



Blue liner

Acrylic adhesive for superior adhesion

Grey acrylic foam core

# A7600 SERIES

## Grey, Double-Sided, Acrylic Foam Tape

**Saint-Gobain® Norbond®** A7600 Series is manufactured by **Saint-Gobain** Performance Plastics Corporation, Tape Solutions business, and comes with a high performance, double-sided acrylic foam tape with outstanding viscoelastic and adhesion properties. It offers ideal bonding performance for many interior and exterior industrial applications. Formulated for durable, long-lasting adhesion, A7600 exceeds industry standards for shear strength and bonding to high surface energy substrates, even at elevated temperatures.

A7600 is specifically intended to provide the following features:

- Enhanced short-term adhesion performance to help aid in field assembly
- Great conformability and resistance to dynamic stress loads
- Excellent performance in peel, tensile, and dynamic shear adhesion
- Durable adhesion at elevated temperature
- Shock and stress absorption

### Available Sizes

Standard thickness: 1.1 mm (.043 in.) and 1.6mm (.063 in.)

Master roll size: 800 mm (31.5 in.) × 33m (108 ft)

Jumbo roll size: 800 mm (31.5 in.) × 300m (984 ft)



## APPLICATIONS

- Bus, truck and trailer skin bonding
- Bus, truck and trailer roof bow bonding
- Replacement of permanent fastening systems (rivets, welds and liquid adhesives) used in general industrial applications
- Paint bake cycle applications requiring short-term, high temperature resistance

Norbond A7600 – Properties

Performance tests are run using standard test procedures. The values presented are typical values and should not be used for specification purposes.



90° Peel Adhesion <sup>1</sup>		T-Block <sup>2</sup>	Dynamic Shear <sup>3</sup>	Static Shear <sup>4</sup>	Service Temperature
20 minute dwell	3-day dwell				
Stainless Steel	Stainless Steel	Aluminum	Stainless Steel	Stainless Steel	
N/cm (lb/in)	N/cm (lb/in)	N/cm <sup>2</sup> (lb/in <sup>2</sup> )	N/cm <sup>2</sup> (lb/in <sup>2</sup> )	7 days/1 kg	
34 (19)	39 (22)	57 (83)	54 (79)	Pass and Exceeds	

<sup>1</sup> Based on ASTM D3330

<sup>2</sup> Based on ASTM D897

<sup>3</sup> Based on ASTM D1002

<sup>4</sup> Based on ASTM D3654

Test data shown is typical for 1.1mm thickness.

Options (subject to minimum order requirements)

Liner: Available on coated release liner, with low liner release values for quick and seamless removal.

Important Instructions

- 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.
- Surfaces must be clean and free of oil, grease, moisture, dust and dirt. Isopropyl alcohol is good for cleaning the surface.
- Apply a uniform pressure of 103 kPa (15 psi) to promote good contact between the material to be bonded and the tape. The application temperature should be between 16°C to 52°C (60°F and 125°F). It is not recommended to apply these tapes at temperatures below 16°C (60°F), as the adhesive does not flow in this condition and can result in poor bonding.
- The adhesion between the substrate and the tape increases with time, typically reaching final bond strength in 72 hours. Heating the product above 40°C (105°F) will accelerate the adhesion process.

Shelf Life

12 months after the date of sale when stored in original packaging at temperatures up to 21°C (70°F) and 50% relative humidity.

**IMPORTANT:** It is the user’s responsibility to ensure the suitability and safety of Saint-Gobain products for all intended uses and that the materials to be used comply with all applicable regulatory requirements. Saint-Gobain assumes no responsibility for any product failures that occur due to your actions or inactions, including your use, design, fabrication or application of the products into which the materials are incorporated.

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