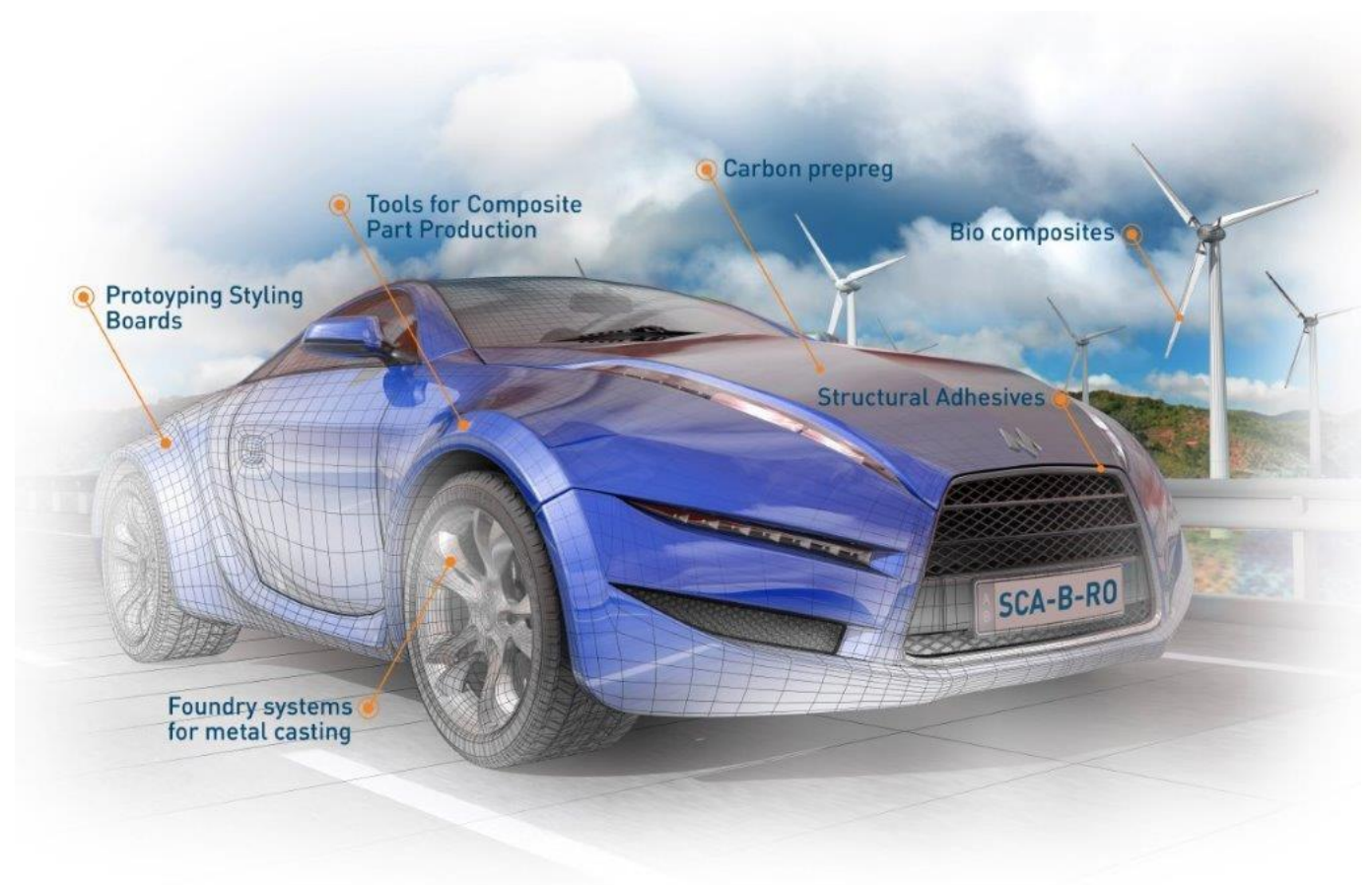


# TECHNICAL DATASHEET

## Tacky Tape<sup>®</sup> SM5160



MALLENBOUW | COMPOSITEN | LIJMEN



# SM5160

## ULTRA HIGH TEMPERATURE VACUUM BAG SEALANT TAPE

### TECHNICAL DATA SHEET

#### PRODUCT DESCRIPTION:

Tacky Tape® SM5160 is an advanced process vacuum bag tape sealant that was developed to fulfill the stringent requirements of very high temperature cure requirements. This dark brown colored tape sealant is formulated with a unique base polymer to function throughout a temperature range of 375°F (191°C) to 750°F (399°C). Extended cure cycles of twelve (12) hours or longer at intermediate temperatures of 400°F (204°C) to 600°F (315°C) are possible.

#### ADVANTAGES:

- Easy to apply by hand (User friendly)
- Ideal for oven or autoclave cure
- 375°F (191°C) to 750°F (399°C) cure cycles
- Tenacious adhesion to polyimide films and tool surfaces
- Strips clean from tools surfaces
- Non-Hazardous and thermally stable

#### APPLICATION:

Apply by hand to a clean dry tool or platen with release paper on top. When the sealant is in position remove the release paper and lay the film on top. Apply pressure by hand or roller on the sealant to obtain maximum adhesion and to ensure positive vacuum. A hot roller or iron (not to exceed 400°F [204°C]) can be used to apply pressure on the sealant. It is recommended to strip below 150°F (66°C) to minimize or reduce the parts from becoming warped. SM5160 can be stripped without leaving a residue on metal tool surfaces that have been cooled to room temperature.

#### PACKAGING:

Tacky Tape® SM5160 sealant is supplied in roll form with a special release paper. The standard size is ¾" x ½" x 30', other sizes will be considered on request. This product is available through ITW Polymers Sealants North America, Inc. Customer Service department at 1-800-878-7876.

#### PERFORMANCE TEMPERATURE RANGE:

Application Temperature Range: 45°F (7°C) to 120°F (49°C)  
Service Temperature Range: 350°F (177°C) to 750°F (399°C)

#### TYPICAL PROPERTIES:

COLOR:	Dark Brown
PERCENT SOLID:	100%
CONSISTENCY: Cone Penetration	90 - 140 150 GRAM LOAD ASTM D-217
WEIGHT/GALLON:	9.0 - 9.5 LBS/GALLON
FREIGHT CLASSIFICATION:	Caulking Compound, NOIBN (NO LABEL REQUIRED)
STORAGE:	Keep in cool dry place. Tacky Tape® SM5160 has a 12 month shelf life from date of manufacture when stored at or between 80°F (27°C) and 0°F (-17.8°C). Note: Material must be at room temperature for application. Do not store cartons on end, keep flat.

#### EXCLUSION OF WARRANTIES:

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Complete technical information is available from  
ITW Polymers Sealants North America, Inc.

ITW POLYMERS SEALANTS NORTH AMERICA, INC.

111 S. Nursery Road, Irving, TX 75060  
Tel: 972-438-9111 Fax: 972-554-3939 [www.itwsealants.com](http://www.itwsealants.com)

5/20/16