CATALOGUE VIK-COMPOSITE

ANCILLARY MATERIALS RANGE

Nr.	Category	Name
1	Vacuum films	SK2VF
2	Release films	SK2RF
3	Sealant tapes	SK2ST
4	Release fabrics	SK2RE
5	Peel Plies	SK2PP
6	Breathers / Bleeders	SK2BB
7	Adhesive tapes	SK2AT
8	Rubbers	SK2RS
9	Tool release	SK2TR
10	Vacuum valves and hoses	SK2VV
11	Tooling materials	SK2TM
12	Resin infusion materials	SK2RIM

Name	Description	Max. use T°C	Elongation on break	Color
SK2VF120-1	Multilayer vacuum film for manufacturing of wide and complex structures	120°C	460%	Green
SK2VF170-1	Nylon vacuum film for oven and autoclave manufacturing of wide structures	180°C	380%	Green/Pink
SK2VF170-2	Multilayer vacuum bagging film for manufacturing of wide and complex structures	177°C	405%	Blue / Yellow
SK2VF170-5	Highly flexible multilayer nylon vacuum bagging film for oven and autoclave cures	170°C	520%	Lilac
SK2VF180-1	Standard nylon vacuum bagging film	200°C	380%	Clear
SK2VF200-1	Soft nylon vacuum bagging film for autoclave and oven molding	204°C	400%	Pink/Green
SK2VF200-E1	Embossed soft nylon vacuum bagging film for autoclave and oven molding	204°C	400%	Pink/Green
SK2VF200-2	Very soft nylon vacuum bagging film for autoclave and oven molding	204°C	440%	Pink
SK2VF200-5	Coextruded mononylon vacuum bagging film for oven and autoclave curing	204°C	440%	Purple
SK2VF205-1	Nylon vacuum film for autoclave and oven applications	205°C	400%	Green
SK2VF230-1	High temperature resistant nylon vacuum film	230°C	380%	Light blue
SK2VF260-1	High-elastic PTFE vacuum film	260°C	400%	Yellow
SK2VF400-1	Ultra-high temperature bagging polyimide film	400°C	85%	Amber
SK2VR145-1	Economical self-releasing multilayer vacuum bagging film	158°C	410%	Light green
SK2VR160-1	Self-releasing multilayer vacuum bagging film	160°C	445%	Green

SK2VR400-3	High temperature polyimide film for thermoplastic operations and for insulation purpose in electrical appliances	400°C	50%	Amber
Folding shape				
Resin compatibility				

► DESCRIPTION

SK2VF120-1 is a tough, puncture resistant co-extrusion of nylon and polyolefin based resins vacuum film, which is designed for use in the production of polyester / vinylester resin infused components for the wind energy, marine and general composite industries.

The product can be used in the production of epoxy resins prior to testing chemical resistance with specific resin.
It is particularly interesting due to its limited sensitivity to low humidity levels which are often problematic to predominantly nylon based films as the lack of moisture can reduce flexibility. This ensures consistent yearlong performance in all workshop environments.

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

► TECHNICAL DATA

		Test method
Material type:	Multilayer	
Color:	Green	
Tensile strength at break:	39,3 MPa	ASTM D882
Elongation at break :	460%	ASTM D882
Tear strength:	1,5 N	ISO1683-1
Maximum use temperature:	120°C	

► SIZES OF FILMS

Thickness	Width	Length	Folding shape
75µm ± 10%	2000mm	400m	SHT
	4000mm	200m	CF
	6000mm	105m	LGT
		125m	LGT
	8000mm	80m	LGT
80µm ± 10%	10000mm	75m	LGT
	12000mm	75m	LGT

	16000mm	30m	LGT
		70m	LGT

Shelf life: unlimited.
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing, protected from direct sun and heat source.

► **NOTE**

For the roll with width 16000mm other lengths are available under request.

Folding shapes: SHT - sheeting, CF - centerfold, LFT = lay-flat tubing, LGT- lay-gusseted tubing. For more information, please read the technical information page: SK2VF_Folding shape.

