

Avery Dennison Performance Tapes

Acrylic Foam Bond (AFB™) Heat-Activated 94 Series

AFB 94 Series incorporates a heat-activated adhesive for lamination to rubber extrusions commonly used in sealing and gasketing applications. The viscoelastic acrylic foam core and acrylic pressure-sensitive adhesive offers high adhesion and good shear resulting in even shock absorption and stress distribution. AFB 94 Series constructions feature moisture, UV and high-temperature resistance and uniform bonding performance. Products in the series are also built with a polyethylene liner that provides good moisture stability and high tear strength for easier converting. By using AFB 94 Series constructions, the need for mechanical fasteners can be eliminated, as well as the drilling or grinding and related clean-up for certain applications.

Application Examples

- Recreational Vehicles
- Boats
- Jet Skis
- ATVs
- Appliances
- Rail and Bus



Peel Adhesion Testing

90° peel adhesion testing was performed on a variety of substrates and under multiple conditions. The substrates and conditions are representative of typical applications. Overall, the products perform similarly with slight differences for each substrate and condition.

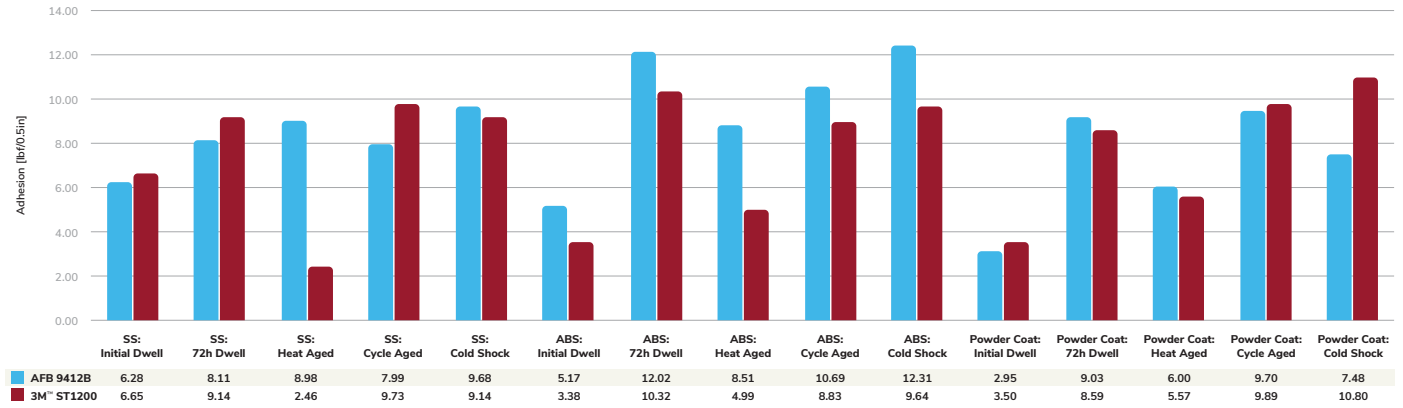
Substrates

- Stainless Steel (SS)
- Acrylonitrile Butadiene Styrene (ABS)
- Powder Coated Metal (Powder Coat)

Conditions

- Initial Dwell
- 72-hour dwell
- Heat Aged: Seven days at 70°C
- Cycle Aged: Two repetitions of 17 hours at -30°C, 72 hours at 70°C, 24 hours at 38°C / 100% RH, 7 hours at -30°C, 24 hours at 38°C / 100% RH, 7 hrs at 70°C, 24 hours at 38°C / 100% RH
- Cold Shock: 72 hours at 54°C, 4 hours at -30°C

90° Peel Adhesion (ASTM D3330)

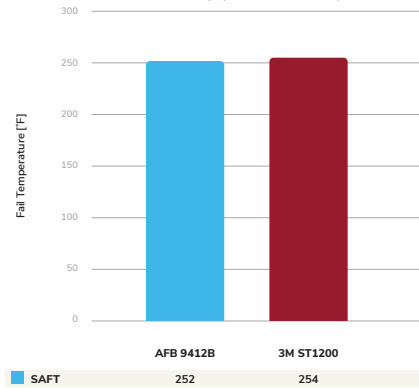


Shear Testing

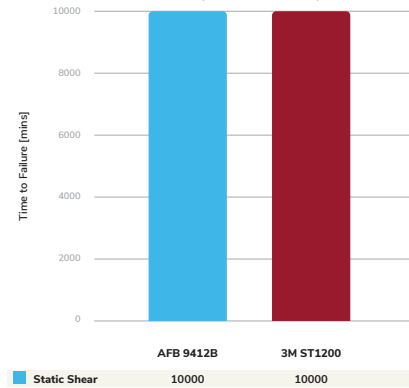
Shear adhesion failure temperature was conducted with 500g weights and the temperature was increased steadily until failure. Both products failed at just over 250°F.

Shear testing was conducted with 1000g weights at room temperature with 1"x1" tape sections. Here, both tapes did not fail and testing was discontinued at 10,000 minutes.

Shear Adhesion Failure Temperature - 500g (ASTM D4498)



Static Shear - 1000g (ASTM D1000)



All testing was conducted with a "D" shaped, hollow EPDM extrusion.



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For more information on our bonding tapes and adhesive solutions, visit [Tapes.AveryDennison.com](https://tapes.averydennison.com)