

Application Procedure for Norseal PVC

1. Clean the Surface

The presence of dust, chemicals, or oil will interfere with the bond strength of a pressure sensitive adhesive. It is important to remove contaminants for proper bonding to occur.

To clean oil or films from metal surfaces, solvents such as MEK, Naptha, or Acetone may be used. For painted finishes and most plastics, isopropyl alcohol or a 50/50 blend of alcohol and water may be used as a surface preparation.

2. Proper Application Temperature: 40 to 125°F (4 to 52°C)

When applying the sealant, we recommend that the temperature be between 40° and 125°F (4 - 52°C). Although all products are affected to some extent by temperature change, our primary concern is that at approximately 40°F (4°C) condensation begins to form on surfaces and increases as the temperature drops. The adhesive is resistant to moisture once in position, but cannot adhere through a film of water, which acts as a lubricant. If the surfaces are wiped dry, then successful use of the product at a lower temperature is possible.

3. Leave the Liner on the Foam

For accurate positioning and to prevent stretching of the foam during application, leave the paper liner on the product. As the roll is unwound, the adhesive surface will be exposed and allow direct placement. Once in place, the specially treated liner can be removed easily and thrown away.

4. Protect the Tape Prior to Compression

If the tape is pre-applied prior to compression or assembly of the parts, the tape must not be compressed during storage or packaging and it should be protected from dirt or dust. The pressure sensitive adhesive is intended to be a temporary placement for the gasket during the assembly process - if assembly is not to occur for several days to months, the gasket should be tested for adequate adhesion properties to the surface to ensure it will meet the criteria.

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5. Sealing Butt Joints

When sealing butt joints – there are 2 options for consideration:

- For **Norseal** PVC tape .032” – .062” (.8 – 1.6mm) thick, the tape can be over lapped and compressed.
- For **Norseal** PVC tape 3/32” – 3/4” (2.4 – 19mm) thick, it is recommended to butt the ends together and then “butter” the joint with a caulk. It is not recommended to over lap the tape due to the thick gauge and irregularities this may cause. The caulk needs to be compatible with both **Norseal** and the substrates that are in contact with it.

6. Compress the Tape Minimum of 30%

Norseal PVC foams are made in a variety of thicknesses, from 1/32” to 3/4” (.8 – 19mm), to provide the customer with the best material for the job. To create a seal which stops flanking of water or air, the foam must be held under compression. Ideally, it is reduced by 30% to 50% of its height. Over compressing the product should be avoided.

7. Fixed Assemblies verses Open & Closed

In general, **Norseal** PVC Tapes are recommended for fixed assemblies where the gasket is permanently compressed and not intended to be used for an open & closed joint. If a dust seal is needed in an open & closed joint – options to consider are:

- Polyester supported **Norseal** PVC foam, (PET will eliminate blocking, but you may sacrifice the sealing properties at the PET film interface).
- **Norseal** PUR or Silicone (ideally suited for open & closed applications).

Each option should be evaluated in the specific application for suitability.

8. Re-assembly of Joints or Parts

Norseal PVC Tapes are intended to be used for a single application where the joint is in a fixed assembly. If the joint needs to be separated for repairs and then re-assembled, it is recommended to remove the original Norseal foam tape and to apply a new foam tape seal. The above procedures (1 - 6) should be followed.

Please Note

Because **Saint-Gobain**® cannot anticipate or control every potential application, we strongly recommend testing this product under individual application conditions prior to use. The **Norseal** PVC product contains plasticizer, which may adversely affect some plastics.



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