

PRODUCT DATA SHEET
RUBBERALL® SEAM TAPE



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Description: RUBBERALL® Seam Tape is a black, tacky, extruded butyl based pressure sensitive product in tape form developed for splicing sheets of EPDM membrane panels and flashing together. It offers uniform adhesive thickness and is manufactured using a tape release paper for application ease. It has been formulated to provide high initial strength in both sheer and peel. It is unaffected by heat or cold and because it is easily applied, offers significant labor savings. May also be used for joining pond liners.

Suggested Uses: RUBBERALL® Seam Tape is specifically developed for use with EPDM membrane roofing. Seam Tape is used in conjunction with seam tape primer to fuse EPDM membranes together in the field for long-term splice strength.

Sizes: RUBBERALL® Seam Tape is produced with a nominal thickness of 0.035” +/- .005”
Rolls sizes available - 3” x 25’ ; 3” x 100’ ; 4” x100’ ; 6” x 100’

General: This product usually has increased adhesion values when aged. Elevated temperatures usually encountered in single ply roof installations will cause the product to cure tighter; therefore, developing the increased test values. Due to the cross-linking that occurs during extrusion and thereafter; the product has excellent elevated temperature resistance.

Product Benefits:

- Labor Savings Cured Product - 12 month shelf life
- Superior performance over full range of environmental conditions
- Quick tack from high to low temperatures

Physical Properties

| Property Type | Test Method | Specification | Test Results |
|------------------|-------------|-------------------------|-----------------|
| Shear strength | ASTM D 816 | 15 lb. PSI min. (1) | ≥ Specification |
| Peel Strength | ASTM D 413 | 3 PLI min. (1) | ≥ Specification |
| Tensile Strength | ASTM D 412 | 50 PSI min. | ≥ Specification |
| Elongation | ASTM D 412 | 500 % min. (2) | ≥ Specification |
| Penetration | ASTM D 217 | 40 - 120 MM (3) | ≥ Specification |
| Flash Point | ASTM D 92 | 350° F min. | ≥ Specification |
| Low Temperature | ASTM D 746 | Minus 49° F flexibility | ≥ Specification |

- (1) Testing done with primer applied to both sides of EPDM membrane; cleaned with Membrane Cleaner. Samples aged for 24 hours @ 70° C prior to testing. Instron speed 2” min.
(2) Specimen cut with an ASTM die C or died. Sample pulled at 10”/ min and aged at 70° C for 72 hours.
(3) 300 gram cone load used.

Application Instructions:

1. Remove dirt and excess dust from the splice area by wiping with a clean rag. If there is a heavy layer of dirt present, clean the area thoroughly with Membrane Cleaner. This process is essential on membrane that has been exposed for a number of weeks.
2. Mark the bottom sheet with a crayon at the edge of the top sheet along the entire splice length as a guide.
3. Apply Tape Primer using Scrub Pads. Scrub the area of the membrane to be flashed or mated in a circular motion to achieve a thin even coating. The properly primed area will be uniform in color without streaks and free of globs or puddles.
4. The entire surface where the tape will be applied must be cleaned and primed. The adhesive will not adhere to dusty/dirty surfaces. Any residual surface contamination will be detrimental to the bond strength of the adhesive.
5. Allow the Tape Primer to dry until it does not transfer to a dry finger touch.
6. Install Seam Tape immediately after the primer flashes off to minimize potential dust contamination.
7. Unroll approximately 3' of Seam Tape. Align the tape with the marked line and press tape down to bottom sheet using firm even hand pressure. Continue for the length of the splice. Tape roll ends should be overlapped 1". Allow top sheet to rest on poly backing after application. A minimum of 1/8" of tape must extend beyond the splice edge. A continuous piece of Seam Tape must be used at all field and factory splice intersection.
8. Rolling the Seam Tape with a steel hand roller after application to the primed substrate will significantly reduce the frequency of air blisters in the completed field seam.
9. Pull the poly backing from the Seam Tape beneath the top sheet and allow the top sheet to fall freely onto the exposed tape. Press top sheet onto the tape using firm even hand pressure across the splice towards the splice edge.
10. Immediately roll the splice with a steel hand roller, using positive pressure. Roll across the splice edge, and then parallel to it.
11. The use of Lap Caulk is optional, but may be applied immediately following the completion of rolling the Seam Tape.
12. To achieve proper adhesion with the job site temperature is below 40° F, the following steps must be followed:
 - a. Heat the primed area of the bottom sheet with a hot air gun as the Seam Tape is applied and pressed into place.
 - b. The Seam Tape must be rolled with a steel hand roller prior to removal of the release paper when temperatures fall below 20° F. Then strip the release paper per normal procedures after rolling onto bottom sheet.
 - c. Prior to rolling the splice area with the Hand Roller, apply heat to the topside of the membrane sheet with a hot air gun. The heated surface should be hot to the touch. Be careful not to burn or blister the membrane.

Handling: RUBBERALL® Tape Primer contains ingredients that could be harmful if mishandled. Contact with eyes and skin should be avoided and protective equipment and clothing should be worn. Avoid prolonged skin contact.

Recommended Storage: RUBBERALL® Seam Tape is a cured material and will not degrade in normal warehouse storage. Store in original unopened containers indoors at temperatures between 60° F and 80° F. Do not store in direct sunlight or at temperatures above 90° F for any extended period. In time, the release paper may become difficult to remove. For this reason, the recommended shelf life is 12 months. ROTATE STOCK.

NOTE: TECHNICAL INFORMATION AND DATA SHOULD BE CONSIDERED REPRESENTATIVE OR TYPICAL ONLY AND SHOULD NOT BE USED FOR SPECIFICATION PURPOSES.

User's Responsibility

This Product Data Sheet cannot cover all possible situations which the user may experience during product application/processing. Each aspect of your operations should be examined to determine if, or where, additional precautions may be necessary. All health and safety information contained in this bulletin should be provided to your employees or customers, along with the applicable MSDS sheet. It is your responsibility to use this information to develop appropriate work practice guidelines and employee instructional programs for your operation.

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