

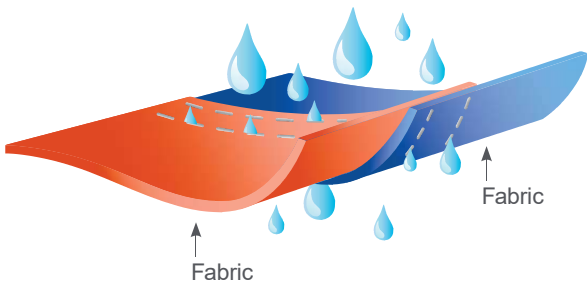
THREE-LAYER SEAM TAPE SELECTOR GUIDE



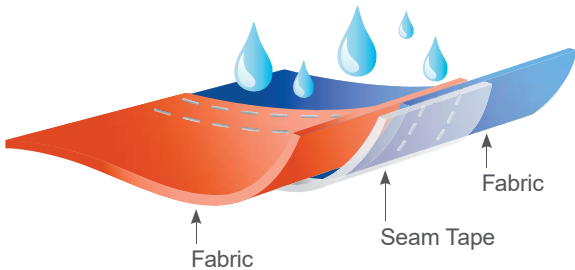
bemisworldwide.com

WATERPROOF PROTECTION FROM HEAD TO TOE

WITHOUT SEAM TAPE



WITH SEAM TAPE



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



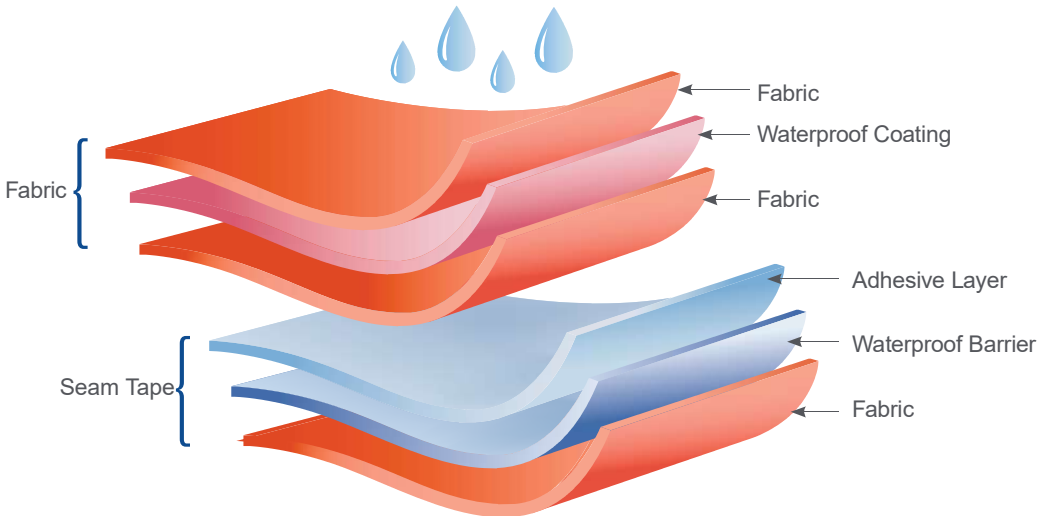
Even the most waterproof fabrics and materials will leak through stitched seams if those seams aren't sealed properly. If a product leaks, customers don't care if the leak is due to the fabric or the seam; all they know is they're getting wet.

Use Bemis Three-Layer Seam Tape to cover needle holes and keep your sewn products watertight.

Three-Layer Seam Tape is ideal for heavy-duty uses. It holds up to the weight of thicker fabrics and conditions, providing a reliable, durable and flexible seal.

Our Three-Layer Seam Tapes can be applied by using commercially available hot air taping machinery.

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, INCLUDING:

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



WATERPROOF



FOR MEDIUM TO HEAVY WEIGHT FABRICS



MINIMAL FOOTPRINT



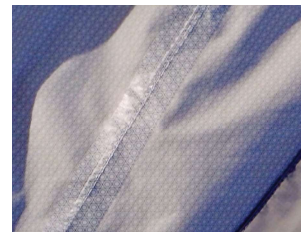
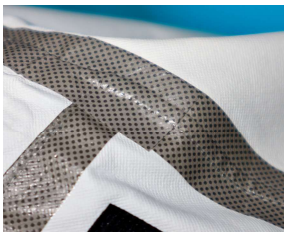
DURABILITY



CUSTOMIZABLE

CUSTOM CAPABILITIES

We offer a wide range of custom color and custom pattern matching capabilities to ensure the Seam Tape doesn't distract from the overall design of your garment or equipment.



