

# 3M

# Riveters Tape

## 685

Technical Data

June, 2003

**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:	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	

### 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

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**Storage** 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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**For Additional Information**

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550 or visit [www.3M.com/industrialtape](http://www.3M.com/industrialtape). Address correspondence to: 3M Industrial Adhesives and Tapes Division, Building 21-1W-10, 900 Bush Avenue, St. Paul, MN 55144-1000. Our fax number is 651-778-4244. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

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**ISO 9002**

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

**3M**

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