



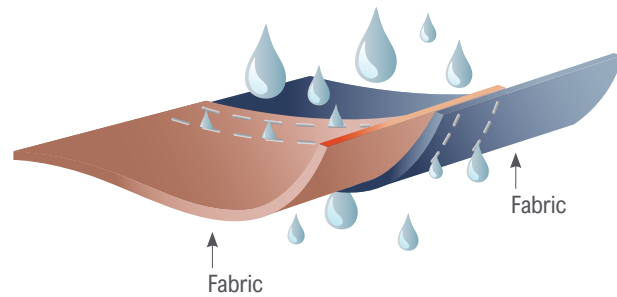
THREE-LAYER SEAM TAPE SELECTOR GUIDE



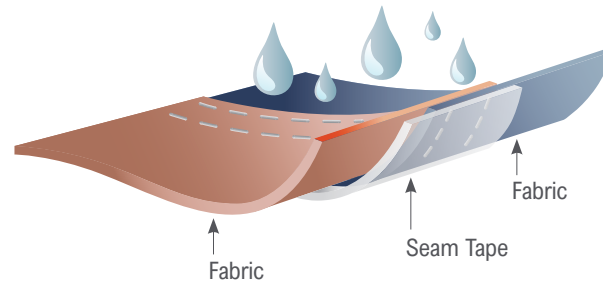
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WATERPROOF PROTECTION FROM HEAD TO TOE

WITHOUT SEAM TAPE



WITH SEAM TAPE



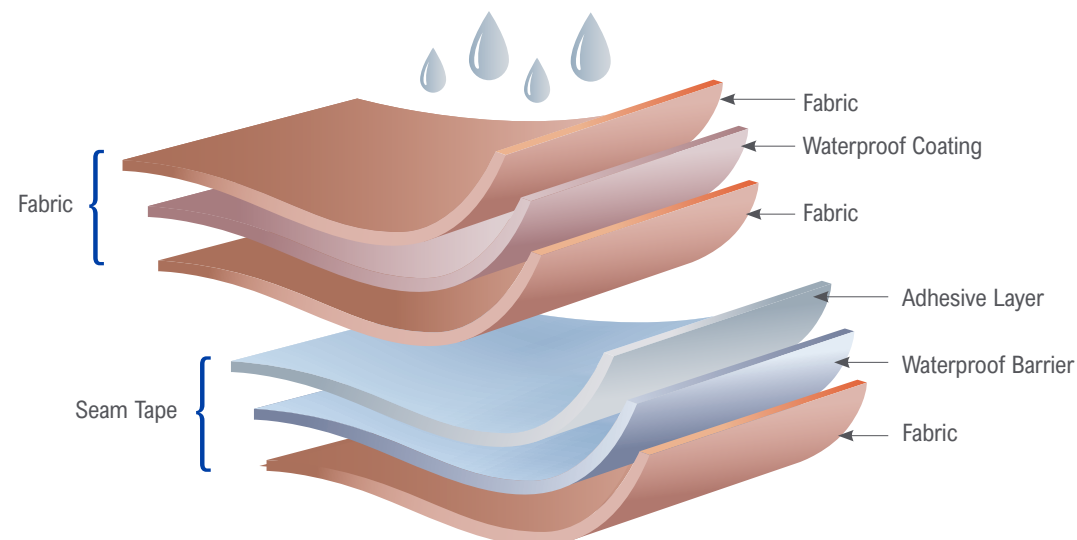
SEAM TAPE IS THE CRITICAL LINK IN THE CHAIN OF WATERPROOF PROTECTION.



Even the most waterproof fabrics and materials will leak through stitched seams if not sealed properly. If a product leaks, customers don't care if it's from the fabric or the seam – all they know is they're getting wet. When you want to keep a sewn product watertight and protect the integrity of your weather-worthy gear, use Bemis Seam Tape to cover up those needle holes.

Three-Layer Seam Tape is the go-to for heavy-duty uses. It holds up to the weight of thicker fabrics and conditions, providing a reliable, durable, flexible seal. With waterproofing solutions for a variety of three-layer fabrics and materials that use a wide array of coatings, our range of Three-Layer Seam Tapes are the key and can be applied by using any of the commercially available hot air taping machinery. Be confident that your waterproof garments and equipment will weather the storm from drizzle to downpour.

3-LAYER WATERPROOF APPLICATION

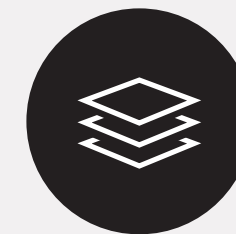


BEMIS THREE-LAYER SEAM TAPES ADHERE TO A WIDE VARIETY OF THREE-LAYER FABRICS AND MATERIALS AND ARE PROVEN IN MANY APPLICATIONS:

- Technical Outerwear & Activewear: skiing, snowboarding, hiking, climbing, fishing, boating, hunting, etc.
- Rainwear
- Industrial Workwear
- Tents & Packs
- Military Garments & Gear
- Footwear
- Protective Suits & Equipment



WATERPROOF



FOR MEDIUM TO HEAVY WEIGHT FABRICS





DURABILITY

BEMIS THREE-LAYER SEAM TAPES ARE CERTIFIED TO THE OEKO-TEX STANDARD 100 AND ARE DEVELOPED TO MEET BRAND'S RESTRICTED SUBSTANCE REQUIREMENTS.



