



**250 Chester Street  
Painesville, Ohio 44077**  
Phone: **866-GO-AVERY (866-462-8379)**  
Fax: **888-358-4469**

email: [psa.tape@averydennison.com](mailto:psa.tape@averydennison.com)

URL: [stus.averydennison.com](http://stus.averydennison.com)

#### Surface Preparation

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.

#### Temperatures

Min Application Temp	50° F	10° C
Max Continuous Operating Temp	250° F	120° C
Max Intermittent Operating Temp	320° F	160° C

#### Storage and Shelf Life

Two years when stored at 70°F (21°C) 50% RH out of direct

#### Limited Warranty

All statements, technical information and recommendations concerning products sold or samples provided by AVERY DENNISON are based upon tests believed to be reliable but do not constitute a guarantee or warranty. All products are sold and samples of products provided with the understanding that PURCHASER has independently determined the suitability of such products for its purposes. AVERY DENNISON warrants the products to be free from defects in material and workmanship. Should any failure to conform to this warranty appear within two years\* after the initial date of shipment, AVERY DENNISON shall, upon notification thereof and substantiation that the products have been stored and applied in accordance with AVERY DENNISON's standards, correct such defects by suitable repair or replacement without charge at AVERY DENNISON's plant or at the location of the products (at AVERY DENNISON's election) provided, however, if AVERY DENNISON determines that the repair or replacement is not commercially practical, AVERY DENNISON shall issue credit in favor of PURCHASER in an amount not to exceed the purchase price of the products.

This warranty is exclusive and is in lieu of any implied warranty of merchantability, fitness for a particular purpose or other warranty of quality, whether express or implied, except the warranty of title and against patent infringement. No waiver, alteration, additions or modifications of the foregoing conditions shall be valid unless made in writing and manually signed by an officer of Avery Dennison. \*Or in the time period stated on the specific product specification sheet, if any, and if not then on the specific product information literature in effect at time of shipment.

#### Limitation of Liability

In no event shall AVERY DENNISON be liable for any incidental or consequential damages, including but not limited to, loss of profit, loss of use of production or loss of capital. The remedies of PURCHASER set forth herein are exclusive and the total liability of AVERY DENNISON with respect to any contract, or anything done in connection therewith such as the performance or breach hereof, or from the manufacture, sale, delivery, resale, installation or use of products whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not exceed the purchase price of the products upon which the liability is based.

## PRODUCT DESCRIPTION

### Applications

Avery Dennison AFB 6680G is a grey acrylic foam tape with double coated general purpose acrylic adhesive on both sides. It is used for bonding a wide range of high surface energy substrates including metal and glass. This product has high initial tack with good adhesion and shear strength, and also resists UV lights and elevated temperatures. AFB 6680G is suitable for many interior and exterior industrial applications.

### Features

Viscoelastic acrylic foam carrier  
Firm density foam  
Improved productivity  
Improved aesthetics

### Benefits

High adhesion combined with good shear and stress relaxation  
Absorbs shock and distributes stress evenly  
Good resistance to moisture, UV, High temperature  
High performance bonding to irregular surfaces  
Eliminate drilling, grinding, refinishing, screwing, welding and clean-up  
Virtually invisible fastening helps keep surface smooth and clean  
Polyethylene liner provide good moisture stability and easy converting with high tear strength.

## PRODUCT DATA

### Product Construction

		Test Methods: PSTC-133	
		<u>US Mil's</u>	<u>MM's</u>
Unwind Adhesive	Acrylic	-	-
Carrier	Grey Acrylic Foam and Adhesive	<b>31.5</b>	<b>0.80</b>
Liner Adhesive	Acrylic	-	-
Liner	Red Avery Logo Printed Polyethylene	<b>5.1</b>	<b>0.13</b>
	Total Construction	<b>36.6</b>	<b>0.93</b>

### Adhesive Properties

#### Peel Adhesion

2 mil PET 90° 12" / min

Test Method(s): PSTC-101, ASTM D3330, STD-10

<u>Substrate</u>	<u>Condition</u>	<u>Lbf / in</u>	<u>US Oz / in</u>	<u>N / Meter</u>
SS	Liner - 20 min dwell	<b>7.8</b>	<b>124</b>	<b>1,361</b>

#### Peel Adhesion

2 mil PET 90° 12" min

Test Method(s): PSTC-101, ASTM D3330, STD-10

<u>Substrate</u>	<u>Condition</u>	<u>Lbf / in</u>	<u>US Oz / in</u>	<u>N / Meter</u>
SS	Liner - 72 hr dwell	<b>9.7</b>	<b>155</b>	<b>1,700</b>

#### Dynamic Shear

2 mil PET 180° 1" sq (6.5 cm2) 0.5" min

Test Method(s): ASTM D1002, STD-27

<u>Substrate</u>	<u>Condition</u>	<u>Lbf / in</u>	<u>US Oz / in</u>	<u>N / Meter</u>
SS	Liner - 72 hr dwell	<b>91.4</b>	<b>1,462</b>	<b>16,004</b>

#### T-Block

Product 180° 1" sq (6.5 cm2) 2" min

Test Method(s): ASTM D897

<u>Substrate</u>	<u>Condition</u>	<u>Lbf / in</u>	<u>US Oz / in</u>	<u>N / Meter</u>
Aluminum		<b>89.9</b>	<b>1,438</b>	<b>15,741</b>

#### Static Shear

2 mil PET 1" sq (6.5 cm2) @ 120°C / 250°F

Test Method(s): PSTC-107, ASTM D3654, STD-9

<u>Substrate</u>	<u>Condition</u>	<u>Min to Fail</u>
SS	Liner - 30 min dwell	<b>&gt; 10,000</b>