

Resin filled
laminated Glass
Bonding

NORMOUNT[®]
Acrylic Tape

NORMOUNT® Acrylic A6200 Series

Clear acrylic tape for perimeter bonding in manufacturing of resin filled laminated glass

Application :

Laminated, or security, glass can be produced by one of two methods. The traditional method uses a polyvinyl butyral (PVB) film that is bonded between two layers of glass. PVB, a tough resilient material, normally 0.38mm thick is interlaid between the glass and permanently bonded using high temperatures and pressure (autoclave process). A disadvantage of this system is the high initial cost for the manufacturing equipment and the constraints for different thicknesses and “glass” types.

The preferred alternative is the resin filled process, injecting a liquid polymer resin between the glass sheets and curing with UV lights (or catalysts, depending on resin formulation). The resin filled process involves minimum initial capital investment, and is a relatively easy, flexible manufacturing process. This resin method allows



NORMOUNT® A6200 Series

variation of the resin thickness as well as potential combinations of glass and plastic to create custom engineered configurations. The flexibility of the resin filled process lends itself to the increasing safety and security requirements for commercial buildings and residential homes throughout the world.

NORMOUNT® Acrylic A6200 Series is a clear solid acrylic tape designed to be placed around the glass perimeter to secure the glass in position, and create the seal prior to the liquid resin injection. The tape is not adversely affected by the resin curing process



Tape Application



Resin Injection

and prevents resin leaks when properly installed. Once cured the clear tape is virtually invisible and often eliminates edge trimming to reduce waste and improve manufacturing efficiency

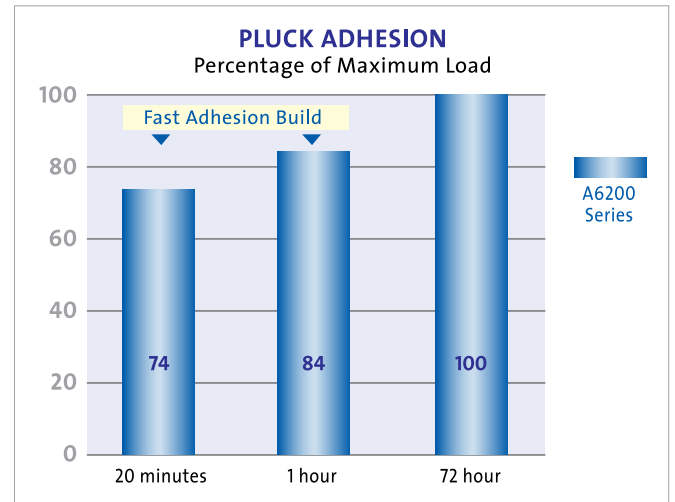
Application Techniques :

1. Pressure sensitive adhesives require clean surfaces for bonding. Ensure all surfaces are free of dirt and contaminants. Since the glass units are typically coming from a commercial washer just before resin injection an additional cleaning wipe is not normally required.
2. Use an edge guide, like our HA-10 Hand Applicator, to align the tape along the edge of the glass perimeter. Apply firm pressure, making sure the adhesive makes good contact with the glass.
3. Carefully align the second lite of glass in position and remove the liner just prior to bonding. Apply firm pressure along the perimeter to get a leak proof bond prior to resin injection.
4. Depending on the resin injection system, it may be advantageous to leave the liner on in one section to provide access. Other techniques leave a gap between the tape ends that is plugged late with a wet caulk.
5. Insure all liners are removed prior to the resin curing process.

Contact your local Saint-Gobain representative for additional application techniques.

Performance Data :

The NORMOUNT® Adhesive A6200 has been designed for optimum performance when used as a perimeter bond in resin filled laminated glass. Once in place and after the resin is cured it sees no significant stress forces. However, until the resin is cured it is important for the glass surfaces to remain firmly bonded. One method to test this attribute is a Pluck test, which measures the force to remove the tape in a perpendicular direction from the surface. As the chart shows, the A6200 Series exhibits superior pluck performance when tested off a glass surface with only 20 minutes dwell time.



Features and Benefits :

Closed Cell Structure Eliminates Leaks

100% acrylic mass, the closed cell structure of the A6200 Series insures resin containment before curing. In addition, the conformable tape surface makes intimate contact with the glass so no resin can creep under the tape edge.

Solid Core Prevent Bubble Formation

Unlike foam tapes A6200's solid core will not trap air that can form perimeter bubbles as the resins shrink during the curing process. This results in fewer visual defects and reduces manufacturing costs.

Transparent Tape Expands Vision Area of Glass

The water like clarity of the A6200 series increases the visual footprint and can eliminate the need to trim the glass perimeter to remove the unsightly tape area. This can expand the functional size for non-aesthetically critical unit, reducing costs.

Easy Release Liner – Easy Removal Without Breaking

By using a release coated, high density polyethylene liner, you can leave the liner in place until the final step in your process. Often a small section of liner is left in place to facilitate the resin injection. By leaving a small tab exposed you can easily remove the liner without concern of tearing or breaking.



PERFORMANCE PLASTICS

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