CALL YOUR BEMIS SALES REPRESENTATIVE FOR MORE INFORMATION AND SAMPLES

TECHNICAL DATA

	ST306	ST325	ST356	ST356RC 	ST360	ST390RC 
PRODUCT OVERVIEW						
Key Benefits + Material Adhesion	-Minimal stretch -Tricot fabric backer -Medium to heavy weight 3L fabrics with Polyurethane membrane	-Minimal stretch -Minimal footprint -Tricot fabric backer -Light to medium weight 3L fabrics with Polyurethane membrane	-Soft and stretchable -Minimal footprint -Good for heat sensitive fabrics -Jersey fabric backer -Light to medium weight 3L stretch fabrics with Polyurethane membrane	Recycled Choice: made with post-consumer recycled polyester, 14% recycled content by overall weight -Soft and stretchable -Minimal footprint -Good for heat sensitive fabrics -Recycled Jersey fabric backer -Light to medium weight 3L stretch fabrics with Polyurethane membrane	-Soft and stretchable -Minimal footprint -Best for heat sensitive fabrics -High wash durability -Jersey fabric backer -Light to medium weight 3L stretch fabrics with Polyurethane membrane	Recycled Choice: made with post-consumer recycled polyester, 11% recycled content by overall weight -Soft with best stretch -Minimal footprint -Good for heat sensitive fabrics -Recycled Jersey fabric backer -Light to medium weight 3L stretch fabrics with Polyurethane membrane
Compliance / Certification	OEKO-TEX®	OEKO-TEX®	OEKO-TEX®	Fabric yarn is GRS Certified	OEKO-TEX®	Fabric yarn is GRS Certified
Stocked Color(s)	Grey ¹	Grey ¹	Black, Grey ¹	Black, Grey ²	Black, Grey	Black, Grey ²
THERMAL & PHYSICAL PROPERTIES						
Composition	Polyurethane / Nylon Tricot	Polyurethane / Nylon Tricot	Polyurethane / Polyester Jersey	Polyurethane / Recycled Polyester Jersey	Polyurethane / Polyester Jersey	Polyurethane / Recycled Polyester Jersey
Adhesive Gauge	152 µm (.006")	165 µm (.0065")	152 µm (.006")	152 µm (.006")	152 µm (.006")	140 µm (.0055")
Total Gauge³	330 µm (.013")	305 µm (.012")	381 µm (.015")	533 µm (.021")	405 µm (.016")	381 µm (.015")
Total Weight⁴	223 g/m ²	228 g/m ²	213 g/m ²	213 g/m ²	285 g/m ²	260 g/m ²
Softening Point	92°C (197°F)	90°C (194°F)	85°C (185°F)	85°C (185°F)	75°C (167°F)	87°C (189°F)
PERFORMANCE						
Modulus at 20% elongation	13mm: 5.19 lbf/in	13mm: 3.7 lbf/in	13mm: 2.68 lbf/in	13mm: 2.16 lbf/in	13mm: 2.4 lbf/in	13mm: 1.2 lbf/in
	20mm: 10.14 lbf/in	20mm: 7.23 lbf/in	20mm: 5.24 lbf/in	20mm: 4.22 lbf/in	20mm: 4.69 lbf/in	20mm: 2.54 lbf/in
Modulus at 40% elongation	13mm: 9.79 lbf/in	13mm: 6.61 lbf/in	13mm: 5.28 lbf/in	13mm: 3.62 lbf/in	13mm: 3.6 lbf/in	13mm: 1.9 lbf/in
	20mm: 19.13 lbf/in	20mm: 12.91 lbf/in	20mm: 10.32 lbf/in	20mm: 7.07 lbf/in	20mm: 7.03 lbf/in	20mm: 4.01 lbf/in
Recovery at 50%	97%	98%	97%	98%	98%	98%
Wash Durability	up to 40°C	up to 40°C	up to 40°C	up to 40°C	up to 40°C	up to 40°C
RECOMMENDED SEALING CONDITIONS⁵						
HOT AIR SEALER						
Temperature	550°C to 700°C	550°C to 700°C	450°C to 600°C	450°C to 600°C	420°C to 660°C	450°C to 600°C
Time	2.5 to 3.0 m/min	2.5 to 3.0 m/min	2.0 to 3.0 m/min	2.0 to 3.0 m/min	2.0 to 3.0 m/min	2.0 to 3.0 m/min
Pressure	4.0 bar	4.0 bar	3.92 bar	4.0 bar	3.4 to 4.2 bar	3.4 to 4.2 bar
FLAT PRESS (REPRESS CONDITION)						
Temperature	130°C to 150°C	130°C to 150°C	130°C to 150°C	130°C to 150°C	130°C to 150°C	130°C to 150°C
Time	8 to 15 seconds	5 to 8 seconds	5 to 8 seconds	5 to 8 seconds	5 to 8 seconds	5 to 8 seconds
Pressure⁶	30 to 60 psi (2.0 to 4.1 bar)	30 to 60 psi (2.0 to 4.1 bar)	30 to 60 psi (2.0 to 4.1 bar)	30 to 60 psi (2.0 to 4.1 bar)	30 to 60 psi (2.0 to 4.1 bar)	30 to 60 psi (2.0 to 4.1 bar)
Cool Press Time	3 to 5 seconds	3 to 5 seconds	3 to 5 seconds	3 to 5 seconds	3 to 5 seconds	3 to 5 seconds

Products may be stocked in various widths or can be slit to requested widths - please contact a Bemis Sales Representative for details.

1. Custom colors may be available for partner brands.

2. Custom colors may be available.

3. Total Gauge may vary slightly by color.

4. Total Weight may vary slightly by color.

5. Recommended bonding conditions will vary between machinery, fabrics, and applications - optimal bonding conditions should be established by Bemis and the customer for each application prior to production.

6. Effective pressure depends on the actual size of reinforced area.



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