

## TECHNICAL DATASHEET AFTC 6411 - 0.047" THICK

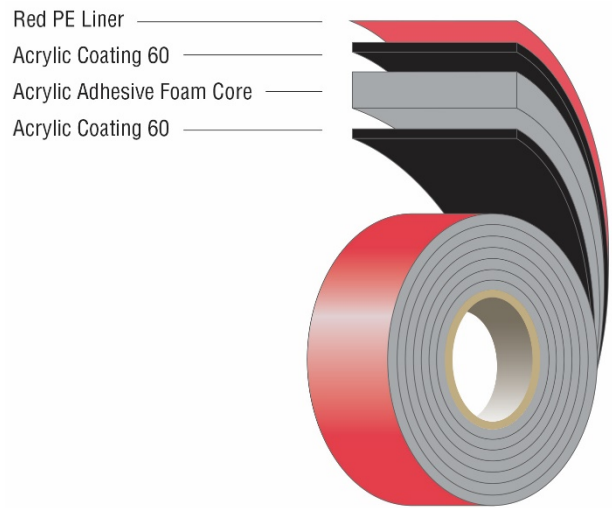
### PRODUCT DESCRIPTION

This product is a double sided highly conformable acrylic based adhesive tape, which is especially designed for a variety of materials with high, medium and low surface energy like powder coatings and several plastics. This tape is capable of absorbing the different thermal expansions of two materials. This high performance tape has a very high initial tack and can be used on almost all substrates. This modified multipurpose adhesive tape has been specifically developed for applications where the use of a primer or adhesion promoter is not preferred.

### TYPICAL APPLICATIONS

Several LSE surfaces like:

- Powder-coatings
- Plastics
- Coated glass
- Ceramics
- Silicones
- Teflon
- PP
- PE



### PRODUCT FEATURES & BENEFITS

- UV resistant
- Solvent resistant

TECHNICAL DATA	VALUE	TEST METHOD / STANDARD
<b>THICKNESS</b>	0.047" ±10%	
<b>COLOR</b>	Black+	
<b>MATERIAL / SUBSTRATE</b>	Coated Acrylic Foam	
<b>CORE</b>	Acrylic Adhesive Foam Core	
<b>ADHESIVE TYPE</b>	Acrylic Coating 60	
<b>ADHESIVE SYSTEM</b>	Permanent Adhesive	
<b>ADHESIVE SIDE</b>	Double Sided Adhesive	
<b>LINER</b>	Red PE liner	
<b>DENSITY</b>	37 lb/ft <sup>3</sup>	
<b>MINIMUM TEMPERATURE RESISTANCE</b>	-40°F	
<b>SHORT-TERM TEMPERATURE RESISTANCE</b>	248°F	
<b>LONG-TERM TEMPERATURE RESISTANCE</b>	194°F	
<b>90° PEEL ADHESION</b>	22 lb/in	ASTM D3330
<b>DYNAMIC SHEAR STRENGTH</b>	94 lb/in <sup>2</sup>	ASTM D1002
<b>TENSILE STRENGTH</b>	94 lb/in <sup>2</sup>	ASTM D897
<b>STATIC SHEAR STRENGTH @ 72°F</b>	1,000 grams*	ASTM 3654
<b>STATIC SHEAR STRENGTH @ 150°F</b>	500 grams*	ASTM 3654
<b>STATIC SHEAR STRENGTH @ 200°F</b>	500 grams*	ASTM 3654

Specifications are believed to be accurate at the time of publication and are subject to change without notice. It is the responsibility of the end-user to test and determine suitability of this material for a particular application. **REV. 0**

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<b>STATIC SHEAR STRENGTH @ 250°F</b>	250 grams*	ASTM 3654
<b>CELL STRUCTURE</b>	Closed Cell	
<b>SOLVENT RESISTANCE</b>	Excellent	
<b>UV RESISTANCE</b>	Excellent	
<b>RECOMMENDED APPLICATION TEMPERATURE</b>	Minimum 65°F	

**NOTES:** +All "Black" tapes have a gray core and black adhesive

\*Weight that 1/2 square inch will hold 10,000 minutes (7 days).

<b>SHELF LIFE/STORAGE</b>	
<b>SHELF LIFE</b>	12 months
<b>RECOMMENDED STORAGE CONDITIONS</b>	Store in its original package and in a dry place between 40°F and 95°F

**CLEANING**

To clean your light and medium contaminated substrates, use an isopropanol/alcohol solution (IPA). When cleaning your substrate, a tear free, light colored paper towel is required. Wipe the substrate in one direction using the one cloth method (one cloth with cleaner) or a two-cloth method (one cloth with cleaner and one dry cloth to follow) is acceptable if you are short on time. Repeat these steps until your cloth is clean and free of any contaminants. For heavily contaminated substrates, use a cleaning agent such as MEK, Heptan or Acetone. These cleaning agents may leave a residue which would have to be removed using the IPA cleaner.

**ABRASION**

When bonding to raw aluminum, abrading of the surface is a must. The oils used in the waltzing of the aluminum are pressed into the pores of the material. To remove these oils, that will influence the bond, we recommend using abrasive pads to ensure the proper level of abrasion without damaging your substrates. Besides raw aluminum, abrading is a method utilized to help improve your bond. After the abrasion process is completed, remove any residue using an IPA cleaner following the methods mentioned above.

**PRIMER**

The use of a primer is recommended when bonding to some low surface energy substrates. Examples include, different types of polymers, powder coated metals, or porous materials such as wood, cork, stone or concrete. Primers are also used to help speed up your production process. The AFTC line can take up to 72 hours to reach its end-strength. The use of a primer ensures the end-strength will be achieved within 20 minutes.

H-O Products offers two primers; the primer 33 and the primer 101. Determining which one of these primers is suitable for your application ultimately depends on the substrates and environmental influences.

**PRESSURE**

AFTC tapes are pressure sensitive adhesives. Therefore, a minimum amount of pressure is required on the bond line to ensure the maximum adhesion to your substrates. This pressure should be applied in a rolling fashion. A hand roller or mechanical presser are the preferred methods. The pressure on the bond line must be a minimum of at least 14.5 psi.

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