

LEXCAN

# HI-FLEX EPDM

## T-325 Seam Tape

### DESCRIPTION & USE

Lexcan Hi-Flex EPDM T-325 Seam Tape is a cross-linked compound of synthetic rubbers and adhesives manufactured into a "peel n' stick" tape form. It is available in 76 mm (3") and 152 mm (6") widths, with a clear poly release liner.

T-325 Seam Tape is used in conjunction with Hi-Flex EPDM's PA-100 Primer Adhesive or Hi-Flex EPDM's SA-747 Seam Adhesive to splice EPDM membrane rolls (end and side laps) together as part of the LexSeam™ seaming method. Applied properly, T-325 Seam Tape forms a permanent, vapour proof and waterproof seam.

**CAUTION:** Proper EPDM 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 & BENEFITS

- **Consistent Adhesive Thickness** - Unlike a liquid adhesive, use of the T-325 Seam Tape ensures a consistent mass of adhesive is applied along the length of the seam.
- **Superior Strength** - The LexSeam seam, featuring Lexcan T-325 Seam Tape, is up to 100% stronger in peel and shear strength than adhesive only seams and up to 32% stronger than other tape systems on the market.
- **Easy to Apply** - The clear poly release paper allows the applicator to easily align the tape with the edge of the membrane or chalk mark. Application is quick and efficient.
- **Reliable Performance** - Lexcan has been using seam tapes with its EPDM roofing systems since it invented EPDM roof systems back in the early 1960's. Thousands of kilometers of LexSeam seams continue to perform flawlessly, year after year.

### TECHNICAL DATA

Physical Properties - Black	
<b>Base:</b>	Synthetic Rubber
<b>Colour:</b>	Black
<b>Thickness:</b>	0.76 mm (0.30")
<b>Roll Size:</b>	30.4 m (100') Long
<b>Shelf Life</b>	1 Year
<b>Packaging:</b>	3" - 4 rolls per Case 6" - 2 rolls per Case
<b>Weight:</b>	12 kg (26 lbs) per Carton



### Physical Properties - White

<b>Base:</b>	Synthetic Rubber
<b>Colour:</b>	Cream
<b>Thickness:</b>	0.76 mm (0.30")
<b>Roll Size:</b>	30.4 m (100') Long
<b>Shelf Life</b>	1 Year
<b>Packaging:</b>	3" - 4 rolls per Case 6" - 2 rolls per Case
<b>Weight:</b>	12 kg (26 lbs) per Carton

### CAUTIONS & LIMITATIONS

- T-325 Seam Tape will lose its initial adhesive tack at cold temperatures (it returns when temperatures are increased). Seam tape should be stored at temperatures 15 °C (60 °F) or above prior to application.
- Prolonged storage at temperatures in excess of 32 °C (90 °F) will reduce the product's shelf life.
- Keep the product dry and out of direct sunlight prior to use.
- Avoid prolonged contact with skin. In case of skin irritation, rinse affected area with soap and water.
- Condensation may form on freshly applied primers or adhesives if the ambient temperature is near the dew point. If condensation develops, the application of primer, adhesive and seam tapes must cease because proper adhesion will not be achieved. Once condensation ceases to occur, the application may continue. Apply a thin re-coat to previously coated areas with primer or adhesive before continuing.

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# HI-FLEX EPDM

## T-325 Seam Tape

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### INSTALLATION INSTRUCTIONS

Lexcan accepts alternative seaming methods. The advantages of the different methods are briefly detailed below.

#### Preferred Application Method

This method is easier for ensuring that a proper width of seam tape extends out from the edge of the seam.

NOTE: T-325 Seam Tape must be used in conjunction with either Hi-Flex EPDM PA-100 Primer Adhesive or Hi-Flex EPDM SA-747 Splice Adhesive. See 'Step 4' on the back page.

1. Overlap the 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. Fold the upper membrane back approximately 60 cm (2') to expose the underside area that will receive the Seam Tape.
3. Ensure areas to receive the Seam Tape are clean and free of excessive dust, dirt, grease and oil.
4. Apply either Hi-Flex EPDM PA-100 Primer Adhesive or Hi-Flex EPDM SA-747 Splice Adhesive.
5. Unroll approximately 1 m (3') of T-325 Seam Tape. Align it with the outside edge of the folded, upper EPDM panel, allowing the tape to extend approximately 3 mm (1/8") beyond. Press it down onto the underside of the sheet using hand pressure. Continue over the length of the splice, lapping Seam Tape roll ends a minimum of 25 mm (1"), when necessary.
6. While the poly backing is still on, roll the upper surface of the Seam Tape heavily with a steel hand roller. Roll lengthwise along the tape to force out air bubbles.
7. Unfold the upper EPDM membrane sheet and let fall neatly over top of the lower sheet, without wrinkles or folds.
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 steel hand roller to force out any trapped air bubbles.
10. Ensure that the edge of the Seam Tape edge extends out from the seam along its entire length.
11. Apply Hi-Flex EPDM Lap Sealant and/or Hi-Flex EPDM LexFlash II Flashing where required in Lexcan specifications and details.

#### Alternative Application Method

1. Overlap the 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") 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 Seam Tape are clean and free of excessive dust, dirt, grease and oil.
4. Apply either Hi-Flex EPDM PA-100 Primer Adhesive or Hi-Flex EPDM SA-747 Splice Adhesive.
5. Unroll approximately 1 m (3') 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 25 mm (1").
6. While the poly backing is still on, roll the upper surface of the Seam Tape heavily with a steel hand roller. Roll lengthwise along the tape to force out air bubbles.
7. Unfold the upper EPDM membrane sheet and let fall neatly over top of the lower sheet, without wrinkles or folds.
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 steel hand roller to force out any trapped air bubbles.
10. Ensure that the edge of the Seam Tape edge extends out from the seam along its entire length.
11. Apply Hi-Flex EPDM Lap Sealant and/or Hi-Flex EPDM LexFlash II Flashing where required in Lexcan specifications and details.

**NOTE:** For application with PA-100 or SA-747, please refer to the appropriate data sheet.