

A 146HT
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DESCRIPTION

A 146HT is a synthetic rubber based vacuum bag sealant tape. It is designed to withstand the sealing at elevated temperature up to 210°C.

KEY FEATURES

Good adhesion to a wide range of substrates.

Good adhesion to metal and composite tools, and to bagging films.

Highly conformable.

Easy and accurate to use with little waste and no mess.

Remains flexible throughout its service life.

Slightly cures at elevated temperature.

USES

For vacuum bag moulding, to bond the bagging film to the mould and suitable for fabricating composite structure under the vacuum and high temperature

PERFORMANCE

PROPERTIES	UNIT	SPECIFICATION	TEST METHOD
Appearance	-	Roll form	TT - 01
Colour	-	Yellow	TT - 02
Specific gravity at 30°C	g/mm ³	1.00 -1.40	TT - 05
Cone penetration with 50g weight at 30°C	1/10 th mm	50 - 70	TT - 08
Solid content at 105±2°C for 3hrs	%	Min 99	TT - 09
Heat aging at 210±2°C for 3hrs	--	No surface crack, No slipup	TT - 14
Peel strength @ RT (27 - 33°C) (Kg/12.5 mm) SS to nylon sheet 1. Before heat aging @ RT (27 - 33°C) for 24 hrs. 2. After aging @ 210°C for 12 hours.	Kg/cm ²	Min. 2.5 Min. 0.40	TT - 11
Lap shear strength @ RT (27 - 33°C) (Kg/cm ²) Stainless Steel to nylon sheet 1. Before heat aging @ RT (27 - 33°C) for 24 hours. 2. After aging @ 210°C for 12 hours.	Kg/cm ²	Min. 0.50 Min. 0.50	TT - 06
Service temperature	°C	-20 to 210°C	TT - 33

❖ TT- TALON TEST METHOD

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APPLICATION

- ❖ Application temperature range: 10 °C to 40 °C
- ❖ **Storage conditions:** Store in 20 -35°C cool and dry place at the original packing (Flat position always)
- ❖ **Self-life:** 12months

INSTRUCTION

- **Surface preparation:** All surfaces should be clean, dry, and free from frost, grease, and loose materials. When cleaning contaminated substrates, our recommend that propan-2-ol (IPA) is used and allowed to dry prior to the application of the butyl tape.
- **Application:** Apply direct from the reel onto one surface and press sufficiently along its whole length to achieve good initial adhesion. Remove backing paper and offer another surface to the sealant and push firmly to seal across the joint.

STD PACKING

Rectangular Section:

3mm X 12mm X 15m- 20rolls
3.2mm x 12.5mm x 7.5m – 10rolls

Note: According to the customer requirement the packing will varied.

TOLERANCES

Rectangular Section:

Thickness: $\pm 10\%$

Width: up to 10mm- $\pm 5\%$ Length: $\pm 5\%$
10 to 25mm: $\pm 1\text{mm}$

GENERAL

A 146 HT butyl tape is part of a range of butyl products for the vacuum forming industry. For further information, please contact our Marketing Team or visit our website.

The information given in this product data sheet is based on laboratory tests and experience which we believe to be correct. Properties quoted are typical and do not therefore constitute a specification. In view of the wide range and variability of substrates, we would advise that our product should be tested by the user to establish suitability for its intended application. E &OE.