



# SM5153 VACUUM BAG SEALANT TAPE

## TECHNICAL DATA SHEET

### PRODUCT DESCRIPTION:

Tacky Tape® SM5153 has been developed for the wind energy and aerospace industry as vacuum bag tape for vacuum bagging operations, wind blades and composite manufacturing. This product has been formulated to outperform all tapes in its class. With aggressive initial tack, it will maintain an air-tight seal during the cure cycle, yet strip clean from the tool, with virtually no trace of residue. SM5153 provides easy, almost effortless de-bagging, and minimal to no clean-up between production cycles. SM5153 exhibits these excellent usage and release characteristics from composite and metal tools, in both oven and autoclave applications. This tape has an optimum cure temperature range of room temperature to 400°F (204°C).

### ADVANTAGES:

- Easy to apply by hand (User friendly)  
Ideal for oven or autoclave cure
- Excellent release from composite tooling
- Uses include: debulking/ compacting, envelope bagging, resin damming, or as pressure strip
- Has been shown to survive 30 debulking cycles
- Room temperature to 400 °F (204°C ) cure cycles
- Maintains adhesion during low temperature cycling
- Good adhesion to various films and tool surfaces
- Strips clean from tools surfaces leaving no residue
- Non-Hazardous

### 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. It is recommended to strip below 150°F (66°C) to minimize or reduce the parts from becoming warped. SM5153 can be stripped without leaving a residue on metal tool surfaces that have been cooled to room temperature.

### PACKAGING:

Tacky Tape® SM5153 sealant is supplied in roll form with a special release paper.  
This product is available through ITW Polymers Sealants North America, Inc. Customer Service department at 1-800-878-7876.

### PERFORMANCE TEMPERATURE RANGE:

Application Temperature Range: 45°F (7°C) to 120°F (49°C)  
Service Temperature Range: Room Temp to 400°F (204°C)

### TYPICAL PROPERTIES:

COLOR:	Yellow
PERCENT SOLID:	100%
CONSISTENCY: Cone Penetration	80 - 95 300 GRAM LOAD ASTM D-217
WEIGHT/GALLON:	10.2 LBS/GALLON (1.22 Kg/L)
FREIGHT CLASSIFICATION:	Caulking Compound, NOIBN (NO LABEL REQUIRED)
STORAGE:	Keep in cool dry place. Tacky Tape® SM5153 has a 12 month shelf life from date of manufacture when stored at or below 80°F (27°C). Do not store cartons on end, keep flat.

### EXCLUSION OF WARRANTIES:

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