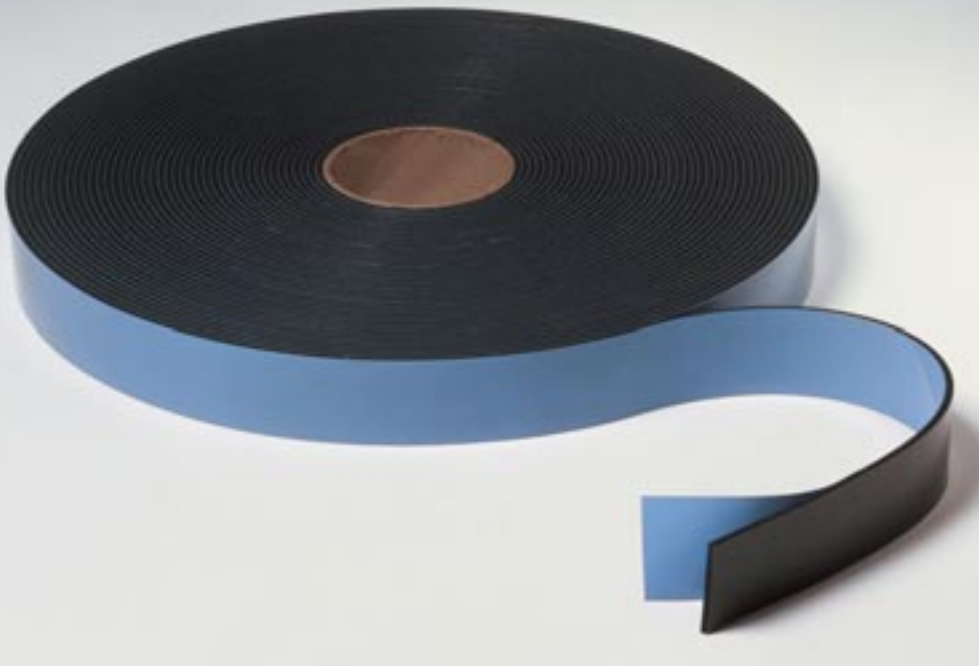


NORMOUNT® Z500



HIGH STRENGTH, ALL-WEATHER BONDING TAPE FOR A VARIETY OF AUTOMOTIVE APPLICATIONS

Normount® Z500 Closed-Cell Polyurethane Bonding Tape

Normount® Z500 series bonding tapes are made with durable, 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. Normount® Z500 is resistant to oxidation, fungi and weathering, providing long performance life.

Normount® Z500 Applications

Body Side Molding: Normount® Z500 series bonding tape is a proven performer around the world for attaching body side moldings. Typical thicknesses used are .045" (1.2mm) for thicker semi-rigid molding and .030" (.8mm) for thin flexible moldings. Recommended maximum weight design load is .85 oz./in² (3.7 gms/cm²).

Nameplates and Emblems: Normount® Z500 is easy to die-cut for emblems, logos and nameplates. It has superior cold shock/slam properties as compared to acrylic foam. Typical thicknesses used are .062" (1.6mm) for rigid emblems and .020" (.5mm) for thin, flexible or low profile emblems and nameplates.

OEM Automotive Grade Bonding Tape Designed Especially for Use With High-Solid and Clear-Coat Paint Finishes

Typical Applications

- Bumper Trim and Inserts
- Body Cladding
- Rear Deck Spoilers
- Various Ornamentation
- Wheel Well and Door Edge Moldings
- Rocker Panels
- Ground Effects
- Air Dams
- Pillar Trim
- Reveal Moldings



Normount® Z500 Standard Roll Sizes

- Widths: 1/4" to 56" (6.35mm to 1.4m)
- 3" ID cores
- Color: black
- Roll Length: 200 ft. (61m)*
- Roll Length Tolerance: ± 1%

Product Number	Thickness, in. (mm)	Tolerance
Z520	.020 (0.5)	± .004 in.
Z530	.032 (0.8)	± .006 in.
Z545	.045 (1.2)	± .005 in.
Z562	.062 (1.6)	± .010 in.

