



ADVANCED SEALANT TECHNOLOGY

**Aerospace**  
Vacuum Bag Sealants

**TW Polymers Sealants** North America

# TACKY TAPE® Aerospace Vacuum Bag Sealants


## TACKY TAPE® SM5126



This high-temperature vacuum bag sealant is the choice of many composite bonding shops due to its secure adhesion and lay-up characteristics. It is tough, yet pliable for rapid lay-up and bagging. It is highly recommended for both oven and autoclave applications.

*Uses: Debulking/Compacting, Envelope Bagging, Resin Dam*

**Tape Color:** Dark Grey

**Cure Cycles:**   
Room Temp. to 450°F (232°C)

**Shelf Life:** 9 Months

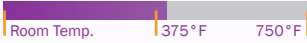
## TACKY TAPE® SM5127



This tape is an unsurpassed performer where post-cure cycles are required. It is compatible with most bagging films and is an ideal choice for composite tools, exhibiting easy release from the tool surface. It is used in the fabrication of parts where oven or autoclave cycles require that a vacuum be maintained.

*Uses: Debulking/Compacting, Envelope Bagging, Resin Dam*

**Tape Color:** Charcoal Grey

**Cure Cycles:**   
Room Temp. to 400°F (204°C)

**Shelf Life:** 9 Months

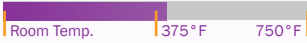
## TACKY TAPE® SM5142



SM5142 is excellent for cures from room temperature to 400°F (204°C). It is easy to use with aggressive tack to all typical films and tools. It strips clean and leaves virtually no residue on tool surfaces after oven or autoclave cures. Works with a variety of resin systems and can function not only as a vacuum bag sealant but as a resin dam and pressure strip as well.

*Uses: Debulking/Compacting, Envelope Bagging, Resin Dam, Pressure Strip*

**Tape Color:** Yellow

**Cure Cycles:**   
Room Temp. to 400°F (204°C)

**Shelf Life:** 1 Year


## TACKY TAPE® SM5144



This sealant has been improved to outperform all tapes in its class. Initial tack is higher. The product exhibits a clean release both warm and cold from all tool surfaces after cure. Its shelf life is 1 year. In addition, this product has the ability to survive 30 debulking cycles and to act as a resin dam.

*Uses: Debulking/Compacting, Envelope Bagging, Resin Dam, Pressure Strip*

**Tape Color:** Yellow

**Cure Cycles:**   
Room Temp. to 425°F (218°C)

**Shelf Life:** 1 Year

Customer Service: 800-878-7876 • Fax: 972-554-3939 • www.itwsealants.com

## TACKY TAPE® SM5160



Designed for use in the stringent requirements of very high temperature cure cycles, this new high-performance sealant exhibits excellent adhesion to the polyimide and Kapton® bagging films throughout its shelf life. Extended cure cycles of twelve hours or longer are also possible with this new material.

*Uses: Envelope Bagging, Resin Dam*

**Tape Color:** Brown

**Cure Cycles:** Room Temp. | 375°F | 750°F  
350°F (177°C) to 750°F (399°C)

**Shelf Life:** 1 Year

## TACKY TAPE® SM5170



This sealant tape exhibits a broad temperature range of room temperature to 450°F (232°C). It is compatible and adheres tenaciously to a variety of tool surfaces and films. It cures tight during the cure cycle and strips clean from the tool surface warm or cool. It is the premier choice to provide a positive vacuum in autoclave and oven applications.

*Uses: Debulking/Compacting, Envelope Bagging, Resin Dam*

**Tape Color:** Natural

**Cure Cycles:** Room Temp. | 375°F | 750°F  
Room Temp. to 450°F (232°C)

**Shelf Life:** 1 Year

## TACKY TAPE® SM5190



This sealant is designed for wind energy, aerospace, and composite manufacturing requiring ambient or low temperature cure cycles. It can be used as a vacuum bag sealant in debulking applications and seals most films to various tool substrates while vacuum is held for room temperature applications.

*Uses: Single to Multiple Debulking/Compacting*

**Tape Color:** Black

**Cure Cycles:** Room Temp. | 375°F | 750°F  
Room Temp. to 250°F (121°C)

**Shelf Life:** 1 Year

## TACKY TAPE® SM9151



The improved qualities of this tape make it an excellent choice for most composite lay-up applications. This was the first tape in the market to incorporate a color indicator that changes, signifying cure. Some of the unique characteristics of SM9151 are: tenacious adhesion, better heat stability, longer shelf life and strips off from tool surface after cure without leaving residue.

*Uses: Debulking/Compacting, Envelope Bagging, Resin Dam, Pressure Strip*

**Tape Color:** Pink

**Cure Cycles:** Room Temp. | 375°F | 750°F  
Room Temp. to 425°F (218°C)

**Shelf Life:** 1 Year

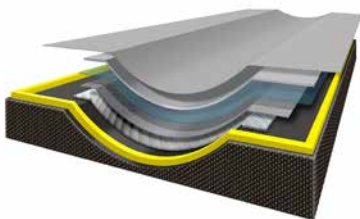


# TACKY TAPE® Aerospace Vacuum Bag Sealants

## Selector Chart

		SM5126	SM5127	SM5142	SM5144	SM5160	SM5170	SM5190	SM9151
TOOL/PLATEN	ALUMINUM	●	●	●	●	●	●	●	●
	COMPOSITE			●	●	●	●	●	●
	NICKEL	●	●	●	●	●	●		●
	STAINLESS STEEL	●	●	●	●	●	●	●	●
	STEEL	●	●	●	●	●	●	●	●
PROCESS USED	DEBULKING/ COMPACTING	●	●	●	●		●	●	●
	ENVELOPE BAG	●	●	●	●	●	●	●	●
	RESIN DAM	●	●	●	●	●	●		●
FILM TYPE (MAX. TEMP)	NYLON (450°F/232°C)	●	●	●	●				●
	P.V.A. (300°F/149°C)								
	P.V.C. (140°F/60°C)	●	●		●		●	●	●
	POLYIMIDE (800°F/427°C)					●			
	SILICONE BLANKET (500°F/260°C)	●			●		●		●
TYPICAL CURE TEMPERATURES	ROOM TEMP.	●	●	●	●		●	●	●
	250°F (121°C)	●	●	●	●		●		●
	350°F (177°C)	●	●	●	●	●	●		●
	375°F (191°C)	●	●	●	●	●	●		●
	400°F (204°C)	●	●	●	●	●	●		●
	425°F (218°C)	●			●	●	●		●
	450°F (232°C)	●				●	●		
	600°F (316°C)					●			
	750°F (399°C)					●			

All tapes listed in the Selector Chart will perform satisfactorily from ambient to cure temperatures as indicated.



### OUR HIGH-QUALITY SEALANTS LINE INCLUDES:

- Butyl Tapes
- Foam Tapes
- Polyurethane
- Waterborne Sealants
- Solvent Release Acrylics
- Acrylic/Urethane Sealants
- Siliconized Acrylic Latex Sealants
- Silicone (Both Acetoxy and Neutral Cure) Sealants

**ITW Polymers Sealants** North America

[www.itwsealants.com](http://www.itwsealants.com)

111 S. Nursery Road, Irving, TX 75060

TEL: 1.800.878.7876 FAX: 972.554.3939