



## AFB™ 6411W

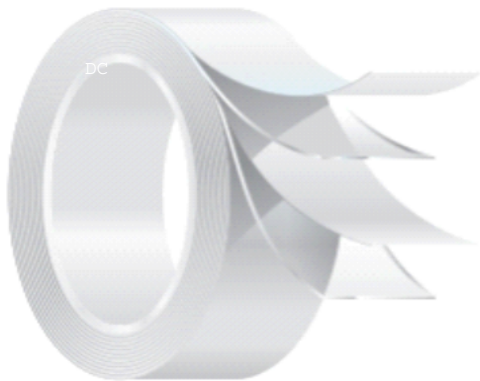
Avery Dennison™ AFB™ 6411W is a white acrylic double coated foam tape, with acrylic adhesive for low surface energy substrates on both sides. This firm yet thin foam adhesive is a custom solution for low surface energy (LSE) substrates and features an additional layer of modified acrylic adhesive for good bonding to powder coated paints. The conformable foam density level enables good lamination on irregular substrates, and offers good weather and environmental resistance. Used for construction and mounting, attachments, and bonding of bumper rails and nameplates on low surface energy (LSE) materials.

### 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
- Polyethylene liner helps provide good moisture stability and easier converting with its high tear strength



### CONSTRUCTION:

**Liner:**

Polyethylene Coated White Paper

**Adhesive 1:**

LSE Acrylic

**Carrier:**

White Acrylic Foam Core

**Adhesive 2:**

LSE Acrylic

**AFB™ 6411W**

Adhesive Properties:		Typical Values		
Thickness	ASTM D3652	US Mils	MM's	Micron's (µm)
Liner		6.3	0.16	160
Carrier & Adhesive		43.3	1.10	1100
Total Caliper without Liner:		43.3	1.10	1100
Total Caliper:		49.6	1.26	1260

Peel Adhesion		ASTM D3330		
90° 12 in (300 mm) min @ Room Temp				
Substrate			Lbf / in	N / Meter
SS	Liner	20 min dwell	11.3	1,990
SS	Liner	72 hr dwell	16.0	2,818

Dynamic Shear		ASTM D1002		
180° 0.5 in (12.7 mm) / min @ Room Temp				
Substrate			Lbf / in	N / Meter
SS	Liner	72 hr dwell	107.3	18,896

Normal Tensile		ASTM D1002		
180° 2 in (50.8 mm) / min @ Room Temp				
Substrate			Lbf / in	N / Meter
Aluminum	Liner	72 hr dwell	105.2	18,526

Static Shear		ASTM D3654		
180° 1" sq (6.5 cm2) 500 g @ 194°F / 90°C				
Substrate			Min to Fail	
SS	Liner	Initial	> 10,000	

TEMPERATURES	° F	° C
Minimum Service Temperature	212° F	100° C
Maximum Service Temperature	248° F	120° C

THE LISTED VALUES ARE TYPICAL 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**

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

Please refer to Tapes.AveryDennison.com for complete terms and conditions, including warranty terms, relating to this product. You should periodically review the site as terms and conditions are subject to change without notice.

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