OEM	Specification#
Chrysler	MS-CH59 (Type B)
Ford	WSB-M3G89D
GM	GM-3802M (Type VI)

Liners: Polyethylene options include: silicone release coated (easy release), raw medium density (medium release), raw low density (high release) and silicone coated polyester. Minimum order requirements may apply for special liners. Saint-Gobain Performance Plastics application engineers can provide additional information.

Application Guide: Paint systems vary greatly, therefore, users should test Normount Z500 series bonding tapes on the surface where they will be used. Saint-Gobain Performance Plastics recommends testing all products under actual application conditions prior to commercial use.

For maximum adhesive performance, prepare the contact surface by removing dust, wax, soap, and oily films with a cleaning solution. A typical cleaning solvent is a 50/50 mixture of isopropyl alcohol and water. It may be necessary to prime the contact surface. If added adhesion is desired, Saint-Gobain Performance Plastics recommends use of Tite-R-Bond™ adhesion promoter (see below for more information).

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 rub down. Remove the liner just prior to bonding the 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: Saint-Gobain Performance Plastics cannot anticipate or control every potential application. We strongly recommend testing of this product under individual application conditions prior to use.

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

Tite-R-Bond™ Adhesion Promoters For Use With Pressure-Sensitive Acrylic Adhesives

Tite-R-Bond™ adhesion promoters are designed to work in conjunction with acrylic, pressure-sensitive adhesive systems. When used correctly, Tite-R-Bond™ becomes a thin film anchored to the surface of the material on which it is applied. The surface energy of this film is typically higher than the material to which the Tite-R-Bond™ is applied. The higher the surface energy level, the better the bond of the pressure-sensitive adhesive. Tite-R-Bond™ is compatible with Saint-Gobain Performance Plastics' full line of Normount® foam bonding tapes, which utilize an acrylic pressure-sensitive adhesive. There are four standard Tite-R-Bond™ formulations designed for various substrates. To select the proper one for your application, refer to the Tite-R-Bond™ Physical Properties chart below.



Tite-R-Bond™ Physical Properties

Formulation Number	Shelf Life (months from date of manufacture)	Recommended Substrate Material	Wet Coating Thickness (inches)
2287A	12	Rigid PVC, ABS Plastic, Polycarbonate, Rigid Polyurethane, Metals & Paints	0.001-0.008
2301A**	12	Rigid PVC, ABS Plastic, Polycarbonate, Rigid Polyurethane, Metals & Paints	0.001-0.008
2684A	6	Polyethylene, Polyolefin & Thermoplastic Elastomers	0.001-0.005
2933A	3	Polyethylene, Polyolefin, Thermoplastic Elastomers, Natural Rubbers & EPDM	0.001-0.005

** Tite-R-Bond™ 2301A includes a fluorescent dye for detection under a black light. Note that depending on the color of the substrate, a yellowish residue may be visible under normal light.

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

Tite-R-Bond™ Standard Sizes Available

Size	Amount
Pint*	1 case — consists of 24 pint containers
Gallon	1 case — consists of 4 one-gallon containers
5-Gallon	1 five-gallon container
55-Gallon	1 fifty-five gallon container

* Only formulation #2287A is available in pint containers

Tite-R-Bond™ is a trademark.
Normount® is a registered trademark.

Saint-Gobain Performance Plastics

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



Limited Warranty: For a period of 6 months from the date of first sale, Saint-Gobain Performance Plastics Corporation warrants this product(s) to be free from defects in manufacturing. Our only obligation will be to provide replacement product for any portion proving defective, or at our option, to refund the purchase price thereof. User assumes all other risks, if any, including the risk of injury, loss or damage, whether direct or consequential, arising out of the use, misuse, or inability to use this product(s). SAINT-GOBAIN PERFORMANCE PLASTICS DISCLAIMS ANY AND ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

NOTE: Saint-Gobain Performance Plastics Corporation does not assume any responsibility or liability for any advice furnished by it, or for the performance or results of any installation or use of the product(s) or of any final product into which the product(s) may be incorporated by the purchaser and/or user. The purchaser and/or user should perform its own tests to determine the suitability and fitness of the product(s) for the particular purpose desired in any given situation.