

### DESCRIPTION AND USE

LEXCAN HI-FLEX EPDM T-325 SEAM TAPE is a black, vulcanized rubber, pressure sensitive adhesive tape, used in conjunction with LEXCAN PA-100 EPDM AND TPO PRIMER, to form a permanent, vapour proof and waterproof seam. It is designed for field splicing of HI-FLEX EPDM membranes.

**CAUTION:** Proper EPDM field seam fabrication is a multi-step process using different materials. Refer to Lexcan's detailed specifications and drawings for complete seam fabrication instructions and requirements.

### FEATURES AND BENEFITS

**Superb Tack** - high initial strength for long-term watertight performance.

**No VOC's** - environmentally-friendly.

**Quick and Easy to Install** - Saves time and labour.

### TECHNICAL DATA

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

Application Properties	Test Method	Typical Values
Service Temperature:	ASTM D 3359	-40°C to 93°C (-40°F to 200°F)
Application Temperature:	ASTM D 603	-40°C to 49°C (-40°F to 120°F)

### PACKAGING & COVERAGE

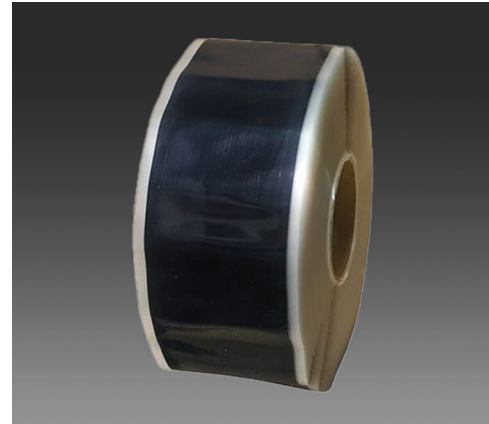
Sizes	Roll per Box
76 mm x 30.48 m (3" x 100')	4
152 mm x 30.48 m (6" x 100')	2

### STORAGE

Store material in original unopened packaging at temperatures between 4°C - 43°C (40°F-110°F).

### SHELF LIFE

24 months when stored as recommended.



### INSTALLATION

Ensure that the substrate is suitable for the application of HI-FLEX EPDM T-325 SEAM TAPE. Ensure the area to receive the tape is clean, dry, and free of dirt, dust, debris, oils, un-adhered coatings, deteriorated membrane or other contaminants that may affect the performance of HI-FLEX EPDM T-325 SEAM TAPE. If necessary, clean the surface to receive the tape with LEXCAN SINGLE PLY MEMBRANE CLEANER.

**NOTE:** HI-FLEX EPDM T-325 SEAM TAPE must be used in conjunction with LEXCAN PA-100 EPDM AND TPO PRIMER.

1. Overlap the HI-FLEX EPDM membranes to be spliced the minimum required distance. For 76 mm (3") wide T-325 SEAM TAPE, the minimum overlap is 76 mm (3"). For 152 mm (6") wide T-325 SEAM TAPE, the minimum overlap is 152 mm (6").
2. Mark on the lower sheet approximately 3 mm (1/8") to 6 mm (1/4") out from the edge of the upper sheet using a crayon. Fold the upper membrane back to expose the underside area that will receive the Seam Tape.
3. Ensure areas to receive the T-325 SEAM TAPE are clean and free of excessive dust, dirt, grease and oil.
4. Apply LEXCAN PA-100 EPDM AND TPO PRIMER to both the lower sheet and underside of upper sheet. Allow the primer to flash-off until it does not transfer to a dry finger touch.
5. Unroll approximately 0.3 m (1') of T-325 SEAM TAPE. Align its edge with the crayon mark on the lower sheet. Press it down onto the sheet using hand pressure. Continue over the length of the splice, lapping Seam Tape roll ends a minimum of 76 mm (3").
6. While the poly backing is still on, roll the upper surface of the Seam Tape heavily with a hand roller. Roll perpendicularly to force out air bubbles and then lengthwise along the tape.
7. Unfold the upper EPDM membrane sheet and let fall neatly over top of the lower sheet, without wrinkles or folds.

# HI-FLEX EPDM

## T-325 SEAM TAPE

LEXCAN

8. Remove the poly backing from the Seam Tape by pulling it out from the edge of the seam.
9. Press down on the seam and roll it heavily across the seam with a hand roller to force out any trapped air bubbles then roll the seam lengthwise.
10. Ensure that the edge of the Seam Tape edge extends out from the seam along its entire length.
11. Apply LEXCAN LAP SEALANT and/or HI-FLEX EPDM LEXFLASH II FLASHING where required in LEXCAN specifications and details.

### CAUTIONS & LIMITATIONS

- Not for use on PVC membranes.
- Do not use in high-traffic areas.

LEXCAN

### SINGLE PLY ROOFING SYSTEMS

Ontario & Western Canada 1.800.268.2889

Quebec & Atlantic Canada 1.800.363.2307

Distr. By/Par Lexsuco 2010 Corporation, 3275 Orlando Drive, Mississauga, ON, L4V 1C5