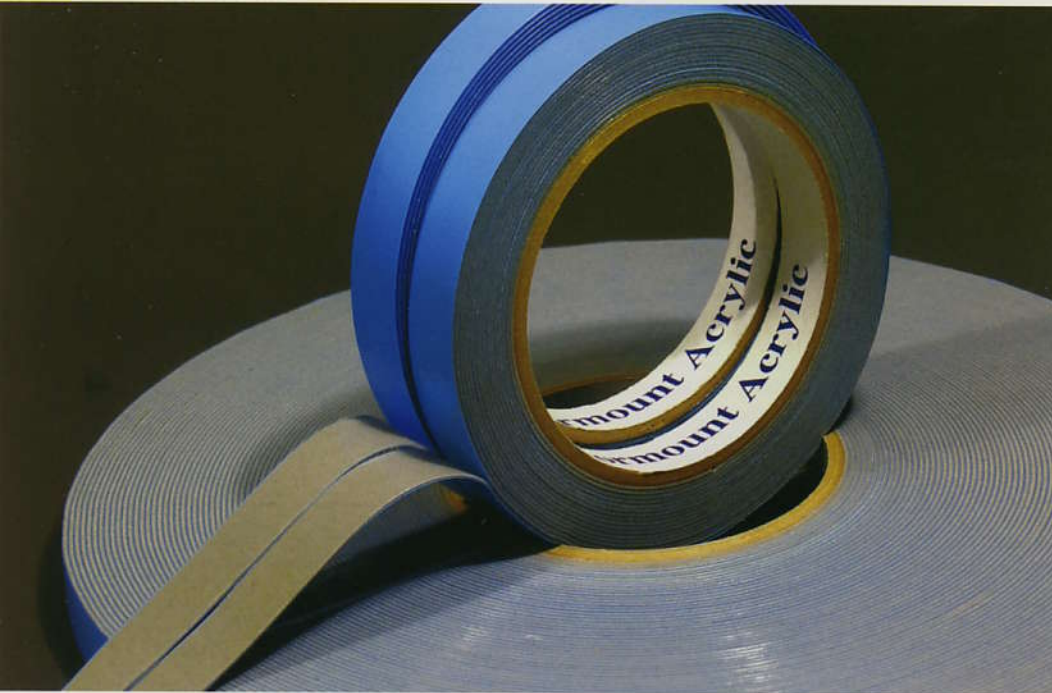


NORMOUNT® Acrylic A3300 Series



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Aggressive Adhesive System

NORMOUNT® Acrylic A3300 Series incorporates a unique adhesive system that provides fast adhesive strength build, high ultimate adhesive levels and long-term performance. Additionally, the A3300 Series is designed to bond to a wide range of substrates, including the new low-surface-energy paint systems. With an all-acrylic construction, NORMOUNT® Acrylic is compatible with most plastics and painted surfaces and has excellent weathering properties.

Viscoelastic Acrylic Core

The acrylic core of the A3300 Series is engineered to absorb the stresses of normal joint movement, providing for enhanced adhesion performance. Unlike mechanical fasteners that concentrate the joint stress in one location, NORMOUNT® Acrylic will distribute stress throughout the entire bond area. This results in higher bond strength, especially in joints of high movement (e.g. truck side panels) and different thermal expansion and contraction (dissimilar substrates).

Features and Benefits

- Excellent initial tack and quick adhesion build for easy application.
- Easy release polyethylene liner facilitates liner removal.
- Unique foam construction distributes joint stress across bond area.
- Specially formulated adhesive system for low-surface-energy substrates.
- Acrylic foam core incorporates high stress relaxation property to enhance dynamic bond strength.

Enhanced Performance Adhesive Gray Acrylic Tape

Unique Attributes

- Enhanced adhesive for bonding to low-surface-energy substrates
- Gray color
- Gauges from 0.4 to 1.5mm
- High tack
- Easy release liner

Typical Applications

- Bus, truck and trailer skin bonding
- Body side molding
- Architectural composite panels
- Automotive aftermarket trims
- Exterior building cladding
- Decorative fascia attachment



NORMOUNT® Acrylic A3300 Series Standard Configurations

Product No.	Color	Thickness in. (mm)	Width in. (mm)	Length ft. (m)
A3304GB	Gray	0.016 (0.4)	17 (450)	108 (33)
A3308GB	Gray	0.031 (0.8)	35 (900)	108 (33)
A3311GB	Gray	0.045 (1.1)	35 (900)	108 (33)
A3315GB	Gray	0.060 (1.5)	17 (450)	108 (33)

Standard Liner: Light blue polyethylene liner is standard on the NORMOUNT® Acrylic Series. Other liners may be available with a minimum order requirement and upcharge. Contact your Saint-Gobain representative for further information.

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

Application Guide: Static weight loads should not exceed 1.0 psi. 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.

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.

NORMOUNT® and NORTON® are registered trademarks.
Tite-R-Bond™ is a trademark.



Saint-Gobain Performance Plastics

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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.

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SPE-5073-5M-0506-SGCS

Typical Physical Properties

Property	Test Method	Value or Rating A3300
90% Peel Adhesion: oz./in. (N/m) 15 min. paint (clear coat) 72 hrs. paint (clear coat) 72 hrs. stainless steel	NTP-9	224 (2478) 320 (3540) 384 (4248)
Dynamic Shear Adhesion: psi (kPa) 24 hrs. al/paint	ASTM D-3163	60 (413)
Static Shear Adhesion: (Holding Power) 1,000 grams/in ² @ 72°F (22°C) @ 158°F (70°C)	ASTM D-3654	Pass Pass
Recommended Service Temperatures:	—	-30°F to 200°F (-35°C to 90°C)
Minimum Recommended Application Temperatures:	—	60°F (15°C)
Temperature Tolerance: (Short Term)	—	300°F (150°C)

NTP is Norton® Test Procedure. Parameter values are not guaranteed and will differ from lot to lot. For specification writing, contact our 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® 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® high performance bonding tapes is 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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