



# TECHNICAL DATA SHEET

## SK2ST399-1

Sealant tape for high temperature processes

### ► DESCRIPTION

SK2ST399-1 is an advanced process vacuum bag tape sealant that was developed to fulfill the stringent requirements of very high temperature cure requirements. This sealant tape is formulated with a unique base polymer to function throughout a temperature range of 191°C to 399°C. Extended cure cycles of 12 hours or longer at intermediate temperatures of 204°C to 315°C are possible.

This product is used in various manufacturing processes of parts made of composite materials.

### ► TECHNICAL DATA

Color:	Dark brown
Percent solid:	100%
Maximum use temperature:	399°C
Consistency:	90-140
Cone penetration:	150 g load

### ► ADVANTAGES

- Easy to apply by hand (User friendly)
- Ideal for oven or autoclave cure
- 191°C to 399°C cure cycles
- Tenacious adhesion to polyimide films and tool surfaces
- Strips clean from tools surfaces
- Non-hazardous and thermally stable

### ► 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. A hot roller or iron (not to exceed 204°C) can be used to apply pressure on the sealant. It is recommended to strip below 66°C to minimize or reduce the parts from becoming warped. SK2ST399-1 can be stripped without leaving a residue on metal tool surfaces that have been cooled to room temperature.

Application Temperature Range:	7°C to 49°C
Service Temperature Range:	177°C to 399°C



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### ► SIZE

Thickness	Width	Length	Packing
3mm	12mm	9m	24 rolls / case

Shelf life: 12 months minimum from date of manufacture with the respect to the storage conditions.

Storage conditions: it is recommended to store at temperatures between +17°C and +27°C stored flat in original packing.

### ► NOTE

Material must be at room temperature for application.

The maximum use temperature is dependent upon the duration at maximum temperature and is process specific, we recommend testing prior to use.