

E500

OEM Automotive Grade, Bonding Tape

Saint-Gobain® Norbond® E500 Series Bonding Tapes are manufactured by **Saint-Gobain** Performance Plastics Corporation, Tape Solutions business, and made with durable black, closed-cell polyurethane foam carrying a high performance, acrylic adhesive system. The polyurethane foam carrier is specifically formulated to meet the most demanding exterior applications. Its energy-dissipating properties absorb vibrations and distribute stress over the entire bond line. The high performance adhesive system is designed especially for today's high solid and clear-coat paint finishes. **Norbond** E500 is resistant to oxidation, fungi and weathering, providing long performance life.

The E500 Series is specially intended to provide the following features:

- Stress distribution reduces pressure points, thereby minimizing distortion
- High-performance, durable acrylic adhesive provides a strong, long-lasting bond
- Conformable, closed-cell polyurethane foam facilitates die-cutting
- Prevents corrosion of dissimilar materials by eliminating the contact between them
- Standard polyethylene liner excels in automated production

Available Sizes

Standard thickness: .020, .03, .045, .062 and .090 in. (.5, .8, 1.1, 1.6 and 2.3 mm)

Master roll size: 56 in. (1422 mm) width. Slit rolls also available.

Standard roll length varies with thickness.



APPLICATIONS

- Rear deck spoilers
- Bumper trim and inserts
- Wheel well and door edge moldings
- Rocker panels
- Various ornamentation
- Body cladding
- Ground effects
- Air dams
- Pillar trim
- Reveal moldings

Norbond E500 Series — Properties

(Formerly known as Normount)

Performance tests are run using standard test procedures.

The values presented are typical values and should not be used for specification purposes.

OEM	Specification
FCA	MS.90152 (Type A, 1-A)

* Has been tested and shown to pass requirements of FMVSS 302

Norbond E500 — Standard Roll Sizes

Product No.	Thickness in. (mm)	Typical Value
E530	.032 (.8)	200 (61)
E545	.045 (1.1)	200 (61)
E562	.062 (1.6)	200 (61)
E590	.090 (2.3)	150 (48)

3" I.D. cardboard cores standard

Options (subject to minimum order requirements)

Liner: Powder-blue silicone release coated polyethylene liner is standard. Other liners, such as silicone coated polyester, may be available upon request with minimum order requirement.

Important Instructions

- Paint systems vary greatly, therefore, test **Norbond** E500 Series Bonding Tapes on the surface where they will be used. **Saint-Gobain** recommends testing all products under actual application conditions prior to commercial use.
- Surfaces must be clean and free of oil, grease, moisture, dust and dirt. Isopropyl alcohol is good for cleaning the surface.
- Apply a uniform pressure of 15 psi (103 kPa) to promote good contact between the material to be bonded and the tape. The application temperature should be between 60°F and 125°F (16°C to 52°C). It is not recommended to apply these tapes at temperatures below 60°F (16°C), as the adhesive does not flow in this condition and can result in poor bonding.
- Recommended service temperature is between -30°F to 200°F (-34°C to 93°C).
- The adhesion between the substrate and the tape increases with time, typically reaching final bond strength in 72 hours. Heating the product above 105°F (40°C) will accelerate the adhesion process.

Shelf Life

12 months after the date of sale when stored in original packaging at temperatures up to 70°F (21°C) and 50% relative humidity.



Need more adhesion? Stick with Saint-Gobain Norbond Adhesion Promoters.

Norbond Adhesion Promoters are designed to work in conjunction with acrylic, pressure-sensitive adhesive systems (such as those used on **Norbond** Tapes).

Norbond improves bonding on substrates that resist adhesion. It can be used to develop an immediate quick-stick and generally improves pressure-sensitive acrylic adhesive systems. This enhances adhesion to irregular and curved surfaces. Various formulations are available for specific substrates.



TAPE SOLUTIONS

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tapesolutions.saint-gobain.com

IMPORTANT: It is the user's responsibility to ensure the suitability and safety of Saint-Gobain products for all intended uses and that the materials to be used comply with all applicable regulatory requirements. Saint-Gobain assumes no responsibility for any product failures that occur due to your actions or inactions, including your use, design, fabrication or application of the products into which the materials are incorporated.

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