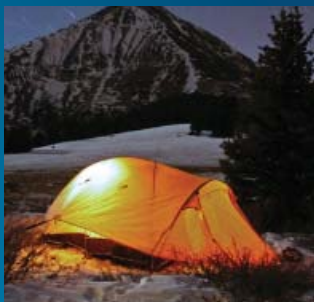




Seam Sealing Tape



The Critical Link in the Chain of Waterproof Protection

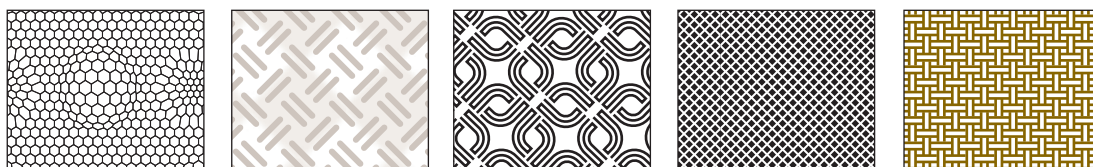


Seam tape is the critical link in the chain of waterproof protection. That's because a garment made of the best waterproof fabric in the world will leak if the seam is not sealed effectively. If the garment leaks, the customer won't care if it is from the fabric or the seam—all they know is they're getting wet and the product has failed. Quality seam tapes protect your investment by preventing leaks at the seams, that's why selecting the right seam tape is important. Bemis offers a wide range of high quality and environmental tapes for waterproofing sewn seams. Our tapes are strong, resilient, and easy to work with. We work closely with customers to develop products to meet their requirements.

Bemis seam tapes adhere to a wide variety of fabrics and materials and have been proven in many **applications** including:

- Rainwear/Outerwear
- Activewear: skiing, snowboarding, cycling, sailing, climbing, paddling sports, hiking, hunting, fishing, golfing, etc.
- Industrial workwear
- Tents
- Footwear
- Military garments & gear
- Hazardous material protective suits

We offer a wide range of **custom print capabilities** as they relate to your design, pattern, text, or logo needs. We've developed many tapes to match patterns on popular 2.5 layer fabrics. Background colors can also be matched. Below are a few examples.



Bemis is a bluesign® system partner with extensive experience in providing film and tape solutions. Our 2-layer tapes contain no Volatile Organic Compounds (VOCs). To complement our line of non-PVC tapes, Bemis printed tapes use only 100% UV-cured and water-based inks.

Features / Benefits



- ◆ Co-extruded tapes designed for excellent adhesion and superior waterproofing
- ◆ Precise slitting to your requirements
- ◆ Wide sealing ranges for efficient processing
- ◆ High quality tapes designed to pass vigorous hydrostatic testing
- ◆ Custom colored and printed tapes
- ◆ Soft, thin-gauge tapes for use with lightweight fabrics

Ordering Information



Stock Widths:	20 mm, 22 mm, other widths are available, contact Bemis
Stock Roll Length (2-layer):	300 m (327 yds)
Stock Roll Length (3-layer):	125 m (137 yds)
Core Size:	76.2 mm with 6.4 mm core wall (3" with .25" core wall)
Maximum Splices:	2 per roll (2 layer tapes), 4 per roll (3 layer tapes), adhesive layer is typically wound in
Stock Packaging:	10 rolls per box
Carton Size:	25.4 cm x 25.4 cm x 30.5 cm (10" x 10" x 12")

Notes: For custom color or printed tapes, contact Bemis for minimum order quantities. ST-804 standard width is 20mm and the standard roll length is 250 m (273 yards)

