

## DATA SHEET

# HK312 SEALANT TAPE

HAWKEYE HK312 SEALANT TAPE is a black, aggressively tacky rubber-based sealant with excellent cohesive and adhesive properties. It was developed as a universal sealant for sealing all films, especially nylon to the mold in the vacuum bag curing of plastic and metal parts in the aircraft and aerospace industries. It is also used in the vacuum bag curing of adhesive bonded sandwich and honeycomb panels. On exposure to curing temperatures ranging from 250 degrees F to 400 degrees F (121 - 214 degrees C), this product cures to a tough elastic rubber, marking it easily stripped from the tool while still warm; eliminating down-time waiting for the tool to cool to room temperature.

HK312 Sealant Tape is designed to strip clean from bare metal and epoxy resin tools with or without a release or parting agent pre-treatment. HK312 should be pre-tested with each individual; release or parting agent to assure that it will strip from the coated metal without leaving a residue.

HK312 Sealant Tape has aggressive tack at application temperatures, as low as minus 35 degrees F (-37 degrees C). It is formulated without solvents, eliminating fire hazard and shrinkage. The sealant tape will deform under slight pressure to fill irregularities, voids and spaces in tools and dies.

HK312 Sealant Tape is extruded in ribbon form. The standard size is 1/8" X 1/2" X 25 ft per roll. Rolls are interlaced with release paper to facilitate rapid and clean application at a controlled thickness.

Pretest for adhesion is intended to eliminate potential field problems by testing Hk312 Sealant Tape with samples of material surfaces on which it will be applied. This testing will aid in determining the proper surface preparation, if any, that will be necessary prior to tape sealant application.

Storage: Keep in cool, dry location. HK312 has a six month shelf life from date of manufacture when stored at or below 70°F (21°C).

NOTE: Technical information furnished by HAWKEYE is based upon laboratory findings and are believed to be correct. No warranties of any kind are made except that materials supplied are HAWKEYE standard quality. All risk and liability arising from handling, storage and use of HAWKEYE products, as well as compliance with applicable legal restrictions rests with the buyer.

## DATA SHEET

# HK312G SEALANT TAPE

HAWKEYE HK312G SEALANT TAPE is a grey, aggressively tacky rubber-based sealant with excellent cohesive and adhesive properties. It was developed as a universal sealant for sealing all films, especially nylon to the mold in the vacuum bag curing of plastic and metal parts in the aircraft and aerospace industries. It is also used in the vacuum bag curing of adhesive bonded sandwich and honeycomb panels. On exposure to curing temperatures ranging from 250 degrees F to 400 degrees F (121 - 214 degrees C), this product cures to a tough elastic rubber, making it easily stripped from the tool while still warm; eliminating down-time waiting for the tool to cool to room temperature.

HK312G Sealant Tape is designed to strip clean from bare metal and epoxy resin tools with or without a release or parting agent pre-treatment. HK312 should be pre-tested with each individual; release or parting agent to assure that it will strip from the coated metal without leaving a residue.

HK312G Sealant Tape has aggressive tack at application temperatures, as low as minus 35 degrees F (-37 degrees C). It is formulated without solvents, eliminating fire hazard and shrinkage. The sealant tape will deform under slight pressure to fill irregularities, voids and spaces in tools and dies.

HK312G Sealant Tape is extruded in ribbon form. The standard size is 1/8" X 1/2" X 25 ft per roll. Rolls are interlaced with release paper to facilitate rapid and clean application at a controlled thickness.

Pretest for adhesion is intended to eliminate potential field problems by testing Hk312 Sealant Tape with samples of material surfaces on which it will be applied. This testing will aid in determining the proper surface preparation, if any, that will be necessary prior to tape sealant application.

Storage: Keep in cool, dry location. HK312 has a six month shelf life from date of manufacture when stored at or below 70°F (21°C).

