

TECHNICAL DATA SHEET

Avery Dennison™ AFB™ 6115B is a black acrylic double coated foam tape with multipurpose acrylic adhesive on both sides. This firm yet thin foamed adhesive offers strong lamination properties and good weather and environmental resistance. An additional layer of adhesive offers resistance of migration toward plasticizer in vinyl substrates. Suitable for a wide range of applications including nameplate, sign bonding, and control panel mounting.

FEATURES

- Foam tape with viscoelastic acrylic foam carrier
- Closed cell structure
- Acrylic adhesive system

BENEFITS

- High adhesion combined with good shear absorbs shock and distributes stress evenly
- Good moisture, UV and high temperature resistance
- Uniform bonding performance
- Helps eliminate the need for mechanical fasteners, drilling or grinding and related clean-up for certain applications



CONSTRUCTION

Liner: Red Polyethylene Liner with Imprinted Avery Logo

Adhesive 1: Acrylic

Carrier: Black Acrylic Foam Core

Adhesive 2: Acrylic



Performance
Tapes

Adhesive Properties

Typical Values

| THICKNESS (ASTM D3652) | | US Mil's | MM's | Micron's (µm) |
|--|--------------|-----------------|--------------------|------------------|
| Liner | | 5.1 | 0.13 | 130 |
| Carrier & Adhesive | | 59.1 | 1.50 | 1500 |
| Total Caliper without Liner | | 59.1 | 1.50 | 1500 |
| Total Caliper | | 64.2 | 1.63 | 1630 |
| PEEL ADHESION (ASTM D3330) | | | | |
| 180° (12") 300 mm / min @ Room Temp | | | | |
| SUBSTRATE | | Lbf / in | US Oz / In | N / Meter |
| Stainless Steel | 20 min dwell | 14.6 | 235 | 2,571 |
| | 72 hr dwell | 19.1 | 307 | 3,364 |
| LOOP TACK (ASTM D6195) | | | | |
| 6.25 cm ² (1"sq) 300 mm / min @ Room Temp | | | | |
| SUBSTRATE | | Lbf / in | US Oz / In | N / Meter |
| Glass | Initial | | | |
| DYNAMIC SHEAR (ASTM D897) | | | | |
| 6.25 cm ² (1"sq) 50 mm / min @ Room Temp | | | | |
| SUBSTRATE | | | kPa | |
| Aluminium | 72hrs dwell | | 615 | |
| STATIC SHEAR (ASTM D3654) | | | | |
| 6.25 cm ² (1"sq) 1000 g @ Room Temp | | | | |
| SUBSTRATE | | | Min to Fail | |
| Stainless Steel | 72hrs dwell | | >10,000 | |
| TEMPERATURES | | | °F | °C |
| Minimum Application Temperature | | | 50 °F | 10 °C |
| Minimum Service Temperature | | | -40 °F | -40 °C |
| Maximum Service Temperature | | | 302 °F | 150 °C |

Note: The listed values are typical only and not intended to serve as product specifications

APPLICATION TECHNIQUES

- It is essential, as with all pressure-sensitive tapes, that the surface to which the tape is applied be clean, dry, and free of grease or oil
- Bond strength is dependent upon the amount of adhesive-to-surface contact developed
- Note that different pressure, time and temperature on different (film / rigid) surface achieves different performance

STORAGE / SHELF LIFE

Two years when stored at 64-72 °F (18-22 °C) / 30-70 % relative humidity, out of direct sunlight and in original packaging.

For more information on our bonding tapes and adhesive solutions, call us:

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Asia Pacific: +86 512 57155001

Europe: +32 (0)14 40 48 11

www.tapes.averydennison.com