

Normount® V2800/V4600



NORMOUNT V2800 AND V4600 BONDING TAPES ARE IDEAL FOR EXTERIOR MOUNTING APPLICATIONS.

Ideal for Exterior Mounting Applications

Normount® V2800/V4600 closed-cell foam bonding tapes are highly conformable. The foam substrate allows energy and stress in the joint to be dissipated over the entire bond. With a high-performance acrylic adhesive on both sides, Normount® is an ideal choice for severe exterior bonding applications. The product is durable in all weather conditions, and provides resistance against UV light, extreme temperatures, fungi, oxidation and ozone. V2800 is a black foam with blue liner. V4600 has a red liner with a gray foam substrate.

Advantages of Using Normount

Reduces or eliminates the use of mechanical fasteners such as screws and rivets, liquid adhesives, welds and subsequent surface refinishing. Elimination of mechanical fasteners saves time, increases productivity, reduces costs and improves overall product appearance.

Dissipates Vibrations and Stresses

The foam properties of Normount dissipate vibrations and distribute stress over the entire bond line. Normount's adhesive further enhances its durability. It has been specially formulated to provide improved quick-stick and ultra-high bond strength.

Quick-Stick Speeds Installation

In a range of applications, including industrial bonding, construction bonding and transportation bonding, Normount speeds installation time and enhances user productivity with its "quick-stick" feature. Acrylic adhesive on both sides of the tape ensures maximum contact with the surface and a strong bond.

Compatible With Other Substances

Normount is compatible with most plastics and painted surfaces tested by Saint-Gobain Performance Plastics. Normount has no VOC (Volatile Organic Compound) emissions.

*Energy-Dissipating,
Closed-Cell Polyurethane
Foam Substrate with a
High-Performance Acrylic
Adhesive on Both Sides*

Features / Benefits

- Stress Distribution Reduces Pressure Points, Thereby Minimizing Distortion
- Standard Polyethylene Liner Excels in Automated Production
- High-Performance, Durable Acrylic Adhesive Provides a Strong, Long-Lasting Bond
- Conformable, Closed-Cell Polyurethane Foam Has Excellent Environmental Resistance
- Prevents Corrosion of Dissimilar Materials by Eliminating the Contact Between Them

Typical Applications Include the Attachment of:

- Emblems and Ornamentation
- Signs and Nameplates
- Window Muntin Bars
- Panel Stiffeners
- Trailer Roof Bows
- Weather Stripping
- Body Side Molding
- Composite Panels

Normount V2800/V4600 Standard Roll Sizes

Widths: 1/4" to 56" (6.35 mm to 1.4 m)	Color: V2800 Black, V4600 Gray	3" I.D. Cores
Product No.	Thickness, in. (mm)	Length, ft. (m)*
V2830/V4630	.030 (0.8)	200 (61)
V2845/V4645	.045 (1.2)	200 (61)
V2862	.062 (1.5)	200 (61)
V2890	.090 (2.3)	150 (45)
V28120	.120 (3.0)	50 (15)

Standard Liner: Powder-blue polyethylene liner is standard on V2800. Red polyethylene liner is standard on V4600. Other liners may be available with minimum order requirement, including a high density, silicone release coated version. This has high tear strength, is easy to remove and is good for die-cut parts. Contact Saint-Gobain Performance Plastics' Customer Service Department for further information.

*Non-standard roll lengths are available on special order.

Storage: Material should be stored at 70°F (21°C), 50% relative humidity.

Application Guide: Static weight loads should not exceed 0.5 psi (35 gms/cm²). Saint-Gobain Performance Plastics recommends testing all products under actual application conditions prior to commercial use. Do not use on fabric, coarse concrete, loose paint, rough wallpaper or similar surfaces.

For maximum adhesive performance, prepare the contact surface by removing dirt, wax, soap and oily films with a cleaning solvent. A typical cleaning solvent is a 50/50 isopropyl alcohol/water mixture. It may be necessary to seal and/or prime the contact surface. If added adhesion is desired, Saint-Gobain Performance Plastics recommends the use of Tite-R-Bond™ Adhesion Promoter.

The greater the adhesive-to-surface contact (known as wet-out), the better the adhesive bond strength. Apply the tape to the first surface with the liner on, then firmly press or roll. Remove the liner just prior to bonding surfaces together and apply firm pressure to ensure full contact.

Bond strength is dependent on the substrate surface, application temperature and dwell time. When possible, allow 24 hours dwell time at room temperature before loading.

Please Note: Because Saint-Gobain Performance Plastics cannot anticipate or control every potential application, we strongly recommend testing of this product under individual application conditions prior to commercial use.

Distributed By:

Saint-Gobain Performance Plastics

One Sealants Park
Granville, NY 12832
1-800-724-0883
(518) 642-2200
Fax: (518) 642-2793

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Typical Physical Properties

Property	Value	Test Method
Density: lbs./cu. ft. (kg/m ³)	30 (480)	ASTM D-1667
180° Peel Adhesion: oz./in.(N/m) 15 min. dwell to stainless steel	108 (1,181)	PSTC-3
Dynamic Shear Adhesion: psi (kPa) 72 hrs. dwell stainless steel to paint	120 (827)	NTP-5
Dynamic Tensile Adhesion: psi (kPa) 24 hrs. dwell aluminum to paint	100 (689)	NTP-11
Tensile Strength of Foam: psi (kPa)	130 (896)	ASTM D-412
Elongation of Foam: %	275	ASTM D-412
Water Absorption: % by weight	5	NTP-36
Recommended Service Temperature:	-40°F to 200°F (-40°C to 93°C)	
Recommended Application Temperature:	60°F to 125°F (16°C to 52°C)	

NTP is Norton Test Procedure. Parameter values are not guaranteed and will differ from lot to lot. For specification writing, contact Saint-Gobain Application Engineering Dept.



Need More Adhesion? Stick with Saint-Gobain Performance Plastics Tite-R- Bond™ Adhesion Promoters.

Tite-R-Bond adhesion promoters are designed to work in conjunction with acrylic, pressure-sensitive adhesive systems (such as those used on Normount® Acrylic bonding tapes).

Tite-R-Bond 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.



The Saint-Gobain Family of Norton® Bonding Tapes

Our select line of Normount® Acrylic high performance bonding tapes are available in a variety of adhesive and substrate combinations that efficiently match your assembly and bonding needs. Call Saint-

Gobain Performance Plastics or one of our authorized distributors to help you select the right tape for your application.

Tite-R-Bond™ is a trademark.
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