



# Product Data Sheet

## MULE-HIDE EPDM IN-SEAM TAPE

### PRODUCT DESCRIPTION

Mule-Hide In-Seam Tape is a black or white, butyl rubber-based adhesive in tape form. The product has been formulated to provide high green strength in both shear and peel. Mule-Hide's In-Seam Tape has a clear, durable poly release film for ease of use.

### BASIC USES

Mule-Hide In-Seam Tape was specifically developed for splicing sheets of EPDM membrane together. The In-Seam Tape may be used on Ballasted, Mechanically Attached and Fully Adhered EPDM Roofing Systems.

### TYPICAL PHYSICAL PROPERTIES

Typical Properties and Characteristics	
Color	Black or White
Base	Synthetic Rubber
Roll Size	100' (30 m) long
Thickness	.030" (0.75mm)
Packaging – 3"	4 rolls / carton – 26 lbs (12 Kg)
Packaging – 6"	2 rolls / carton – 26 lbs (12 Kg)
Typical properties and characteristics are based on samples tested and are not guaranteed for all samples of this product. This data and information is intended as a guide and does not reflect the specification or specification range for any particular property of this product.	



### LEED Information

LEED Information	
Pre-consumer Recycled Content	4%
Post-consumer Recycled Content	0%
Manufacturing Location	Greenville, IL
Solar Reflectance Index (SRI)	N/A

### BENEFITS & SUPPLEMENTAL STATEMENTS

- Available in 3" or 6" widths x 100 foot long rolls
- Available in Black or White
- Excellent long-term strength
- Manufactured with a clear poly film
- Greater peel and shear strength

### INSTALLATION INSTRUCTIONS

1. Overlap the EPDM membranes the appropriate amount. For 3" (75 mm) In-Seam Tape, overlap the membranes 4" (100 mm). For 6" (150 mm) In-Seam Tape, overlap the membranes 7" (175 mm).
2. The entire surface where the In-Seam Tape will be applied must be clean. The In-Seam Tape will not adhere to dusted or dirty surfaces. Any residual contamination will be detrimental to the bond strength of the adhesive.



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### INSTALLATION INSTRUCTIONS (Continued)

3. If membrane is very dirty, scrubbing with Weathered Membrane Cleaner may be necessary. This process is essential on membrane that has been exposed for a number of weeks. Allow membrane to dry thoroughly before proceeding.  
Note: Permeation resistant gloves (that meet ANSI/ISEA 105-2005) are required for hand protection when cleaners or primers are being used.
4. Mark the bottom sheet with a crayon approximately ¼" (6 mm) at the edge of the top sheet along the entire splice length as a guide to install the In-Seam Tape.
5. Apply tape primer with Scotch-Brite® pads or clean rags. Scrub the area of the membrane where the In-Seam Tape is to be applied, in a circular motion to achieve a thin, even coating on the membrane. The properly cleaned/primed area will be uniform in color without streaks and free of globs or puddles.  
Note: The use of excessive amounts of Low VOC EPDM Primer will not significantly enhance the adhesion of the Pre-Taped or Taped Product to the EPDM or TPO membrane. Use only the amount necessary to obtain 100% coverage of the area where the tape or adhesive will be applied.
6. Allow the Low VOC EPDM Primer to dry until it does not transfer to a dry finger touch. Prompt installation of the In-Seam Tape or Taped Product as soon as the primer flashes off minimizes potential dust contamination and promotes adhesion in colder weather.
7. Unroll approximately 3' (1 m) of In-Seam Tape. Align the tape with a marked line and press tape down to bottom sheet using firm, even hand pressure. Continue for the length of the splice. Tape roll ends should be overlapped 1" (25 mm). Allow top sheet to rest on poly backing after application. A minimum of 1/8" (3 mm) to a maximum of 1/2" (12 mm) of tape must extend beyond the splice edge. A continuous piece of In-Seam Tape must be used at all field and factory splice intersections.
8. Roll the In-Seam Tape with a 2"-wide hand roller after application to the primed substrate. This will significantly reduce the frequency of air blisters in the completed field seam.
9. Pull the poly backing from the In-Seam Tape beneath the top sheet and allow the top sheet to fall freely onto the exposed tape.
10. Press top sheet onto tape using firm, even hand pressure across the splice towards the splice edge.
11. Immediately roll the splice with a 2"-wide roller using positive pressure. Roll across the splice edge, not parallel to it.
12. The use of Lap Sealant with In-Seam Tape seams is optional except at cut edges of reinforced membrane (exposed scrim reinforcement and tape overlaps), where Lap Sealant must be utilized. Lap Sealant may be applied immediately following the completion of an In-Seam Tape splice for added protection. See Lap Sealant PDS or appropriate detail for more information.
13. Use of In-Seam Tape at temperatures below 40°F will result in reduced adhesion. Review Mule-Hide Specifications and details for complete installation information.

### PRECAUTIONS

- Avoid prolonged contact with skin. In case of contact with skin, thoroughly wash affected area with soap and water.
- Prolonged jobsite storage temperatures in excess of 90°F (32°C) will shorten product shelf life.
- In warm, sunny weather, keep In-Seam Tape rolls in original box in a shaded area until ready to use.
- Storage and use of In-Seam Tape at temperatures below 40°F (4°C) will result in a loss of tape tack and, in extreme cases, will result in no bond to the substrate. Overnight storage must be available to keep the temperature of the In-Seam Tape at a minimum of 60°F (15°C). Hot boxes for jobsite storage must be provided to maintain a minimum tape temperature of 40°F (4°C).
- In-Seam Tape must be stored in a dry area.
- Due to solvent flash-off, condensation may occur on freshly applied primer when the ambient temperature is near the dew point. If condensation develops, the application of primer and In-Seam Tape must be discontinued as proper adhesion will not be achieved.



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### **PRECAUTIONS (Continued)**

- Allow the primer surface to dry and apply a thin freshener coat of primer to the previously coated surface and apply In-Seam Tape when conditions allow.
- KEEP OUT OF REACH OF CHILDREN

### **PROTECTION & SAFETY**

Mule-Hide maintains Material Safety Data Sheets on all of its products. Material Safety Data Sheets contain health and safety information for your development of appropriate product handling procedures to protect your employees and customers. Mule-Hide's Material Safety Data Sheets should be read and understood by all of your supervisory personnel and employees before using Mule-Hide products in your facilities.

### **ADDITIONAL INFORMATION**

The information given on this PDS is subject to change without notice. Always check the Mule-Hide website at [www.mulehide.com](http://www.mulehide.com) for the latest information, changes and updates or contact Mule-Hide Products Company at 800-786-1492.

### **DISCLAIMER**

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