

Acrylic adhesive  
Acrylic foam core  
Easy release Liner

# NORBOND

## A7711

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### Black, Double-Sided, Acrylic Foam Tape for Automotive

Saint-Gobain NORBOND® A7711 series is a high performance black, double-sided, acrylic coated foam tape with outstanding viscoelastic, conformability and adhesion properties. A7711 is characterized by short-term adhesion build and excellent adhesion to automotive paint systems as well as Medium Surface Energy (MSE) plastics such as ABS and ASA.

NORBOND® A7711 is specially designed to provide the following features:

- Engineered foam core for durable stress resistance
- Resistance to weathering degradation (UV and high temperature)
- Enhanced short-term adhesion build
- Excellent adhesion on a variety of automotive paint systems
- Durable performance at elevated temperature
- Shock and stress absorption
- High conformability

#### Available sizes:

- Standard thickness: 1.1mm
- Master roll size: 800mm x 33m, 66m



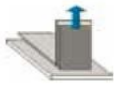
#### Typical Applications:

- Automotive aftermarket



## NORBOND® A7711 Test Data:

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



Thickness without liner	90° Peel Adhesion <sup>1</sup> Automotive Painted Panel			90° Peel Adhesion <sup>1</sup> ABS	90° Peel Adhesion <sup>1</sup> Stainless Steel	Static Shear <sup>2</sup>	Service Temperature	Weathering and UV resistance	
	20 min. Dwell	72 hour Dwell	Accelerated Aging	72 hour Dwell	72 hour Dwell	Painted Panel (80°C)			
	mm	N/cm	N/cm	N/cm	N/cm	7 days/500g			
A7711	1.1	29.48	33.97	82.01	48.61	39.57	Pass and exceeds	(- 35°C a 93°C)	High

Note: The values are averages from actual test data done on limited samples of material and results may vary. Saint-Gobain materials were chosen randomly from commercial stock. All testing was done at room temperature unless noted using the same method for all conditions.

1. Based on ISO8510-1

2. 7 Day Duration (minimum). Samples 25mm x 25mm.

### 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 15 psi (103 kPa) 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);
- 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

24 months from date of sale when stored in original packaging at 21°C (70°F) and 50% relative humidity

NORBOND® is a trademark of Saint-Gobain Performance Plastics.



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specialty tapes

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Limited warranty: For a period of 6 months from the date of first sale, Saint-Gobain Performance Plastics 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).

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