

SWORL, Inc.

Dedicated to providing innovative solutions and quality service

(512)846-2444

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PRSI 308 Adhesive Tape

Technical Data Sheet

PRSI 308 Adhesive Tape is utilized during the process of repairing post cured and uncured SWORL reusable vacuum bags to itself and is also suitable for bonding SWORL bags to Viton, metal or composite frames for use as clamping or lifting frames.

Physical Properties

The physical properties shown below were obtained on 0.40" thickness molded ASTM samples. The values below are typical but should not be used to set Quality Control Specification minimum requirements.

Hardness (Shore A).....	55
Tensile Strength (psi).....	675
Elongation at Break (%).....	310%
Modulus at 100% Elongation (psi).....	385
Modulus at 300% Elongation (psi).....	790
Tear Strength (ppi).....	140
Specific Gravity.....	1.10
Compression Set at 350°F.....	18%

This compound is a high strength, uncured silicone rubber for use as an adhesive for bonding cured and uncured PRSI 308 to itself, metal or composite surfaces, or Viton for use as an intensifier or sealing mechanism.

Method 1. Bonding Viton or other to newly spray fabricated PRSI 308 bag.

- Step 1 Position clean Viton strips (as received) on the tool flange in the required area. Use gloves (powder free to eliminate oil or other contamination from fingers).
- Step 2 Position PRSI 308 Adhesive Tape on top of Viton strips or other, hand roll to insure uniform contact.
- Step 3 Apply a wet bead of PRSI 308 on top of Viton or other/Tape layup. This wet bead will fixture the Viton/Tape in place so as to not be disturbed during the spray process.
- Step 4 Bag contents in a disposable vacuum bag, UNDER Pressure of 60 psi , co cure all of the materials together for 30 minutes at 300°F, after which post cure the prepared bag at 400°F for 4 hours.

**Viton or other may also be bonded to SWORL using vacuum and heat and provide similar results. Critical care must be taken to insure intimate contact between silicone tape and substrate.

PRSI 308 Adhesive Tape TDS, continued

Method 2. Bonding Viton or other to a post cured SWORL bag.

- Step 1 Position clean Viton strips or other (as received) use gloves (powder free to eliminate oil contamination from fingers) on the tool flange in the required area.
- Step 2 Position PRSI 308 Adhesive Tape on top of Viton or other, hand roll to insure uniform contact.
- Step 3 Install post cured SWORL bag over Viton or other/Tape layup.
- Step 4 Bag contents in a disposable vacuum bag, UNDER pressure of 60 psi, co cure all of the material together for 30 minutes at 300°F, after which post cure the prepared seal at 400°F for 4 hours.

**Viton or other may also be bonded to SWORL using vacuum and heat and provide similar results. Critical care must be taken to insure intimate contact between silicone tape and substrate.

Storage and Handling:

PRSI 308 Adhesive Tape is supplied in 1" wide, 30' rolls. Storage in a freezer at temperatures below 40 degrees F will insure shelf stability of at least 6 months. Material should be removed from the freezer and allowed to reach room temperature prior to use. Any moisture that condenses on rubber surface should be removed with a dry cloth. If the surface needs to be freshened, use a cloth saturated with Acetone or MEK solvent. Any unused material should be repackaged and returned to the freezer.

Do not subject the tape to temperature in excess of 302°F in an oxygen environment. Before using this product, please refer to the Safety Data Sheet (SDS).

NON – WARRANTY Except for a warranty that the materials supplied substantially comply with the data presented in the Manufacturer's latest bulletin describing the product, "All Materials are sold AS-IS, and without any warranty expressed or implied as to merchantability, fitness for a particular purpose, patent, or any other matter. In no event shall Manufacturer's liability for damages exceed manufacturer's sale price of the particular quantity with respect to which damages are claimed.

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