

## TECHNICAL DATA SHEET

**Avery Dennison™ FT 239** is a 245 µm double coated tape with a permanent soft synthetic rubber adhesive for applications requiring aggressive adhesion on rough or foam substrates.

### FEATURES

- Extremely high tack adhesive
- Thick adhesive mass
- Low density open tissue
- Easy release liner

### BENEFITS

- Provides excellent initial adhesion to a wide variety of substrates
- Good bonding to uneven surfaces
- Provides exceptional conformability while capable of anchoring to low density foams
- Facilitates easy removal at point of application



### CONSTRUCTION

**Liner:** Blue-green glassine

**Adhesive:** Rubber

**Carrier:** Tissue

**Adhesive 2 Unwind:** Rubber

## Adhesive Properties

## Typical Values

THICKNESS (PSTC-133)		US Mils	MM's	Micron's (µm)
Liner		3.4	0.09	85
Carrier & Adhesive:		6.3	0.16	160
Total Caliper		9.7	0.25	245
<b>PEEL ADHESION (ASTM D3330)</b>				
180° (12") 300 mm / min @ Room Temp				
<b>SUBSTRATE</b>		<b>Lbf / in</b>	<b>US Oz / In</b>	<b>N / Meter</b>
Stainless Steel	20 min dwell	5.0	80	870
	24 hr dwell	5.1	82	900
Polycarbonate	20 min dwell	4.4	70	770
	24 hr dwell	4.5	72	790
Painted Steel	20 min dwell	5.1	82	900
	24 hr dwell	5.2	83	911
Polypropylene	20 min dwell	3.7	58	639
	24 hr dwell	3.8	61	671
<b>LOOP TACK (ASTM D6195)</b>				
1"sq (6.25 cm <sup>2</sup> ) 300 mm / min @ Room Temp				
<b>SUBSTRATE</b>		<b>Lbf / in</b>	<b>US Oz / In</b>	<b>N / Meter</b>
Glass	Initial	6.3	100	1100
<b>DYNAMIC SHEAR (ASTM D- 1002)</b>				
1"sq (6.25 cm <sup>2</sup> ) 2mm / min @ Room Temp				
<b>SUBSTRATE</b>			<b>Lbf / in<sup>2</sup></b>	<b>kPa</b>
Stainless Steel			28	194
<b>STATIC SHEAR (ASTM D3654)</b>				
1"sq (6.25 cm <sup>2</sup> ) 1000 g @ Room Temp				
<b>SUBSTRATE</b>			<b>Min to Fail</b>	
Stainless Steel Initial			> 1,800	
<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			175 °F	80 °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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