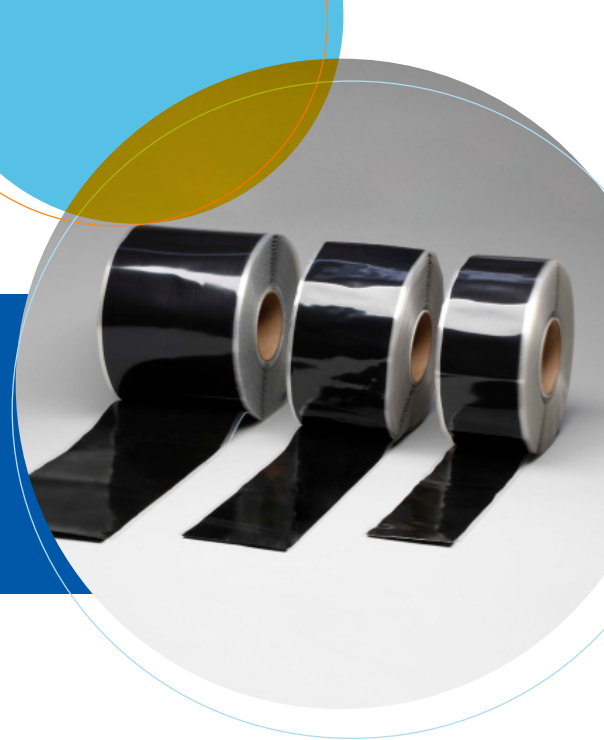


EPDM RESTORATION

# 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.

## STORAGE

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.

## COLOR

Black

## SAFETY

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

## PACKAGING AND COVERAGE

Millennium EPDM Seam Tape is available in the following sizes:

### NORTH AMERICA

Width	Length	Part #	Rolls/Case
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

Width	Length	Part #	Rolls/Case
3 inch (76mm)	100 ft. (30.48m)	ET-0418-05EU	4

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

## FEATURES

## BENEFITS

UL and FM approved	Proven performance
OEM grade	Industry standard quality
No VOC's	Environmentally safe
Quick and easy installation	Saves time and labor
Excellent tack	Immediate green strength
No torch or liquid adhesives required	Improved safety
Water-tight seams	Suitable for roofing or pond lining applications



## 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.

## 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 flashing with an approved EPDM membrane cleaner.

## LIMITATIONS

- Not for use on PVC roof membranes.
- Not for use in high traffic areas.
- Talc, dust, oil, ice, snow, or wet conditions inhibit good adhesion. Clean and dry surfaces are necessary for proper installation of this product.

## TECHNICAL DATA

Typical Physical Properties and Characteristics		
	Typical Values	Test Method
Base Polymer	EPDM	FTIR
Color	Black	Visual
Tensile Strength	40 psi min.	ASTM D 412
Elongation	>1000%	ASTM D 412
Peel Strength on EPDM	10 pli @ 70°F (21°C)	ASTM D 413
Shear Strength	20 psi @ 70°F (21°C)	ASTM D 816
Brittleness Temperature	-50°F (-46°C)	ASTM D 746
Application Properties		
Service Temperature	-40°F to 200°F (-40°C to 93°C)	ASTM D 3359
Application Temperature	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. 8770

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



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