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## DATA SHEET

# HK44 SEALANT TAPE

HAWKEYE HK44 Sealant Tape is a light-gray, aggressively tacky, medium to high temperature sealant tape. Designed to hold tenaciously to all types of bagging films, especially nylon, HK44 Sealant Tape cures to an elastic rubber, making it easily stripped from metal or plastic tools without leaving a residue.

HK44 Sealant Tape was designed for a temperature range of 225 degrees F to 425 degrees F (107 - 218 Degrees C). It is made of 100% solids, therefore it has no odor, toxicity, bleeding or corrosive reaction with any of your tools.

HK44 Sealant Tape is extruded in ribbon form, 1/8" X 1/2" X 25 ft per roll. Rolls are interlaced with release paper to facilitate rapid and clean application at controlled thickness.

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## DATA SHEET

# HK 45 SEALANT TAPE

HAWKEYE HK45 SEALANT TAPE is a gray, aggressively tacky high temperature butyl rubber base product with excellent cohesive and adhesive properties. It was developed for sealing all films, especially nylon, to the tool in both low and high temperature vacuum bag curing of plastic and metal parts in the aircraft and aerospace industries. It is also used in the vacuum bag curing of adhesive bonded sandwich and honeycomb panels.

HK45 Sealant Tape is sufficiently aggressive to permit application at temperatures as low as minus 35 degrees F (-37 degrees C), and is formulated without solvents, eliminating fire hazard and shrinkage. HK45 will deform under slight pressure to fill irregularities, voids and spaces.

HK45 Sealant Tape cures to a tough, elastic rubber, marking it easily stripped from the tool without leaving a residue, on exposure to temperatures of 325 degrees F to 400 degrees F (163 - 204 degrees C). At temperatures bellow 325 degrees F (163 degrees C), HK45 does not cure completely, but can be stripped due to its hardness and high adhesive strength.

HK45 Sealant Tape is supplied in rolls in the form of extruded ribbons 1/8" X 3/4" X 30' per roll which are interlaced with release paper to facilitate rapid and clean application at a controlled thickness to a desired area.

Other sizes are available upon request.

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## DATA SHEET

# SM5144 SEALANT TAPE

SM5144 Sealant Tape provides maximum adhesion to tool and bagging film while maintain a vacuum on assembled parts during the cure cycle. This was the first tape in the industry to incorporate a color indicator. The indicator imparts a yellow color to the tape before cure and changes to a gray color after cure. It will maintain a secure seal throughout a temperature range of ambient room temperature to 375 degrees F (191 degrees C). It adheres tenaciously to a variety of bagging films.

## SPECIFICATIONS

Color:	Yellow (before cure) Gray (after cure)
Percent Solids:	100%
Consistency (Cone Penetration):	85-95 mm/5 seconds 300 grams load - ASTM D-217
Performance Temperature Range:	Ambient room temperature to 375 degrees F (191 degrees C)
Weight:	10.57 lbs./gallon (4.79 Kg/L)
Storage:	Keep in cool place. Store at or below 80 degrees F (27 degrees C)
Shelf Life:	Six Months from date of manufacture

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## DATA SHEET

# SM5126 SEALANT TAPE

SM5126 SEALANT TAPE is a pressure sensitive sealant in tape form that is ideal for plastic laminating and it has been successfully used with silicone blankets, nylon and PVC films. Compatibility and tenacious adhesion is evidenced on a variety of known tool surfaces. Typical cure cycles requiring a positive bag seal from ambient temperature to 450 degrees F (232 degrees C) are easily accommodated. It will also function well during short cycles such as one hour at ambient temperature. This tape provides a quick, clean and easy method of adhering bagging films too mold platen tools.

