

## TECHNICAL DATA SHEET

**Avery Dennison™ FT 21905** is a 5mil transfer tape with an advanced acrylic adhesive and a polyethylene protected paper liner. It offers low VOC and fogging performance and broad temperature compatibility. It is resistant to solvents, chemicals, plasticizers, and UV and it ensures reliable adhesion. It shows good adhesion on metal and medium or high surface energy substrates and is used for assembly applications requiring high temp resistance and low VOC.

### FEATURES

- Advanced pure acrylic adhesive
- APEO free adhesive
- Low VOC and Fogging performance
- Easy release glassine liner
- Broad range of service temperatures

### BENEFITS

- Excellent resistance to solvents, chemicals, plasticizers, temperature and UV light
- Good resistance to moisture
- Good conformability to flat or curved surfaces
- Immediate initial adhesion for part placement
- Excellent die cutting characteristics and lay flat properties



### CONSTRUCTION

**Liner:** Polyethylene protected paper natural liner

**Adhesive:** Pure acrylic



Performance  
Tapes

## Adhesive Properties

## Typical Values

THICKNESS (ASTM D3652)		US Mils	MM's	Micron's (µm)
Liner		4.92	0.125	125
Adhesive		4.92	0.125	125
Total Caliper		9.84	0.250	250
<b>PEEL ADHESION (ASTM D3330)</b>				
180° (12") 300 mm / min @ Room Temp				
SUBSTRATE		Lbf / in	US Oz / In	N / Meter
Stainless Steel	20 min dwell	3.33	53	584
	24 hr dwell	3.84	61	672
Polycarbonate	20 min dwell	4.98	80	872
	24 hr dwell	5.09	81	892
Painted Steel	20 min dwell	1.30	21	228
	24 hr dwell	1.42	23	248
Polypropylene	20 min dwell	393	63	688
	24 hr dwell	425	68	744
<b>LOOP TACK (ASTM D6195)</b>				
(12") 300 mm / min @ Room Temp				
SUBSTRATE		Lbf / in	US Oz / In	N / Meter
SS	Initial	3.20	51	560
<b>STATIC SHEAR (ASTM D3654)</b>				
1"sq (6.25 cm <sup>2</sup> ) 1000 g @ Room Temp				
SUBSTRATE		Minutes to Fail		
Stainless Steel	Initial	> 10000		
TEMPERATURES		°F	°C	
Minimum Application Temperature		50 °F	10 °C	
Minimum Service Temperature		-40 °F	-40 °C	
Maximum Service Temperature		392 °F	200 °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

## 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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