	ST-104	ST-503	ST-504	ST-604	ST-804	ST-306	ST-318
Sample							
Composition	PU/PU	PU/PU	PU/PU	PU/PU	PU/PU	PU/PU/ Nylon tricot	PU/PU/ Nylon jersey
Type	2 Layer	2 Layer	2 Layer	2 Layer	2 Layer	3 Layer	3 Layer
Standard Color / Finish ¹	Translucent or white / matte	Translucent / matte	Translucent / matte	Translucent / matte	Translucent / matte	Barrier: White / Tricot: Grey	Barrier: Clear / Jersey: Grey or black
Gauge:							
Total Adhesive	102 µm (.004") 51 µm (.002")	76 µm (.003") 45 µm (.0018")	102 µm (.004") 51µm (.002")	89 µm (.0035") 45µm (.0018")	102 µm (.004") 51 µm (.002")	260 µm (.010") 130 µm (.005")	160 µm (.016") 130 µm (.005")
Printing ²		Available	Available	Available	Available		
Features	Can be applied to fabrics at moderate temperatures & high line speeds. Provides consistent leak prevention, even when applied at high temperatures.	Offers a wide processing window. Adhesive melt flow promotes sealing at crossover seams. Can be applied to heat sensitive fabrics using low temperature.	Offers a wide processing window. Adhesive melt flow promotes sealing at crossover seams.	Soft tape designed for light weight fabrics where soft hand & minimal tape lines are desired. Can be applied to heat sensitive fabrics using low temperature.	A premium grade soft tape with stretch, designed for light-weight polyurethane and PVC coated fabrics where minimal tape lines are desired.	Designed specifically for 3-layer water-proof fabrics. Offers a moderate processing window.	A soft, stretch, 3-layer seam tape designed to seal seams on flexible three layer waterproof fabrics.
Adheres to: ¹	Light to medium weight vinyl or polyurethane coated fabrics	Very light weight vinyl or polyurethane coated fabrics	Light to medium weight vinyl or polyurethane coated fabrics	Very light to medium weight polyurethane or PVC coated fabrics	Very light weight and stretch polyurethane or PVC coated fabrics	Tight or loose weave polyester or nylon tricots	Stretch 3 layer water-proof fabrics
Softening Point ³	98°C (208°F)	85°C (185°F)	85°C (185°F)	105°C (221°F)	100°C (212°F)	95°C (203°F)	95°C (203°F)
Service Temperature ⁴	-40 to 50°C (-40 to 122°F)	-40 to 60°C (-40 to 140°F)	-40 to 60°C (-40 to 140°F)	-40 to 60°C (-40 to 140°F)	-40 to 60°C (-40 to 140°F)	40 to 80°C (-40 to 176°F)	40 to 80°C (-40 to 176°F)
Wash ⁵	Excellent up to 40°C	Excellent up to 40°C	Excellent up to 40°C	Excellent up to 40°C	Excellent up to 40°C	Excellent up to 40°C	Excellent up to 40°C
Initial Processing Conditions ⁶							
Temperature	350 - 700°C	350 - 700°C	350 - 700°C	550 - 700°C	500 - 700°C	550 - 700°C	550 - 700°C
Air	0.58 bar	0.58 bar	0.58 bar	0.58 bar	0.58 bar	0.58 bar	0.58 bar
Roller	3.92 bar	3.92 bar	3.92 bar	3.92 bar	3.92 bar	3.92 bar	3.92 bar
Line Speed	4.0 - 7.0 m/min	4.0 - 7.0 m/min	4.0 - 7.0 m/min	4.0 - 7.0 m/min	4.0 - 7.0 m/min	2.5 - 3.0 m/min	2.5 - 3.0 m/min

¹ Color: Other colors are available for all tapes (except ST104), however a minimum order quantity is required for any colors not listed in this table.

² Printing: There is a minimum order quantity of 2,743 linear meters (3,000 yards) at 16" wide, or approximately 46,634 slit meters (51,000 slit yards) at 20mm widths. The slit quantity may be slightly more or less than estimated. We will ship all that is produced. Contact Bemis for further details.

³ Adhesive Softening Point: The temperature at which the adhesive layer begins to flow.

⁴ Service Temperature: The ambient temperature range in which the tape will best perform.

⁵ Washability: An "excellent" rating dictates that the seam tape passes Bemis testing of adhesion and hydrostatic waterproof at 3 psi for 2 minutes after 5 wash (@ 40°C) & dry cycles. Wash testing is completed after the samples equilibrate for a minimum of 4 hours. Satisfactory adhesion for wash resistance varies depending on fabric and fabric finish. To assure performance, each fabric should be individually tested.

⁶ Initial Processing Conditions: Recommended settings when using a hot air sealer. Depending on machinery & fabric, adjustments may be required.

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building bonds that last

Quality Products

Bemis has been formulating thermoplastic films, adhesives and tapes for more than 40 years. We've combined this experience with the latest machinery and new chemistries to bring our customers high quality films that are designed to perform the functions they require.

Innovation

Our innovation drives the development of many custom film solutions for a variety of industries. We strive to continuously improve our performance, our service, and our understanding of the needs of our customers. We possess a wide range of adhesive chemistry to ensure that we have an array of formulations to choose from. If there isn't a Bemis film that meets your needs, we'll put our product development team to work on designing one that does.

Industry Leader

We have high standards in executing business practices, making ecologically friendly products, and fostering civic mindfulness. We're a reliable vendor; we've been in business for over one hundred years. Our success has allowed us to reinvest in our products, equipment, and talent. We bring valuable and credible insights based on years of industry and market experience.

Worldwide Products & Service

Laboratories and offices in the US, China, UK, Korea, Taiwan, Sri Lanka, France and Central America allow us to provide "local" support on a "global" basis. This has tremendous advantages for companies looking to harmonize product supply, maintain quality, and provide excellent service. This world-class technical support is based on our ability to analyze composite materials, test adhesive compatibility and provide sound recommendations based on quantitative lab results.



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