

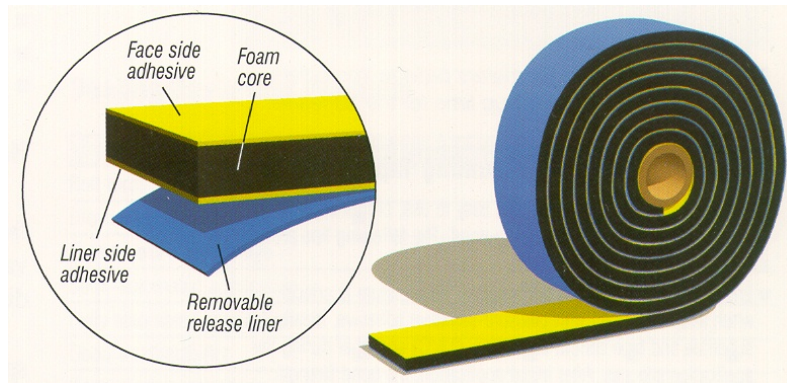
NORFIX[®] Mirror Mounting Application Guide

Norfix[®] Mirror mounting tapes are double sided white closed cell cross linked polyethylene foam with Pressure Sensitive adhesives on both surfaces, protected by a siliconised paper liner.

The rubber adhesives combine excellent tack and load bearing at normal temperatures. These products are designed for interior applications where the bond is not exposed to severe U.V. radiation. V1500 and V1550 products exhibit high bond strength and peel performance to various substrates such as plastics including polycarbonate, PVC, PE, PS, glass, wood, metals etc. (FIRA Approved)

The acrylic adhesive has been developed for high shear applications requiring excellent resistance to UV and elevated temperatures. The high tack of the V1600 adhesive allows an excellent bond to build between the two substrates, reaching its maximum strength in approximately 24 hours.

The PE foam is available in a wide range of thickness and density variations in order to offer conformable products suitable for uneven, irregular or contoured materials. The typical thickness grades are 0.8mm, 1.0mm and 1.5mm with widths of 19mm and 25mm.



Typical Properties

	V1500 and V1550 rubber adhesives			V1600 acrylic adhesive		
	0.8mm	1.0mm	1.5mm	0.8mm	1.0mm	1.5mm
180° Peel adhesion from stainless steel	>10 N/cm	>7 N/cm	>9 N/cm	>8 N/cm	>7 N/cm	>8 N/cm
Static shear strength	Minimum 500 hours with 5Kg on 625mm ² at 23°C			Minimum 100 hours with 2Kg on 625mm ² at 23°C		
Service Temperature	-40°C to +50°C			-40°C to +80°C		
Water absorption	Maximum 1%			Maximum 1%		

The details contained within this leaflet were correct and up-to-date at the time of printing and are intended to provide information of our products and their possible applications. This is not intended as a specification and does not assure specific product characteristics or make reference to the suitability of the products for a definite application. Saint-Gobain cannot anticipate or control every application, therefore, we strongly recommend testing of this product under individual conditions. 04/2003

Application and Assembly

To promote an adequate bond, the two surfaces must be smooth, dry and free from dust or grease. All surfaces should have a solid construction in order to bear the weight of the mirror, thicker Norfix grades will accommodate any minor surface irregularities. The adhesive is pressure sensitive, we therefore recommend the application to be carried out at a minimum of 15°C with as high a pressure as the process allows. With non polar materials like PP or PE, it is often necessary to prime the surface or to use a Corona Pre-Treatment. Additional details are available on request.

To ensure the shear strength is evenly distributed, the pads must be applied at the four corners or along the vertical edges of the mirror. This method of bonding avoids undesirable cleavage stress but inclined or overhead mirrors should be secured additionally by mechanical fastening methods.

The tables below show the total length of tape required to permanently bond the mirrors into place. The recommended coverage has been calculated based on a recommendation by BS 7449, 1991 and on investigations carried out on our behalf.

Area of Mirror (cm ²)	Minimum Length of V1500 and V1550 tape (cm)							
	19mm *		25mm *		19mm *		25mm *	
250	4	3	5	4	8	6		
500	8	6	10	8	16	12		
750	12	9	16	12	23	18		
1000	16	12	21	16	31	24		
1500	23	18	31	24	46	35		
2000	31	24	41	31	62	47		
3000	46	35	62	47	93	71		
4000	62	47	83	63	124	94		
5000	77	59	103	78	155	118		
6000	93	71	124	94	186	141		
7000	108	82	144	110	217	165		
8000	124	94	165	125	248	188		
9000	139	106	186	141	279	212		
10000	155	118	206	157	310	235		

Area of Mirror (cm ²)	Minimum Length of V1600 tape (cm)							
	19mm *		25mm *		19mm *		25mm *	
250	5	4	6	5	10	8		
500	10	8	13	10	20	15		
750	15	11	20	15	29	23		
1000	20	15	26	20	39	30		
1500	29	23	39	30	58	44		
2000	39	30	51	39	78	59		
3000	58	44	78	59	116	89		
4000	79	59	104	79	155	118		
5000	96	74	129	97	194	148		
6000	116	89	155	118	233	176		
7000	135	103	180	138	271	206		
8000	155	118	206	156	310	235		
9000	174	133	233	176	349	265		
10000	194	148	258	196	388	294		

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