideline. Actual parameters must be verified at the facility where the product is to be used.

INSTALLATION

Use Conditions

A cure schedule detailing maximum working time and press time at varying temperatures for **DuPont™ Betafuse™ 654 Laminating Adhesive** can be found in Table 2.

Application

Betafuse™ 654 is designed to be applied via roll coater or bead applicator. Water mist on the adhesive surface is recommended to ensure uniform cure rate.

Notice

ICC Evaluation Service, Inc. (ICC-ES) has confirmed that **Betafuse™ 654** complies with the provisions of the 2021 International Building Code (2021 IBC), and the 2021 International Residential Code (2021 IRC). This confirmation, as evidenced in ICC-ES evaluation report ESR-1023, provides guidance to code officials faced with approving the use of **Betafuse™ 654** these codes. The evaluation report is available online at www.icc-es.org.

Contact your DuPont sales representative or local authorities for state and local building code requirements and related acceptances.

HANDLING

WARNING: For Professional Use Only. Read and follow the entire Handling section of the Safety Data Sheets (SDSs, formerly MSDSs or Material Safety Data Sheets) carefully before use. The information below is designed to protect the user and allow for safe use and handling of DuPont™ products. Follow all applicable federal, state, local and employer regulations.

Precautionary Statements

- **Betafuse™ 654 Laminating Adhesive** is moisture reactive and must be protected from undue exposure to moisture.
- Use only in well ventilated area away from open flames, sparks, or excessive heat.
- Avoid contact with skin and eyes. Wear protective gloves/ protective clothing/ eye protection/ face protection.

Clean Up and Purge

- To clean up **Betafuse™ 654** before it has cured, use DBE (dibasic ester) or propylene carbonate.
- Use all solvents with care. Make sure there is adequate ventilation. Read and understand the MSDS provided with the solvent.

Shelf Life and Storage

- Ideal storage temperatures for **Betafuse™ 654** are between 50-75°F (10-24°C).
- When stored as directed, and in the original unopened containers, at 70°F (21°C), **Betafuse™ 654** has a shelf life of 1 year from the date of manufacture.
- Containers of **Betafuse™ 654** should be stored under cover and protected from contact with rain or snow. Water should not be allowed to accumulate on the totes where it can be drawn into the containers.
- Once opened, containers of the adhesive should be used immediately or protected by a blanket of dry nitrogen and sealed.

Disposal

Dispose of any residual DuPont™ product, coated debris, or solvent in accordance with applicable federal, state, and local government regulations.



**For more information visit us at
building.dupont.com
or call 1-866-583-2583**

NOTICE: No freedom from any patent owned by DuPont or others is to be inferred. Because use conditions and applicable laws may differ from one location to another and may change with time, Customer is responsible for determining whether products and the information in this document are appropriate for Customer's use and for ensuring that Customer's workplace and disposal practices are in compliance with applicable laws and other government enactments. The product shown in this literature may not be available for sale and/or available in all geographies where DuPont is represented. The claims made may not have been approved for use in all countries or regions. DuPont assumes no obligation or liability for the information in this document. References to "DuPont" or the "Company" mean the DuPont legal entity selling the products to Customer unless otherwise expressly noted. NO EXPRESS WARRANTIES ARE GIVEN EXCEPT FOR ANY APPLICABLE WRITTEN WARRANTIES SPECIFICALLY PROVIDED BY DUPONT. ALL IMPLIED WARRANTIES INCLUDING THOSE OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXPRESSLY EXCLUDED. The buyer assumes all risks as to the use of the material. Buyer's exclusive remedy or any claim (including without limitations, negligence, strict liability, or tort) shall be limited to the refund of the purchase price of the material. Failure to strictly adhere to any recommended procedures shall release DuPont Specialty Products USA, LLC or its affiliates, of all liability with respect to the materials or the use thereof. The information herein is not intended for use by non-professional designers, applicators or other persons who do not purchase or utilize this product in the normal course of their business.

DuPont™, the DuPont Oval Logo, and all trademarks and service marks denoted with ™, SM or ® are owned by affiliates of DuPont de Nemours, Inc. unless otherwise noted. © 2024 DuPont.

43-D100128-enUS-0124 CDP