



# TECHNICAL DATA SHEET

**SK2RS204-3**

**Uncured non-silicone tooling rubber**

## ► DESCRIPTION

SK2RS204-3 is an uncured, non-silicone rubber for manufacture of pressure caul sheets, flexible mandrels, and rubber tooling. The product caul sheets improve part quality on the vacuum bag side of the part.

SK2RS204-3 pressure intensifier provides uniform pressure distribution during autoclave processing. The product will take high temperature similar to silicone rubbers but will not cause silicone contamination. SK2RS204-3 is dimensionally stable when reinforced with prepregs, which bond well and do not generate volatiles that could also cause delamination.

## ► ADVANTAGES

- Reduce scrap with improved part quality due to better thickness control and corner consolidation
- Reduce rework by eliminating surface wrinkles, voids, and porosity
- Avoid part distortion due to uneven laminate consolidation during cure

This product is used in various manufacturing processes of parts made of composite materials.

## ► TECHNICAL DATA

Material type:	Non silicone rubber
Color:	Black
Maximum use temperature:	204°C
Elongation at break:	400%
Hardness:	60 Shore A
Tensile strength:	11 MPa

## ► APPLICATION

### Moulding Guidelines:

- Mould SK2RS204-3 off a part, dummy part, or mould which is stable at high temperature and capable of high pressure
- Tack is temperature dependent and can be controlled with additional heat to assure adhesion to vertical surfaces, sharp corners, and complex shapes
- SK2RS204-3 is not self-releasing and must be covered with a release material, bondable one side release film during the layup process



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- Adhesive tape SK2AT260-4 or film SK2TR260-4 can also be applied to cured SK2RS204-3

### Recommended Cure:

- Apply vacuum bag throughout cure cycle and pressurise autoclave to 7 bar (100 psi), minimum recommended pressure is 3 bar (45 psi)
- Heat to 176°C and hold for 2 hours, then cool to room temperature before removing vacuum and demoulding from master mould

### ► **SIZE**

Thickness	Width	Length
1,6 mm	137cm	15,24m

Shelf life: 24 months from date of shipment

Storage conditions: it is recommended to store at temperature of 22°C in the original packing. Do not freeze.

### ► **NOTE**

The maximum use temperature is dependent upon the duration at maximum temperature and is process specific, testing is recommended prior to use.