

Millennium EPDM Seam Tape

Description

Millennium EPDM Seam Tape is a black, vulcanized rubber, pressure sensitive adhesive tape designed to provide high strength, watertight seams for single ply EPDM roofing membranes. Millennium EPDM Seam Tape is soft and tacky providing a quick grab onto EPDM field membranes, yet possesses high initial strength. Millennium EPDM Seam Tape exhibits excellent adhesion to most substrates including glass, metals, wood, concrete, masonry and some plastics. This tape will provide OEM quality performance for EPDM single-ply restoration projects.

Basic Use

Millennium EPDM Seam Tape is designed for field splicing of EPDM membranes.

Surface Preparation

All work surfaces should be clean, dry, and free of dirt, dust, debris, oils, un-adhered coatings, deteriorated membrane and other contaminants that may result in a surface that is not sound or is uneven. If necessary, clean the surface to receive the Millennium EPDM Seam Tape with an approved EPDM membrane cleaner.

Safety

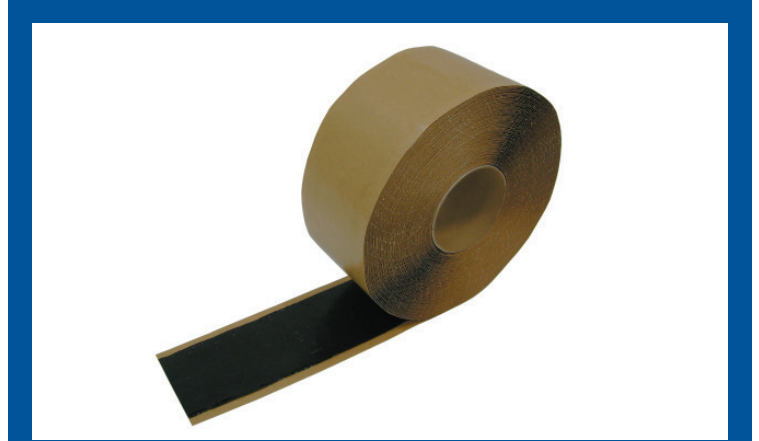
Prior to working with this or any adhesive product consult product label and Safety Data Sheet (SDS) for necessary health and safety precautions.

Limitations

- Do not use for detail flashing applications.
- Talc, dust, oil, ice, snow, or wet conditions inhibit good adhesion. Clean and dry surfaces are necessary for proper installation.
- Not for use on PVC or TPO membranes.

Color

Black



Features

UL and FM approved

OEM grade

No VOC's

Quick and easy installation

Excellent tack

No torch or liquid adhesives required

Water-tight seams

Benefits

Proven performance

Industry standard quality

Environmentally safe

Saves time and labor

Immediate green strength

Improved safety

Suitable for roofing or pond lining applications

Packaging and Coverage

Millennium EPDM Seam Tape is available in the following size:

<u>Widths</u>	<u>Length</u>	<u>Part #</u>	<u>Rolls/Case</u>
North America			
3 inch (76mm)	100 ft. (30.48m)	ET-0418	4
4 inch (102mm)	100 ft. (30.48m)	ET-0419	4
6 inch (152.4mm)	100 ft. (30.48m)	ET-0420-06	2
Europe, CIS and Middle East			
3 inch (76mm)	100 ft. (30.48m)	ET-0418-EU	4

Consult your technical sales representative regarding the availability of Millennium EPDM Seam Tape in additional widths.

Storage and Shelf Life

Store material in original unopened packaging at temperatures between 40°F-110°F (4°C - 43°C). Shelf life is 24 months when stored as recommended.

Application

1. The entire surface where Millennium EPDM Seam Tape will be applied must be cleaned and primed.
2. Mark the membrane where the edge of the splice occurs and then fold the top portion back. Apply EPDM primer to both sides of membrane using the supplied scrub pad. Scrub the membrane thoroughly while the primer is wet moving up and down the seam area. NOTE: Use caution when installing at temperatures below 40°F (4°C) to prevent blushing of EPDM primer (formation of condensation on surface of primer).
3. Allow the primer to dry to the touch (no material transfer, typically less than 20 minutes). Dry time will vary depending on ambient temperature and humidity.
4. Position the Millennium EPDM Seam Tape over the primed splice area along the marked edge. Press in by hand. Verify that approximately 1/8" (0.3cm) of tape extends beyond splice edge.
5. Roll the top surface of the release liner to promote adhesion to the bottom substrate.
6. Allow the EPDM membrane to fall freely onto the Seam Tape. Remove release liner at a 45° angle.
7. Immediately roll the splice with a 2" (5.08cm) wide silicone roller. Roll perpendicular to splice edge.
8. Seal edge of seam detail with patented Millennium EPDM Edge Sealant.*

Note: Millennium Single Ply Primer and Millennium Primer 240 are designed to dry with little or no tack. When dry, the primed seam area will feel completely "clean" to the touch. Other primers are designed to remain "tacky" to the touch in the dry state. With all primers, allow up to 24 hours after installation and rolling for taped seam to build maximum strength.



Technical Data

Typical Physical Properties and Characteristics		
	Typical Values	Test Method
Base Polymer	EPDM	FTIR
Color	Black	Visual
Peel Strength on EPDM	10 pli @ 70°F (21°C)	ASTM D 413
Shear Strength on EPDM	20 psi @ 70°F (21°C)	ASTM D 816
Brittleness Temperature	-50°F (-46°C)	ASTM D 746
Tensile Strength	40 psi min.	ASTM D 412
Elongation	>1000%	ASTM D 412
Application Properties		
Service Temperature	-40°F to 200°F (-40°C to 93°C)	ASTM D 3359
Application Temp	40°F to 120°F (4°C to 49°C)	ASTM D 603

NOTE:

The foregoing information is published as general information only. The listed properties and performance characteristics are typical values and are not to be interpreted as manufacturing specifications.



Membrane Splicing Tape for roofing systems as to external fire exposure see UL Directory of products certified for Canada and UL Roofing Materials and Systems Directory. 8790



Code #0016-0417

*US 6,642,296 B2; US 6,291,571 B1

WARRANTY: Royal Adhesives and Sealants warrants its products to conform to Royal's specifications at the time of sale when tested according to Royal standards. If a product is proven to be defective when tested according to Royal standards, Royal will, at its option, refund the purchase price or replace or repair the defective product. THIS LIMITED WARRANTY IS THE BUYER'S SOLE AND EXCLUSIVE REMEDY AGAINST ROYAL ADHESIVES AND SEALANTS AND IS IN LIEU OF ANY AND ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. In no event shall Royal be liable for any special, incidental, consequential, or punitive damages arising out of any claims whether based on negligence, contract, warranty, strict liability or otherwise.