

# Norcryl™ A1000/A2000



Norcryl™ solid acrylic tape is available in clear and translucent for a clean appearance.

## A Very High Bond Acrylic Tape

The Norcryl™ solid acrylic core has outstanding internal strength. Norcryl structural grade bonding power can reduce or replace conventional fasteners, rivets, liquid adhesives and welds. Elimination of mechanical fasteners saves time, increases productivity, reduces costs and improves overall product appearance.

## Outstanding Weather Resistance

Norcryl is resistant to Ultraviolet radiation, high humidity and climate extremes. A 3-year aging study showed that its adhesion strength actually increases with time. Norcryl maintains a strong bond in high temperatures. Over time Norcryl will not harden or become brittle.

## Clean, Clear Appearance

Norcryl A-1000 series is water clear and virtually invisible after installation\*. Norcryl A-2000 series is translucent and blends in with background colors. This is ideal for applications in which the tape may be visible after installation. For example, when bonding together overlapping truck trailer side skins Norcryl provides a nearly seamless appearance.

## Reduces Localized Distortion

Conventional attachment methods cause localized distortions and stresses as the temperature fluctuates. An example of this includes dimples found on riveted trailer side skins. Norcryl tapes minimize these stress points by distributing stresses evenly across the entire tape contact area and compensating for thermal expansion. This provides a uniform appearance and improves fatigue resistance. Norcryl also acts as a joint seal, reduces noise, dampens vibrations and prevents galvanic corrosion when bonding dissimilar metals.

\* Slight discoloration may occur over time in some applications when exposed to UV light. Integrity of bond not effected.

*Solid Acrylic Bonding  
Tape Available in Clear  
or Translucent*

## Features / Benefits

- Solid Acrylic Core Provides a Very High Bond
- Outstanding Weather\* and Chemical Resistance
- Superior Moisture Resistance
- Available in Clear and Translucent Grades
- Thin Gauges for Low Profiled Applications

## Typical Applications Include Bonding of:

- Security Glass Lamination
- Muntin Bar Attachment
- Computer Security Devices
- Architectural/Industrial Signs
- Trailer Side Skin Bonding
- Cellular Phone Antennas

## Norcryl A1000/2000 Standard Roll Sizes

Widths: 1/4" to 18"      Color: A1000 Clear  
(6.35 mm to .46 m)      A2000 Translucent      3" I.D. Cores

Product No.	Thickness in. (mm)	Length ft. (m)*
A1010	.010 (0.3)	200 (61)
A1020	.020 (0.5)	200 (61)
A1040	.040 (1.0)	100 (30.5)
A2025	.025 (0.6)	200 (61)
A2045	.045 (1.1)	100 (30.5)
A2060	.060 (1.5)	100 (30.5)

**Standard Liner:** Powder-blue polyethylene liner is standard. Other liners may be available with minimum order requirement. Contact Customer Service 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 1.0 psi (70 gms/cm<sup>2</sup>). 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 rub down. 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. Elevated temperatures will accelerate bond strength and decrease dwell time required for optimum bond.

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

Norcryl™ and Tite-R-Bond™ are trademarks.  
Normount® is a registered trademark.



**PERFORMANCE PLASTICS**

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## Typical Physical Properties

Property	Test Method	Value or Rating	
		K1000	K2000
Peel Adhesion: lbs./in. (N/cm) 90° Peel, 1 hr. at 70°F 1 hr. at 158°F	NTP-9	18 (32) 30 (53)	18 (32) 30 (53)
Dynamic Shear Adhesion: psi (kPa)	ASTM D-3163	60 (410)	90 (620)
Static Shear Adhesion: (Holding Power) grams/in <sup>2</sup> @ 72°F (23°C) @ 250°F (121°C)	ASTM D-3654	1000 500	2000 500
Tensile Strength: psi (kPa)	ASTM D-412 Die C	120 (825)	250(1,725)
Elongation: %	ASTM D-412 Die C	900	600
Recommended Service Temperatures:	—	-30°F to 200°F (-34°C to 93°C)	
Minimum Recommended Application Temperatures:	—	60°F (16°C)	

Parameter values are not guaranteed and will differ from lot to lot. For specification writing, contact Technical Service Department.



### Need More Adhesion? Stick with Saint-Gobain 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® and Norcryl™ mounting 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 Bonding Tapes

Our select line of Normount and Norcryl high performance bonding tapes are available in a variety of adhesive and foam carrier combinations that efficiently match your assembly and mounting needs.

Call us or your authorized Saint-Gobain distributor to help you select the right tape for your application.

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