

PRODUCT TECHNICAL DATA SHEET

VACCUM-TAPE YELLOW COLOUR (Tacky Tape) 12mm X 3mm

PRODUCT DESCRIPTION

ORPL VACUUM-TAPE (Tacky Tape) is a sealant tape developed for use in vacuum bagging of composite parts. It is compatible with most bagging films and it is best choice for use on composites tools. It will maintain an airtight seal during the cure cycle, and then strip off clean from the mold during de-bagging. It performs in both oven and autoclave applications by tenaciously adhering nylon films to the tool surfaces.

ADVANTAGES:

- Easy to apply by hand
- Ideal for oven or autoclave cure
- Up to 210°C cure cycles
- Max temp limit 250°C for 10 mints.
- Strips Clean from tool surfaces
- Good adhesion to various films and tool surfaces
- Non-Hazardous (User friendly) and Thermally Stable

TYPICAL PROPERTIES:

PROPERTIES	UNIT	SPECIFICATION	TEST METHOD
Appearance	-	Roll form	--
Color	-	Yellow	--
Specific gravity at RT	g/cc	1.30 ± 0.15	ASTM D 297
Needle penetration with 50g Weight at RT	U/10 Sec.	70-110	ASTM D 5
Cone penetration with 100g Weight at RT	U/10 Sec.	50-90	ASTM D 217
Peel strength	Kg/cm ²	Min 3.50	ASTM D 1000
Shear strength	Kg/cm ²	Min 5.00	ASTM D 1002
Tensile strength	Kg/cm ²	Min 1.0	ASTM D 412
Elongation	%	Min 600	ASTM D 412
Corrosion	-	No corrosion	ASTM-D-2671

OSAKA RUBBER PVT. LTD.

6/106, Mittal Indl Estate, Andheri- Kurla Road, Andheri (East), Mumbai – 400 059
 Tel: 91-22- 4204 4204 Email: sales@osakarubber.com Web: www.osakarubber.com

Flexibility at low temperature	--	No change in dimensions No loss admission at -30°C	ASTM D765
Solid content	%	Min 99	99.99
Weather ability	-	No changes in the surface like crack or crazing	ASTM D 750

STORAGE:

Keep in cool dry place ORPL vacuum Tape has a 12-month shelf life from date of manufacture when stored at or below (25°C). Store cartons as per instruction on cartons.

PERFORMANCE TEMPERATURE RANGE:

Application Temperature Range: (5°C) to (45°C)

Service Temperature Range: (90°C) to (210°C)

Maximum Temperature Range:(250°C for 10 Minutes)

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. It is recommended to strip off below (40°C) to minimize or reduce the parts from becoming warped. ORPL Vacuum Tape can be stripped off without leaving a residue on metal tool surfaces that have been cooled to room temperature.

PACKAGING:

ORPL Vacuum Tape is supplied in roll form with a special release paper. This product is available through OSAKA RUBBER (P) LTD.

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