



NORBOND® Polyurethane, Polyethylene or Acrylic Foam Tapes

The purpose of this application guide is to define the assembly and mounting techniques in order to prepare the surfaces and give the optimum adhesion of NORBOND® Bonding Tapes.

Surface Preparation

It is important that the **surface** to which the tape will be bonded is **free of dust, oil and other contaminants**. The surface should be dry when the tape is applied. A 50/50 alcohol and water solution is usually sufficient in removing most contamination. The cleaning cloth should routinely be replaced. If oil is present on the substrate, a stronger solvent may be necessary. An acetone (for most raw metals) or naphtha (for most painted surfaces) wipe should be able to remove most oils. A second wipe of 50/50 alcohol and water solution can be used after naphtha to remove film. Finish with a dry wipe to remove residue. **Please refer to the Safety Data Sheet (SDS)** of any cleaning solvents for proper use and procedures.

Adhesion Promoters

Adhesion promoters are primarily used when bonding to low surface energy materials that are hard to adhere to. Promoters can be applied per the manufacturer's instructions but must be dry before attachment tape is applied to the surface.

Temperature

The recommended typical application temperature is **60°F to 125°F (16°C to 52°C)***. Both the tape and substrate(s) that are being bonded should be above this minimum temperature. In general, higher applications temperatures increase adhesion build.

** Refer to individual data sheets for specific temperature range.*

Pressure

The tape should be applied using **roller weight** or other mechanism to initiate and provide intimate contact of the tape's adhesive surface to the substrate(s). A common recommended pressure is **15 PSI (100 kPa) minimum**. The application design also should provide the best possible surface match between substrates to maximize adhesive wet-out (contact to substrates).

Time

Upon application, the **adhesive bond builds with time**. After initial bonding, care should be taken not to expose the newly bonded joint to excessive stresses. Generally, 50-60% of ultimate bond strength is achieved in 20 minutes, 70-80% in 1 hour and 80-90% after 24 hours at 68°F (20°C). Full bond strength is normally achieved in 72 hours. **Exposure to elevated temperatures** will accelerate bond build. Heat guns or "hot boxes" are commonly used in fall or winter conditions.

These instructions are general recommendations. As Saint-Gobain cannot anticipate nor control every single application, it is highly recommended to test the product in case of specific needs, application or system.

Don't hesitate to contact Saint-Gobain for any additional information or questions.

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