## SPECIFICATIONS

Color:	Dark Gray
Consistency:	Moldable rubber-like solid
Solids:	100% (approx.)
Cone Penetration:	85-95 mm/5 seconds 300 grams load - ASTM D-217
Temperature:	Ambient temperature to 450 degrees F (232 degrees C)
Storage:	Store at or below 80 degrees F (26.6 degrees C)
Shelf Life:	Six Months from date of Manufacture

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## DATA SHEET

# HK5601 SEALANT TAPE

HK5601 Sealant Tape is compounded from polyisobutylene and isoprene polymers. Tests indicate that they exhibit aggressive initial adhesion, are easily compressed and will easily accommodate dimensional changes in a detail where movement is anticipated. Physical characteristics are maintained after exposure to ultraviolet radiation and temperature extremes. Atmospheric contamination has little to no effect on the function of these sealant tapes.

Tests indicate that HK5601 Sealant Tape exhibits resistance to ultraviolet and infrared radiation, precipitation, atmospheric hydrocarbon contamination and extremes in temperature. Clean substrates are required for optimum adhesion.

### SPECIFICATIONS

Color:	Gray
Consistency:	Soft Tacky Rubber
Cone Penetration: per ASTM D-217	101-115mm/5 seconds 300 gram load
Percent Solids:	100%
Elongation per ASTM D 1191	500% Minimum
Service Temperature Range	-17.77 to 82.22 Degrees C
Shelf Life:	18 Months from date of manufacture when stored in original container at or below below 80° F (26.67 ° C)
Crazing to Acrylic Plastic (MIL S-11030 C Para 4.5.7):	None
Peel Strength (AAMA 800.92)	7-10 P.I.W. - 95% cohesive separation

### SPECIFICATION COMPLIANCE

AAMA SPECIFICATION:	AAMA 807.3.92
Reference Standards:	ANSI/AAMA 101-85 ANSI/AAMA 1002.10-83

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## DATA SHEET

# HK603 SEALANT TAPE

HK603 Sealant Tape is light grey in color and compounded from polyisobutylene and isoprene polymers. Tests indicate that they exhibit aggressive initial adhesion, are easily compressed and will easily accommodate dimensional changes in a detail where movement is anticipated. Physical characteristics are maintained after exposure to ultraviolet radiation and temperature extremes. Atmospheric contamination has little to no effect on the function of these sealant tapes.

Tests indicate that HK603 Sealant Tape exhibits resistance to ultraviolet and infrared radiation, precipitation, atmospheric hydrocarbon contamination and extremes in temperature. Clean substrates are required for optimum adhesion.

## SPECIFICATIONS

Color:	Light Gray
Consistency:	Soft Tacky Rubber
Cone Penetration:	101-115mm/5 seconds
per ASTM D-217	300 gram load
Percent Solids:	100%
Elongation per ASTM D 1191	500% Minimum
Service Temperature Range	-17.77 to 82.22 Degrees C
Shelf Life:	18 Months from date of manufacture when stored in original container at or below below 80 Degrees F (26.67 Degrees C)
Crazing to Acrylic Plastic (MIL S-11030 C Para 4.5.7):	None
Peel Strength (AAMA 800.92)	7-10 P.I.W. - 95% cohesive separation

## SPECIFICATION COMPLIANCE

AAMA SPECIFICATION:	AAMA 807.3.92
Reference Standards:	ANSI/AAMA 101-85 ANSI/AAMA 1002.10-83

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## DATA SHEET

# HK621 SEALANT TAPE

HK621 SEALANT TAPE is a pressure sensitive sealant in tape form that is ideal for plastic laminating and it has been successfully used with silicone blankets, nylon and PVC films. Compatibility and tenacious adhesion is evidenced on a variety of known tool surfaces. Typical cure cycles requiring a positive bag seal from ambient temperature to 450 degrees F (232 degrees C) are easily accommodated. It will also function well during short cycles such as one hour at ambient temperature. This tape provides a quick, clean and easy method of adhering bagging films to mold platen tools.

