TECHNICAL DATA SHEET

Avery Dennison™ FT 219

FEATURES

- Cross-linked acrylic adhesive
- High coat-weight adhesive
- Low density nonwoven carrier
- Medium release liner

BENEFITS

- Provides a very high temperature resistance and a high chemical, moisture and UV-light resistance
- Good bonding to uneven surfaces
- Provides exceptional conformability
- Provides a balance between the requirements for conversion and liner removal at point of application



CONSTRUCTION

Liner: White glassine
Adhesive 1: Cross-linked acrylic adhesive
Carrier: Nonwoven
Adhesive 2: Cross-linked acrylic adhesive

Classification: Avery Dennison - Public

Adhesive Properties		Typical Values		
THICKNESS (ASTM D3652)		**US Mils**	**MM's**	**Micron's (µm)**
Liner		2.64	0.067	67
Carrier & Adhesive		4.72	0.120	120
Total Caliper		7.36	0.187	187
PEEL ADHESION (ASTM D3330) 180° (12") 300 mm / min @ Room Temp				
SUBSTRATE		**Lbf / in**	**US Oz / In**	**N / Meter**
Stainless Steel	20 min dwell	2.74	44	480
	24 hr dwell	3.03	48	530
Polycarbonate	20 min dwell	2.74	44	480
	24 hr dwell	2.97	48	520
Painted Steel	20 min dwell	2.00	32	350
	24 hr dwell	2.86	46	500
Rigid Polypropylene	20 min dwell	1.11	18	195
	24 hr dwell	1.20	19	210
LOOP TACK (ASTM D6195) (12") 300 mm / min @ Room Temp				
SUBSTRATE		**Lbf / in**	**US Oz / In**	**N / Meter**
Glass	Initial	2.6	41	450
STATIC SHEAR (ASTM D3654) 1"sq (6.25 cm^2) 1000 g @ Room Temp				
SUBSTRATE		**Min 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, 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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www.tapes.averydennison.com

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