

# 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)<br>(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<br>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.

# 3M™ Riveters Tape 685

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

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

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**ISO 9001**

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

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