## SPECIFICATIONS

Color:	Dark Gray
Consistency:	Moldable rubber-like solid
Solids:	100% (approx.)
Cone Penetration:	85-95 mm/5 seconds 300 grams load - ASTM D-217
Temperature:	Ambient temperature to 450 degrees F (232 degrees C)
Storage:	Store at or below 80 ° F (26.6° C)
Shelf Life:	Six Months from date of Manufacture

NOTE: Technical information furnished by HAWKEYE is based on laboratory findings and is believed to be correct. No warranties of any kind are made except that materials supplied are HAWKEYE standard quality. All risk and liability arising from handling, storage and use of HAWKEYE products, as well as compliance with applicable legal restrictions rests with the buyer.

## DATA SHEET

# HK600 SEALANT TAPE

HK600 SEALANT TAPE is an extremely tough and reliable vacuum bagging sealant. It is used to maintain full vacuum on all cure cycles; up to temperatures as high as 600 degrees F (315 degrees C). HK600 will hold a full vacuum through the complete cycle down to room temperature. It is noted for its high tack and adhesion to all standard vacuum bagging film and tools.

## SPECIFICATIONS

Cure Cycle:	Room Temperature to 600 degrees F (315 degrees C)
Heat Source:	Autoclave, oven or portable heating device
Stripability:	Excellent
Film Tack:	Excellent on all films tested
Tool Tack	Excellent
Pleats:	Easy to seal (eg. thermal couple wires and vacuum probes)
Vacuum:	Will maintain 26" (or better) of mercury through all cycles down to room temperature
Cohesive Strength:	Excellent
Size:	1/8" X 1/2" X 30 ft roll

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# HK780 SEALANT TAPE

HAWKEYE HK780 SEALANT TAPE is a red-orange aggressive sealant designed primarily for high temperature applications. The strong adhesion of this material makes it possible for the tape to adhere at room temperature, thus eliminating the need for a secondary sealant.

HK780 SEALANT TAPE is extruded in ribbon form. The standard roll size is 1/8" X 1/2" X 30 feet per roll. Rolls are interlaced on release paper to aid in faster and more efficient application.

The versatility of this product makes it possible to use at room temperature continuously to 840° F (448° C).

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## DATA SHEET

# SM5150 SEALANT TAPE

SM5150 is an elevated temperature sealant tape. It is a beige colored tape that is easily moldable, exhibits good adhesion to most tool surfaces and adheres tenaciously to polyimide films. It is designed to function throughout a temperature range of ambient room temperature to 600°F. Extended cure cycles requiring twelve (12) hours are easily accommodated.

### SPECIFICATIONS

Color:	Beige
Consistency:	Moldable rubber-like solid
Solids	100% (approx)
Temperature:	Ambient temperature to 600°F (315°C)
Storage:	Store at or below 80°F (26.6°C)
Shelf Life:	Six Months from date of manufacture

NOTE: Technical information furnished by HAWKEYE is based on laboratory findings and is believed to be correct. No warranties of any kind are made except that materials supplied are HAWKEYE standard quality. All risk and liability arising from handling, storage and use of HAWKEYE products, as well as compliance with applicable legal restrictions rests with the buyer.

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## DATA SHEET

# HK515 SEALANT TAPE

HK515 is an elevated temperature sealant tape. It is a beige colored tape that is easily moldable, exhibits good adhesion to most tool surfaces and adheres tenaciously to polyimide films. It is designed to function throughout a temperature range of ambient room temperature to 600°F. Extended cure cycles requiring twelve (12) hours are easily accommodated.

### SPECIFICATIONS

Color:	Beige
Consistency:	Moldable rubber-like solid
Solids	100% (approx)
Temperature:	Ambient temperature to 600°F (315°C)
Storage:	Store at or below 80°F (26.6°C)
Shelf Life:	Six Months from date of manufacture

NOTE: Technical information furnished by HAWKEYE is based on laboratory findings and is believed to be correct. No warranties of any kind are made except that materials supplied are HAWKEYE standard quality. All risk and liability arising from handling, storage and use of HAWKEYE products, as well as compliance with applicable legal restrictions rests with the buyer.