STANDARD 100

23.HHK.55668
Hohenstein HTTI

Bemis Three-Layer Seam Tapes are certified to the OEKO-TEX® STANDARD 100 and are developed to meet brands' restricted substance requirements.



Bemis is a bluesign® System Partner with extensive experience providing film and tape solutions.

Contact your Bemis sales representative for more information and samples.



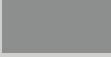

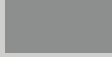


TECHNICAL DATA

ST346RC 

ST356RC 

PRODUCT OVERVIEW

<p>Key Benefits + Material Adhesion</p>	<p>Recycled Choice: Made with post-consumer recycled nylon, 14% recycled content by overall weight.</p> <ul style="list-style-type: none"> • Soft hand feel • Minimal footprint • Waterproof barrier • Adhesive film backer • Light to medium weight 3L fabrics with Polyurethane membrane or with heat sensitivity 	<p>Recycled Choice: Made with post-consumer recycled nylon, 14% recycled content by overall weight.</p> <ul style="list-style-type: none"> • Soft hand feel • Minimal footprint • Good for heat sensitive fabrics • Recycled jersey fabric backer • Light to medium weight 3L stretch fabrics with Polyurethane membrane
<p>Compliance / Certification</p>	<p>Fabric yarn is GRS Certified</p>	<p>Fabric yarn is GRS Certified</p>
<p>Stocked Color(s)</p>	<p>Black PANTONE 19-0508 TPX </p> <p>Light Grey PANTONE 17-1501TCX </p> <p>Grey PANTONE 17-1501TPX </p>	<p>Black PANTONE 19-0508 TPX </p> <p>Grey PANTONE 17-1501TPX </p>
<p>Stocked Width</p>	<p>20 mm / 1372 mm Product can be slit to requested widths</p>	<p>13 mm / 15 mm / 20 mm / 1372 mm Product can be slit to requested widths</p>

THERMAL & PHYSICAL PROPERTIES

<p>Composition</p>	<p>Polyurethane / Recycled Nylon</p>	<p>Polyurethane / Recycled Polyester Jersey</p>
<p>Adhesive Gauge</p>	<p>152 µm (.006")</p>	<p>152 µm (.006")</p>
<p>Total Gauge³</p>	<p>556 µm (.014")</p>	<p>381 µm (0.015")</p>
<p>Total Weight⁴</p>	<p>229 g/m²</p>	<p>213 g/m²</p>
<p>Softening Point</p>	<p>85°C (185°F)</p>	<p>85°C (185°F)</p>

PERFORMANCE

<p>Modulus at 20% Elongation</p>	<p>13 mm: 5.95 lbf/in</p>	<p>13 mm: 2.16 lbf/in</p>
	<p>20 mm: 9.15 lbf/in</p>	<p>20 mm: 4.22 lbf/in</p>
<p>Modulus at 40% Elongation</p>	<p>13 mm: 13.21 lbf/in</p>	<p>13 mm: 3.62 lbf/in</p>
	<p>20 mm: 20.33 lbf/in</p>	<p>20 mm: 7.07 lbf/in</p>
<p>Recovery at 50%</p>	<p>98%</p>	<p>98%</p>
<p>Wash Durability</p>	<p>up to 40°C</p>	<p>up to 40°C</p>

RECOMMENDED SEALING CONDITIONS⁵

HOT AIR SEALER

<p>Temperature</p>	<p>450°C to 660°C</p>	<p>450°C to 600°C</p>
<p>Time</p>	<p>2.0 to 3.0 m/min</p>	<p>2.0 to 3.0 m/min</p>
<p>Pressure</p>	<p>4.0 bar</p>	<p>4.0 bar</p>

FLAT PRESS (REPRESS CONDITION)

<p>Temperature</p>	<p>130°C to 150°C</p>	<p>130°C to 150°C</p>
<p>Time</p>	<p>5 to 8 seconds</p>	<p>5 to 8 seconds</p>
<p>Pressure⁶</p>	<p>30 to 60 psi (2.0 to 4.1 bar)</p>	<p>30 to 60 psi (2.0 to 4.1 bar)</p>
<p>Cool Press Time</p>	<p>3 to 5 seconds</p>	<p>3 to 5 seconds</p>

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.

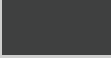
6. Effective pressure depends on the actual size of reinforced area.

