



# Riveters Tape

## 685

### Technical Data

January, 1995

**Product Description** A zone-coated polyester film tape with a tack-free center “window” for use in holding aircraft rivets in place 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 yds. (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:	27 oz./in width (30 N/100mm) (on adhesive-coated areas)	<b>D-3330</b>
Tensile Strength:	16 lbs./in/ width (280N/100mm)	<b>D-3759</b>
Backing Thickness:	.9 mil (.023 mm)	<b>D-3652</b>
Total Thickness:	1.6 mils (.04 mm)	<b>D-3652</b>
Width:	3/4 in. (19 mm) with 3/16 in. (4.8 mm) adhesive strip on each edge 1 in. (.25 mm) with 1/4 in. (6.4 mm) adhesive strip on each edge	

### General Information

- Transparent tack-free center “window” helps ensure easy visibility of rivets and no adhesive transfer to rivet heads during riveting.
- Store in a clean dry place at 60-80°F (15-27°C) and 40-50% relative humidity no longer than 18 months from date of manufacture.

### Application Ideas

- Primarily to hold rivets in place riveting.

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Features	Advantages	Benefits
<ul style="list-style-type: none"><li>• Tough polyester film</li><li>• Uncoated center “window”</li><li>• Rubber adhesive</li></ul>	<ul style="list-style-type: none"><li>• Resists shattering or slivering</li><li>• Dose not adhere to rivets</li><li>• Good immediate adhesion</li><li>• Resists stretching induced by bucking bar that might lead to film entrapment under river head</li></ul>	<ul style="list-style-type: none"><li>• Helps save time Helps increase output</li><li>• Eliminates potential of adhesive transfer to river heads</li><li>• Ease of application</li><li>• Helps reduce rework</li></ul>

### For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-227-5085. Address correspondence to : 3M, Industrial Tape and Specialties Division, 3M Center, Building 220-8E-04, St. Paul, MN 55411-1000. Our fax number is 612-733-9175. in Canada, phone: 1-519-451-2500. in Puerto Rico, phone:1-809-750-3000. in Mexico. Phone: 5-728-0400.

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