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## DATA SHEET

### HK603 SEALANT TAPE

HK603 Sealant Tape is light grey in color and compounded from polyisobutylene and isoprene polymers. Tests indicate that they exhibit aggressive initial adhesion, are easily compressed and will easily accommodate dimensional changes in a detail where movement is anticipated. Physical characteristics are maintained after exposure to ultraviolet radiation and temperature extremes. Atmospheric contamination has little to no effect on the function of these sealant tapes.

Tests indicate that HK603 Sealant Tape exhibits resistance to ultraviolet and infrared radiation, precipitation, atmospheric hydrocarbon contamination and extremes in temperature. Clean substrates are required for optimum adhesion.

### SPECIFICATIONS

Color:	Light Gray
Consistency:	Soft Tacky Rubber
Cone Penetration:	101-115mm/5 seconds
per ASTM D-217	300 gram loan
Percent Solids:	100%
Elongation per ASTM D 1191	500% Minimum
Service Temperature Range	-17.77 to 82.22° C
Shelf Life:	18 Months from date of manufacture when stored in original container at or below below 80 Degrees F (26.67 Degrees C)
Crazing to Acrylic Plastic (MIL S-11030 C Para 4.5.7):	None
Peel Strength (AAMA 800.92)	7-10 P.I.W. - 95% cohesive separation

### SPECIFICATION COMPLIANCE

AAMA SPECIFICATION:	AAMA 807.3.92
Reference Standards:	ANSI/AAMA 101-85 ANSI/AAMA 1002.10-83

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## DATA SHEET

# HK151 SEALANT TAPE

HK151 Sealant Tape is a selective cure bag sealant tape with a built-in color indicator. This tape will function from ambient room temperature to 375°F (191°C). A positive vacuum of 100 psi is easily maintained during autoclave cycles. HK151 tape is pink in color before cure and dark maroon after cure.

### SPECIFICATIONS

Color:	
Before cure:	Pink
After Cure:	Dark Maroon
Percent Solids:	100%
Consistency:	
Cone Penetration:	85-95mm/5 seconds 300 grams load ASTM D-217
Performance Temperature Range:	Ambient room temperature to 375°F (191°C)
Weight per Gallon:	10.48 lbs/gallon (1.25 kg/l)
Storage:	Keep in cool, dry place. HK151 Sealant Tape has a 6 month shelf life from date of manufacture when stored at or below 80°F (27°C).

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# HK90 SEALANT TAPE

HK90 Sealant Tape is a 100% solids, asbestos-free butyl tape sealant that can best be described as a highly rubbery, tacky, reinforced compound ideal for room temperature vacuum bagging. This tape sealant is easy to apply and compress during installation. It exhibits excellent application and performance characteristics over a wide temperature range and will not become brittle, crack or flow under normal use. It is available in various sizes supplied on easy to use rolls.

HK90 Sealant Tape exhibits resistance to ultraviolet and infrared radiations, precipitation, atmospheric hydrocarbon contamination and extremes in temperature. It has adhesion to the metals and paint finishes typically found in metal building construction and will not stain these surfaces. Shelf life is eighteen (18) months when stored in a dry place where temperature does not exceed 100°F (38°C).

Optimally a clean dry uncontaminated surface is desired to obtain intimate adhesion, but realistically there are situations that prevent complete control of surface conditions. Excessive oil, caked-on dirt and water must be removed. Do not apply tape sealant to wet or frost bearing surfaces.