TECHNICAL DATA

ST350RC 

ST358RC 

PRODUCT OVERVIEW

Key Benefits + Material Adhesion	<ul style="list-style-type: none"> Soft and stretchable Applied on three-layer waterproof fabrics With a thick fabric lining 	<p>Recycled Choice: Made with post-consumer recycled polyester, 14% recycled content by overall weight.</p> <ul style="list-style-type: none"> Soft hand feel Minimal footprint Waterproof barrier Adhesive film backer Light to medium weight 3L fabrics with Polyurethane membrane or with heat sensitivity
Compliance / Certification	Fabric yarn is GRS Certified	Fabric yarn is GRS Certified
Stocked Color(s)	<p>Black PANTONE 19-0508TPX</p> 	Custom color
Stocked Width	13 mm / 20 mm / 1372 mm Product can be slit to requested widths	1372 mm Product can be slit to requested widths

THERMAL & PHYSICAL PROPERTIES

Composition	Recycled Polyester Jersey / Polyurethane Barrier / Polyurethane Adhesive	Recycled Polyester Jersey / Polyurethane Barrier / Polyurethane Adhesive
Adhesive Gauge	356 µm (.014")	203 µm (.008")
Total Gauge ³	394 µm (.015")	559 µm (.022")
Total Weight ⁴	393 g/m ²	267 g/m ²
Softening Point	85°C (185°F)	85°C (185°F)

PERFORMANCE

Modulus at 20% elongation	13 mm: 3.68 lbf/in	13 mm: 2.02 lbf/in
	20 mm: 5.86 lbf/in	20 Mm: 3.31 lbf/in
Modulus at 40% elongation	13 mm: 6.15 lbf/in	13mm: 3.33 lbf/in
	20 mm: 9.77 lbf/in	20mm: 5.42 lbf/in
Recovery at 50%	98%	98%
Wash Durability	up to 40°C	up to 40°C

RECOMMENDED SEALING CONDITIONS⁵

HOT AIR SEALER

Temperature	450°C to 600°C	450°C to 600°C
Time	2.0 to 3.0 m/min	2.0 to 3.0 m/min
Pressure	4.0 bar	3.92 bar

FLAT PRESS (REPRESS CONDITION)

Temperature	130°C to 150°C	130°C to 150°C
Time	5 to 8 seconds	5 to 8 seconds
Pressure ⁶	10 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

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.

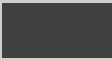

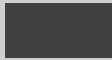

6. Effective pressure depends on the actual size of reinforced area.

TECHNICAL DATA

ST360RC 

ST390RC 

PRODUCT OVERVIEW

Key Benefits + Material Adhesion	<ul style="list-style-type: none"> 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 	<p>Recycled Choice: Made with post-consumer recycled polyester, 11% recycled content by overall weight</p> <ul style="list-style-type: none"> 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	Fabric yarn is GRS Certified	Fabric yarn is GRS Certified
Stocked Color(s)	<p>Black PANTONE 19-0508 TPX </p> <p>Grey PANTONE 17-1501TPX </p>	<p>Black² PANTONE 19-0508 TPX </p> <p>Grey PANTONE 17-1501TPX </p>
Stocked Width	13 mm / 20 mm / 1372 mm Product can be slit to requested widths	13 mm / 15 mm / 20 mm / 1372 mm Product can be slit to requested widths

THERMAL & PHYSICAL PROPERTIES

Composition	Recycled Polyester Jersey / Polyurethane Barrier / Polyurethane Adhesive	Polyurethane / Recycled Polyester Jersey
Adhesive Gauge	152µm (.006")	140 µm (.0055")
Total Gauge ³	405 µm (.016")	381 µm (.015")
Total Weight ⁴	285g/m ²	260 g/m ²
Softening Point	75°C (167°F)	87°C (189°F)

PERFORMANCE

Modulus at 20% Elongation	13 mm: 2.07 lbf/in	13mm: 1.2 lbf/in
	20 mm: 3.41 lbf/in	20mm: 2.54 lbf/in
Modulus at 40% Elongation	13 mm: 2.92 lbf/in	13mm: 1.9 lbf/in
	20 mm: 5.12 lbf/in	20mm: 4.01 lbf/in
Recovery at 50%	98%	98%
Wash Durability	up to 40°C	up to 40°C

RECOMMENDED SEALING CONDITIONS⁵

HOT AIR SEALER

Temperature	420°C to 660°C	450°C to 600°C
Time	2.0 to 3.0 m/min	2.0 to 3.0 m/min
Pressure	3.4 - 4.2 bar	3.4 to 4.2 bar

FLAT PRESS (REPRESS CONDITION)

Temperature	130°C to 150°C	130°C to 150°C
Time	5 to 8 seconds	5 to 8 seconds
Pressure ⁶	10 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

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.

