SAINT-GOBAIN
PERFORMANCE PLASTICS

# Normount® Tape Application Recommendations

**Surface Preparation:**
It is important that the surface the tape is being bonded to 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 maybe necessary. An acetone (for most raw metals) or naphtha (for most painted surfaces) wipe would be able to remove most oils. A second wipe of 50/50 alcohol and water solution should be used after Naphtha to remove film. Finish with a dry wipe to remove residue. Please refer to the MSDS sheets of any cleaning solvents for proper use and procedures.

Abrading metal surfaces often increases adhesion by removing gloss layers and oxidation. Norton Bear-Tex 796, a very fine general-purpose abrasive pad, is usually sufficient to scuff the surface. Dust should be removed with a wipe of 50/50-alcohol and water solution followed by a dry wipe.

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

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

**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 (minimum). The application design should also 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 one hour and 80-90% after 24 hours (at 70° F). 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.

The above instructions are general guidelines. Because Saint-Gobain cannot anticipate or control every potential application, we recommend testing the product under individual application conditions prior to use. If you have any questions or comments please feel free to contact Saint-Gobain Technical Service at (518) 642-2200.