### SPECIFICATIONS

Specific Gravity - ASTM D792:	1.47		
Density (lbs/gal):	12.24		
(Kg/liter)	1.47		
Percent Solids:	100%		
Peel Adhesion (AAMA 800)			
Galvalume®	16 (2.8)/100	Siliconized Polyester	16 (2.8)/100
Anodized Aluminum	16 (2.8)/100	Polyester	16 (2.8)/100
Mill Finish Aluminum	16 (2.8)/100	PVC Plastisol	17 (3.0)/100
Polyvinylidene Fluoride	17 (3.0)/100		
Tensile Adhesive Strength			
PSI (k Pa)/% Cohesive Separation	20 (138)/95		
Yield Strength PSI(k Pa) (ASTM C907)	8 (55)		
% Elongation ASTM C908	> 1000		
Sage (AAMA 800)	None		
Vehicle Migration (AAMA 800)	Pass <1/8" (<3.175 mm)		
Water Resistance (AAMA 800)	No effects		
Hardness (Shore 00) (AAMA 800)	50 to 60		
Crazing to Acrylic Plastics (MIL-S-11030C)	None		
Cone Penetration (0.1mm) (ASTM D217)			
@77°F (25°C)	85-100		
@120°F (48.8°C)	125-135		
@0°F (-17.7°C)	45-55		
Application Temperature Range	-5° to 120°F (-20° to 49°C)		
Service Temperature Range	-40° to 180°F (-40° to 82°C)		
Color:	Gray		
Weatherability:	Excellent		
QUV, 340A Lamps	No Cracking		
1000 Hours	No Chalking, No Wash-off, No Flow (Sag)		

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## DATA SHEET

# HK5229 LOW TEMPERATURE SEALANT TAPE

HK5229 is a 100% solids, asbestos-free butyl tape sealant designed for projects where cost is the primary consideration. It is easy to apply and compress during installation. It exhibits excellent resistance to water, extremes in climatic temperature and atmospheric contamination. This tape provides a good vacuum seal for debulking and oven cures to 180°F (82°C).

### SPECIFICATIONS

Specific Gravity (ASTM D792)	1.48
Percent Solids	100%
% Elongation (ASTM C908)	200% min
Hardness (Shore 00) (AAMA800)	60 to 70
Use Temperature Range	-25 to 180°F (-32 to 82°C)
Yield Strength Psi (Kpa) (ASTM C908)	8 (55)
Color:	Gray
Odor:	None

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## DATA SHEET

# SM5127 SEALANT TAPE

SM5127 SEALANT TAPE is a black, aggressively tacky rubber-based sealant with excellent cohesive and adhesive properties. It was developed as a universal sealant for sealing all films, especially nylon to the mold in the vacuum bag curing of plastic and metal parts in the aircraft and aerospace industries. It is also used in the vacuum bag curing of adhesive bonded sandwich and honeycomb panels. On exposure to curing temperatures ranging from 250 degrees F to 400 degrees F (121 - 214 degrees C), this product cures to a tough elastic rubber, marking it easily stripped from the tool while still warm; eliminating down-time waiting for the tool to cool to room temperature.

SM5127 Sealant Tape is designed to strip clean from bare metal and epoxy resin tools with or without a release or parting agent pre-treatment. SM5127 should be pre-tested with each individual; release or parting agent to assure that it will strip from the coated metal without leaving a residue.

SM5127 Sealant Tape has aggressive tack at application temperatures, as low as minus 35 degrees F (-37 degrees C). It is formulated without solvents, eliminating fire hazard and shrinkage. The sealant tape will deform under slight pressure to fill irregularities, voids and spaces in tools and dies.

SM5127 Sealant Tape is extruded in ribbon form. The standard size is 1/8" X 1/2" X 30 ft per roll. Rolls are interlaced with release paper to facilitate rapid and clean application at a controlled thickness.

Pretest for adhesion is intended to eliminate potential field problems by testing SM5127 Sealant Tape with samples of material surfaces on which it will be applied. This testing will aid in determining the proper surface preparation, if any, that will be necessary prior to tape sealant application.

Storage: Keep in cool, dry location. SM5127 has a six month shelf life from date of manufacture when stored at or below 70°F (21°C).

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## DATA SHEET

# HK7200 Sealant Tape

HK7200 is designed for use as a general purpose sealant tape. It offers good weathering characteristics, flexibility at -30°F, sag resistance at 200°F and excellent resistance to water.

