

## TECHNICAL DATA SHEET

**Avery Dennison™ AFB™ 6111G** is a gray acrylic foam tape with general purpose acrylic adhesive. This conformable, foamed 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

### 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:** Red Polyethylene Liner with Imprinted Avery Logo

**Adhesive 1:** Acrylic adhesive

**Carrier:** Gray Acrylic Foam Core

**Adhesive 2:** Acrylic adhesive



Performance  
Tapes

## Adhesive Properties

## Typical Values

THICKNESS (ASTM D3652)		US Mils	MM's	Micron's (µm)
Liner		5.1	0.13	130
Carrier & Adhesive		43.3	1.10	1100
Total Caliper		48.4	1.23	1230
PEEL ADHESION (ASTM D3330)				
180° (12") 300 mm / min @ Room Temp				
SUBSTRATE		Lbf / in	US Oz / In	N / Meter
Stainless Steel	20 min dwell	13.9	224	2,448
	72 hr dwell	17.9	286	3,135
NORMAL TENSILE (ASTM D6195)				
6.25 cm <sup>2</sup> (1") 50 mm / min (2" ) @ Room Temp				
SUBSTRATE			kPa	
Aluminium	72hrs dwell		670	
DYNAMIC SHEAR (ASTM D897)				
6.25 cm <sup>2</sup> (1"sq) 2 mm / min @ Room Temp				
SUBSTRATE			kPa	
Stainless Steel	72hrs dwell		680	
STATIC SHEAR (ASTM D3654)				
6.25 cm <sup>2</sup> (1"sq) 1000 g @ Room Temp				
SUBSTRATE			Min to Fail	
Stainless Steel	Initial		> 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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[www.tapes.averydennison.com](http://www.tapes.averydennison.com)