

# Industrial High Performance Bonding

Product Information Bulletin : **XHA 6680**

Spec # 57313

Industrial Foam Tape

**XHA™ 6680**



## Specialty Tape Division

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### 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 **400° F** **204° C**

Max Intermittent Operating Temp **480° F** **249° C**

### Storage and Shelf Life

One year when stored at 70°F (21°C) 50% RH out of direct sunlight.

### 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 one year\* 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.

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## PRODUCT DESCRIPTION

### Applications

XHA™ 6680 is particularly suited for superior adhesion to common substrates found in industrial applications. The conformable acrylic core allows for good stress relaxation and the adhesive bonds well to metals and painted surfaces.

FEATURE	BENEFIT
Visco-elastic acrylic foam	Very high adhesion combined with good shear and stress relaxation
High density acrylic foam	High density foam offers high temperature resistance
Polyethylene liner	Polyethylene liner combines moisture stability with tear resistance
Easy liner release	Easy liner release enable smooth removal during application
UV and solvent resistant	Delivers long-term durability

## PRODUCT DATA

### Product Construction

Tape	Acrylic Foam	Test Methods: PSTC-33	
		US Mils	MM's
Liner	Polyethylene	<b>4.0</b>	<b>0.10</b>
	Total Construction	<b>35.5</b>	<b>0.90</b>

### Adhesive Properties

#### Peel Adhesion

2 mil PET 90° 12" / min 72 hr dwell Test Method(s): PSTC-3, ASTM D-3330, STD-10

Substrate	Lbf / in	US Oz / in	N / Meter
SS	<b>20</b>	<b>320</b>	<b>3,502</b>
Aluminum	<b>23</b>	<b>368</b>	<b>4,027</b>

#### Dynamic Shear

180° 2" / min 72 hr dwell 1" sq (6.5 cm2) Test Method(s): ASTM D-1002, STD-27

Substrate	Lbf / Sq in	US Oz / Sq in	kPa
SS	<b>90</b>	<b>1,440</b>	<b>621</b>
Aluminum	<b>90</b>	<b>1,440</b>	<b>621</b>

#### T Block Tensile

90° 2" / min 72 hr dwell 1" sq (6.5 cm2) Test Method(s): ASTM D-897

Substrate	Lbf/sq in	US Oz / Sq in	kPa
SS	<b>60</b>	<b>960</b>	<b>414</b>
Aluminum	<b>65</b>	<b>1,040</b>	<b>448</b>

#### SAFT

Foil Initial 1" sq (6.5 cm2) 1000 g Test Method(s): PSTC-5, ASTM D 3654, STD-243

Substrate	Fail Temp °F
SS	<b>400+</b>

THE LISTED VALUES ARE TYPICAL AND NOT INTENDED TO SERVE AS PRODUCT SPECIFICATIONS