### TYPICAL PHYSICAL PROPERTIES AND GENERAL INFORMATION

<u>Property</u>	<u>Value</u>
Raw Material Base	Synthetic Resin
Cone Penetration @ 77°F, 300G	7.8mm
Color	Black
Specific Gravity	1.45
Webbing and Elongation	620%
Shelf Life	One Year
Form & Packaging	Tape Rolls
Physical State	Solid
Odor	Neutral

### STORAGE AND HANDLING

It is suggested that the material be stored in a cool, dry area in the original sealed containers until used. No special handling is required.

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## DATA SHEET

# HK5227 ROOM TEMPERATURE SEALANT TAPE

HK5227 Room Temperature Sealant Tape has been used in the aerospace industry and composite manufacturing as a debulking tape in vacuum bag applications that require no heating or curing. The tape is formulated to seal most films to tools while positive vacuum is held for room temperature applications.

HK5227 is easily applied by hand. It is tenacious to most films and tool surfaces and strips cleanly from tool surfaces at room temperature.

## SPECIFICATIONS

Color:	Grey
Percent Solid:	100%
Consistency: Cone Penetration:	85-100 300 gram load ASTM D-217
Weight/Gallon	13.54 lbs/gal (1.62 Kg/L)
Freight Classification:	Caulking Compound NOIBN (No label required)
Storage:	Keep in a cool dry place HK5227 has an 18 month shelf life from date Of manufacture when stored at or below 80° F (27°C). Do not store cartons on end, keep flat.
Performance Temperature Range	
Application Temperature	45°F (7°C) to 120°F (49°C)
Service Temperature	45°F (7°C) to 120°F (49°C)

NOTE: Technical information furnished by HAWKEYE is based upon laboratory findings and are believed to be correct. No warranties of any kind are made except that materials supplied are HAWKEYE standard quality. All risk and liability arising from handling, storage and use of HAWKEYE products, as well as compliance with applicable legal restrictions rests with the buyer.

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## DATA SHEET

### HK7191 SEALANT TAPE

HK917 is a sealant tape developed for use in vacuum bagging. It will maintain an air-tight seal during the cure cycle, then strip clean from the mold during de-bagging. The tape has an optimum cure temperature range of 250°F (121°C) to 375°F (191°C).

HK917 is easy to apply by hand with easy clean-up after curing. HK917 is ideal for oven or autoclave cures.

#### SPECIFICATIONS

Color:	Gray
Application Temperature	45°F (7°C) to 120°F (49°C)
Service Temperature:	250°F (121°C) to 375°F (191°C).
Percent Solid	100%
Consistency	90-95
Cone Penetration	300 GRAM Load ASTM D-217
Weight/Gallon	10.2 lbs per gallon (1.22 Kg/L)
Freight Classification:	Caulking compound NOIBN
Storage:	Keep in cool dry place
Shelf Life:	6 months from DOM when stored at or below 80°F (27°C)

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## DATA SHEET

### HK917 SEALANT TAPE

HK917 is a sealant tape developed for use in vacuum bagging. It will maintain an air-tight seal during the cure cycle, then strip clean from the mold during de-bagging. The tape has an optimum cure temperature range of 250°F (121°C) to 375°F (191°C).

HK917 is easy to apply by hand with easy clean-up after curing. HK917 is ideal for oven or autoclave cures.

#### SPECIFICATIONS

Color:	Gray
Application Temperature	45°F (7°C) to 120°F (49°C)
Service Temperature:	250°F (121°C) to 375°F (191°C).
Percent Solid	100%
Consistency	90-95
Cone Penetration	300 GRAM Load ASTM D-217
Weight/Gallon	10.2 lbs per gallon (1.22 Kg/L)
Freight Classification:	Caulking compound NOIBN
Storage:	Keep in cool dry place
Shelf Life:	6 months from DOM when stored at or below 80°F (27°C)

NOTE: Technical information furnished by HAWKEYE is based upon laboratory findings and are believed to be correct. No warranties of any kind are made except that materials supplied are HAWKEYE standard quality. All risk and liability arising from handling, storage and use of HAWKEYE products, as well as compliance with applicable legal restrictions rests with the buyer.

