

3M

Riveters Tape

685

Technical Data

June 2017

Product Description 3M™ Riveters Tape 685 is a zone-coated polyester film tape with a tack-free center “window” for use in holding rivets in place both prior to and during riveting.

Construction	Backing	Adhesive	Color	Standard Roll Length
	Polyester film	Rubber-strip coated along edges of tape only	Green adhesive, transparent film in uncoated center section	36 yards (32.9 m)

Typical Physical Properties and Performance Characteristics

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

		ASTM Test Method
Adhesion to Steel:	30 oz./in. width (33 N/100 mm) (on adhesive-coated areas)	D-3330
Tensile Strength:	19 lbs./in. width (330 N/100 mm)	D-3759
Backing Thickness:	1 mil (.025 mm)	D-3652
Total Thickness:	1.7 mils (.043 mm)	D-3652
Width:	1 in. (.25 mm) and 2 in. (50mm) with 1/4 in. (6.4 mm) adhesive strip on	

Features

- During riveting, helps ensure easy visibility of rivets and no adhesive transfer to rivet heads.
- Tough polyester film that resists shattering or slivering to help save time and increase output.
- Uncoated center “window” so it does not adhere to rivets in order to eliminate potential of adhesive transfer to rivet heads.
- Rubber adhesive for good immediate adhesion that resists stretching induced by bucking bar that might lead to film entrapment under rivet head for ease of application and to help reduce rework.

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Storage humidity. Store in a clean dry place at 60-80°F (15-27°C) and 40-50% relative humidity.

Shelf Life No longer than 18 months from date of manufacture.

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ISO 9001

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