

TECHNICAL DATA SHEET

MANUS-BOND 64A-HVT VACUUM BAG TAPE (TVBTG 1812-1000)

“Creates Positive Vacuum and Airtight Seal During Pre-Preg and Autoclave Composite Manufacturing”

PRODUCT DESCRIPTION:

MANUS-BOND 64A-HVT is 100% solid, Grey colored preformed synthetic hybrid polymer based sealant tape, developed for the Aerospace and composite industry. It is designed for vacuum bagging operations during pre-preg and composite parts manufacturing at room temperature and elevated temperatures. The tape when it cures in oven without outside pressure does not foam in the same way other vacuum bag tapes in the market do. This product has been formulated with good initial tack, balanced level of softness to easily seal around vacuum and resin injection ports, high molecular weight polymers to resist flow under vacuum and pressure, and it will maintain an air-tight seal during the resin cure cycle, yet strips clean from the tool surface. Typical uses for this tape include debulking/compacting, envelope bagging, pre-preg, resin damming, or as a pressure strip.

64A-HVT provides minimal to no clean-up between production cycles. It exhibits these excellent usage and release characteristics from composite and metal tool surfaces. This tape has an optimum service temperature from room temperature to exothermic resin cure temperature, ranging from room temperature to 425°F (204°C). For optimum release properties and to prevent part to warp, strip when the tool surface cool down.

APPLICATION INSTRUCTION:

Apply by hand to a clean dry surface with release paper on top. When the sealant is in position remove the release paper and while laying the film on top. Apply pressure by hand or use 1” roller on the top of the film and sealant to obtain intimate contact with the surface and to ensure positive seal. It is recommended to strip below 120°F (49°C).

Features	Advantages
<ul style="list-style-type: none">• Easy to apply by hand on flat and contour surfaces• Easy to wrap around vacuum and resin injection ports• Strong adhesion to nylon films and tooling surfaces• Maintains adhesion during low temperature cycling• Easy, almost effortless de-bagging• Strips clean from various tools surfaces at room temperature	<ul style="list-style-type: none">• Does not foam when it is cured in an oven without pressure• Excellent resistance to common resins used in the manufacturing of composites

PERFORMANCE TEMPERATURE RANGE:

Application Temperature Range: 45°F (7°C) to 120°F (49°C)
Service Temperature Range: Room temperature to 425°F (204°C)

PACKAGING AND SIZES:

64A-HVT Sealant Tape is extruded in roll form with a release liner. The tape standard size is ½” x ⅛” x 25’, 3/32” x ¾” x 45’, other tape dimensions and roll lengths can be extruded upon request. Consult with Manus Products for specific dimensional needs.

PROPERTIES:

COLOR	Visual	Grey
PERCENT SOLID	ASTM C681	100%
Specific Gravity	ASTM D71	1.24 (10.5 lbs/gal)
Weight Per Gallon	ASTM D71	10.5 lbs
Cone Penetration	ASTM D217	85-100 (0.1 mm)
Yield Strength	ASTM C908	>10 Psi
Vehicle Migration	ASTM C772	None
Backing Removal	ASTM C879	Complete removal, no tearing
FREIGHT CLASSIFICATION	Caulking Compound, NOIBN (NO LABEL REQUIRED)	
STORAGE and Shelf Life	64A-HVT has a 12 month shelf life from date of manufacture when stored in cool dry place at or below 80°F (27°C). Do not store cartons on end, keep flat.	

¹ The values are typical or an approximation for the material and are not intended for use in specifications. Field or environmental conditions or application methods may yield different results.

TECHNICAL SERVICE:

Manus technical representatives are always available to provide assistance. Please contact our Technical Service Department with your questions or requests for specific applications.

LIMITED WARRANTY:

Any goods proved defective will be replaced or the purchase price refunded. The limited warranty described herein is in lieu of any other warranty, expressed or implied, including any implied warranty of merchantability or fitness for a particular use. The user shall determine suitability of the product for its intended use. Liability for any incidental or consequential damage or loss is excluded. The user assumes all risks of the product’s use, handling and storage.

MANUS PRODUCTS

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