

TECHNICAL DATA SHEET

HOTBOND TAPE

Tape of uncured rubber for making vulcanized Hotbond seams.



Technical data

Base:	Unvulcanized rubber
Colour:	Black
Shelf life:	4 months in a well ventilated and dry storage place at temperatures in between +5°C and 30°C.

Packaging

Product	Thickness (mm)	Width (mm)	Length (m)	Package (rolls/box)
EPDM tape	0.7 / 1.0	25	30	32
Butyl tape	0.7 / 1.0	25	25	13

Other dimensions available on demand.

Note

Both Hotbond tape EPDM and Hotbond tape Butyl are compatible with EPDM membranes.

On Butyl membranes only Butyl tape is allowed.

The main difference between the two versions "EPDM/Butyl" is that EPDM tape is stronger but less sticky.

Direction for use

Press settings to reach a seam with shear strength of >5 N/mm and peel strength >2 N/mm are shown in the table below.

Pressure: 5-8 kPa/cm²

Membrane thickness (mm)	EPDM tape		Butyl tape	
	Pressure temperature: 170-200 °C		Pressure temperature: 170-200 °C	
	Pressure time (s)		Pressure time (s)	
	Factory	Site	Factory	Site
0.75	80	105	50	70
1.0	100	120	60	80
1.2	105	135	65	90
1.5	115	150	70	100
2.0	180	220	120	150

This table is an indication of machine settings. A test has to be performed for each machine and location needs to be tested to reach and optimize the results.

Disclaimer

Information contained in this data sheet is up-to-date and correct as at the time of issue. For latest version please always check www.sealeco.com.