TECHNICAL DATA

	ST306	ST325
PRODUCT OVERVIEW		
Key Benefits + Material Adhesion	<ul style="list-style-type: none"> Minimal stretch Tricot fabric backer Medium to heavy weight 3L fabrics with Polyurethane membrane 	<ul style="list-style-type: none"> Minimal stretch Minimal footprint Tricot fabric backer Light to medium weight 3L fabrics with Polyurethane membrane
Compliance / Certification	bluesign®, OEKO-TEX®	bluesign®, OEKO-TEX®
Stocked Color(s)	Grey ¹ PANTONE 17-1501TPX 	Grey ¹ PANTONE 17-1501TPX 
Stocked Width	20 mm Product can be slit to requested widths	20 mm Product can be slit to requested widths
THERMAL & PHYSICAL PROPERTIES		
Composition	Polyurethane / Nylon Tricot	Polyurethane / Nylon Tricot
Adhesive Gauge	152 µm (.006")	165 µm (.0065")
Total Gauge ³	330 µm (.013")	305 µm (.012")
Total Weight ⁴	228 g/m ²	228 g/m ²
Softening Point	92°C (197°F)	90°C (194°F)
PERFORMANCE		
Modulus at 20% Elongation	13 mm: 5.19 lbf/in	13 mm: 3.7 lbf/in
	20 mm: 10.14 lbf/in	20 mm: 7.23 lbf/in
Modulus at 40% Elongation	13 mm: 9.79 lbf/in	13 mm: 6.61 lbf/in
	20 mm: 19.13 lbf/in	20 mm: 12.91 lbf/in
Recovery at 50%	97%	98%
Wash Durability	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
Time	2.5 to 3.0 m/min	2.5 to 3.0 m/min
Pressure	4.0 bar	4.0 bar
FLAT PRESS (REPRESS CONDITION)		
Temperature	130°C to 150°C	130°C to 150°C
Time	8 to 15 seconds	5 to 8 seconds
Pressure ⁶	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

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2. Custom colors may be available.

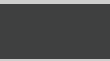

3. Total Gauge may vary slightly by color.

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.

TECHNICAL DATA

	ST370	ST385V
PRODUCT OVERVIEW		
Key Benefits + Material Adhesion	<ul style="list-style-type: none"> Soft and stretchable Minimal footprint Good for heat sensitive fabrics Jersey fabric backer Light to medium weight 3L stretch fabrics with Polyurethane membrane 	<ul style="list-style-type: none"> Soft and stretchable Ultimate customization Sustainable Environmentally friendly heat sublimation technique Applied on three-layer waterproof fabrics
Compliance / Certification	OEKO-TEX®	OEKO-TEX®
Stocked Color(s)	Black <small>PANTONE 19-0508 TPX</small>  Grey <small>PANTONE 17-1501TPX</small> 	Custom color (solid color print/custom graphics)
Stocked Width	1372 mm Product can be slit to requested widths	Product can be slit to requested widths
THERMAL & PHYSICAL PROPERTIES		
Composition	Polyester Jersey / Polyurethane Barrier / Polyurethane Adhesive	Polyester Jersey / Polyurethane Barrier / Polyurethane Adhesive
Adhesive Gauge	100 µm (.004")	152 µm (.006")
Total Gauge ³	330 µm (.013")	330 µm (0.013")
Total Weight ⁴	220 g/m ²	270 g/m ²
Softening Point	83°C (181°F)	75°C (167°F)
PERFORMANCE		
Modulus at 20% Elongation	13 mm: 1.09 lbf/in	13mm: 2.36 lbf/in
	20 mm: 1.76 lbf/in	20mm: 3.94 lbf/in
Modulus at 40% Elongation	13 mm: 2.05 lbf/in	13 mm: 4.01 lbf/in
	20 mm: 3.48 lbf/in	20 mm: 6.50 lbf/in
Recovery at 50%	98%	98%
Wash Durability	up to 60°C	up to 40°C
RECOMMENDED SEALING CONDITIONS⁵		
HOT AIR SEALER		
Temperature	350°C to 500°C	420°C to 660°C
Time	1.5 to 2.45 m/min	2.0 to 3.0 m/min
Pressure	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
Time	20 to 30 seconds	5 to 8 seconds
Pressure ⁶	40 to 60 psi (2.8 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

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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.

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