

## TECHNICAL DATA SHEET

**Avery Dennison™ AFB 6680G** is a grey acrylic foam tape with general purpose acrylic adhesive. This firm, dense adhesive enables good lamination and maintains high internal strength on irregular substrates, even when surfaces are mismatched. Offers excellent longer term durability and internal strength, and is suitable for auto-dispensing by converters. Ideal for attachments in large domestic appliances, air-conditioners, housing lamination and nameplate or sign bonding. Suitable industry applications include manufacturing, construction and appliance assembly, including metal or plastic bonding with high internal strength. Suitable for office furniture and telecommunication mounting, decoration and TV frame mounting.

### FEATURES

- Foam tape with viscoelastic acrylic foam carrier
- Closed cell structure
- Acrylic adhesive system
- Easy release polyethylene liner

### BENEFITS

- High adhesion combined with good shear absorbs shock and distributes stress evenly
- Good moisture, UV and high temperature resistance
- Uniform bonding performance
- Can help 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:** Red polyethylene liner with Avery Dennison logo

**Adhesive:** Gray acrylic foam core



Performance  
Tapes

## Adhesive Properties

## Typical Values

THICKNESS (ASTM D3652)	US Mil's	MM's	Micron's (µm)
Liner	5.1	0.13	130
Adhesive + Carrier	31.5	0.80	800
Total Caliper	36.6	0,93	930
<b>PEEL ADHESION (ASTM D3330)</b>			
180° (12") 300 mm / min @ Room Temp			
<b>SUBSTRATE</b>		<b>Lbf / in</b>	<b>N / m</b>
Stainless Steel	20 min dwell	7.8	1370
	72 hr dwell	9.7	1700
<b>DYNAMIC SHEAR (ASTM D- 1002)</b>			
1"sq (6.25 cm²) 2mm / min @ Room Temp			
<b>SUBSTRATE</b>		<b>Lbf / in²</b>	<b>kPa</b>
Stainless Steel	72 hr dwell	91.4	630
<b>NORMAL TENSILE (ASTM D- 897)</b>			
1"sq (6.25 cm²) 50mm / min @ Room Temp			
<b>SUBSTRATE</b>		<b>Lbf / in²</b>	<b>kPa</b>
Aluminium	72 hr dwell	89.9	620
<b>STATIC SHEAR (ASTM D3654)</b>			
1"sq (6.25 cm²) 1000 g @ Room Temp			
Stainless Steel	@ 90°C	Min to Fail > 10,000	
<b>TEMPERATURES</b>		<b>°F</b>	<b>°C</b>
Minimum Application Temperature		50 °F	10 °C
Minimum Service Temperature		-40 °F	-40 °C
Maximum Service Temperature		248 °F	120 °C

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

## APPLICATION TECHNIQUES

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

## STORAGE / SHELF LIFE

The shelf life of the product is one year when stored at 18-22 °C / 64-72 °F, 30-70 % relative humidity and out of direct sunlight, in original packaging.

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

North America: +1 866 462 8379

Asia Pacific: +86 512 57155001

Europe: +32 (0)14 40 48 11

[www.tapes.averydennison.com](http://www.tapes.averydennison.com)