► DESCRIPTION

SK2VF170-1 is a highly flexible multilayer nylon vacuum bagging film designed for processing of advanced composite structures and laminated security glass. This film is ideal for use in both oven and autoclave cures, up to a maximum recommended temperature of 180°C. Key benefits of this film are its high elongation and flexibility.

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

► TECHNICAL DATA

		Test method
Material type:	Multilayer	
Color:	Green / Pink	
Elongation at break:	380 %	ASTM D882
Tensile strength at break:	50 MPa	ASTM D882
Maximum use temperature:	180°C	

► SIZE

Thickness	Width	Folding shape
50µm ± 10%	100mm	LFT- sheet
	200mm	
	300mm	
	600mm	
	900mm	
	1200mm	
	1500mm	
	2200mm	

Shelf life: unlimited

Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► **NOTE**

Film available in thickness from 38 µm to 75 µm or thicker for glass lamination on demand
Film of bigger sizes are produced under order in the preferred shape. All the other shapes, like CF-sheet can be produced on demand.

► DESCRIPTION

SK2VF170-2 vacuum bagging film is a tough, high temperature resistant co extruded nylon-based material which is designed for use in the production of advanced composite structures such as wind turbine blades and nacelles, boat hulls and decks, plus other industrial structures. The film is ideal for use in both resin infusion and prepreg moulding applications and is resistant to all commonly used resin systems.

This film is not suitable for use in autoclave processing of composites.

► TECHNICAL DATA

		Test method
Material type:	Multilayer	
Color:	Blue	
Elongation at break:	405%	ASTM D882
Tensile strength:	54MPa	ASTM D882
Maximum use temperature:	177°C	
Materials to avoid:	Phenolic resins / Strong oxidizers	

► STANDARD SIZES

Thickness	Width	Length	Folding shape
50µm ± 10%	2000mm	250m	SHT or CF
	3000mm	250m	CF
	4000mm	150m	CF
	6000 mm	130m	LGS
	8000mm	75m	LGS
	10500mm	75m	LGS
	12000mm	75m	LGS
65µm ± 10%	2000mm	250m	SHT or CF

	3000mm	250m	CF
	4000mm	150m	CF
	6000 mm	130m	LGS
	8000mm	75m	LGS
	10500mm	75m	LGS
	12000mm	75m	LGS
75µm ± 10%	2000mm	250m	SHT or CF
	3000mm	250m	CF
	4000mm	150m	CF
	6000 mm	130m	LGS
	8000mm	75m	LGS
	10500mm	75m	LGS
	12000mm	75m	LGS

Shelf life: unlimited.
Storage conditions: recommended temperatures between +5°C and +25°C in original packing, protected from direct sun and heat source.

► NOTE

Other lengths are available under request.

Other colors are available under request.
Width up to 12 meters wide. Film up to 4,6m wide supplied in sheet and V sheet.
Widths 6m and above supplied gusseted, centrally slit.

Folding shapes: SHT- sheet, CF - centerfold, LGS- lay-gusseted slit. For more information, please read the technical information page: SK2VF_Folding shape.

► DESCRIPTION

SK2VF170-5 is a lilac coloured highly flexible multilayer nylon vacuum bagging film, designed for processing of advanced composite structures and laminated security glass. The film is ideal for use in both oven and autoclave cures, up to a maximum recommended temperature of 170°C and a maximum recommended pressure of 8 bars.
Key benefits of this film are its high elongation and flexibility.
SK2VF170-5 is suitable for use with low temperature phenolic prepregs, typically curing at 135°C.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

		Test method
Colour:	Lilac	
Density:	1.05 g/cm^3	Internal
Thickness:	50µm	ISO 4593
Tensile strength:	63 MPa	ASTM D882
Elongation at break:	520%	ASTM D882
Maximum use temperature:	170°C	Internal

► SIZE (STANDARD)

Thickness	Width	Length	Folding shape
50µm	6000mm	200m	May vary

Shelf life: unlimited.

Storage conditions: Store in original packaging at ambient temperature between +5°C and +40°C, relative humidity between 25% and 60%, covered area protected from direct sunlight and UV light / radiation sources.

► NOTE

Other widths and colors are available under request depending on the volume of order.
Maximum use pressure and temperature should be determined under your actual process conditions.
This product can be recycled.

SK2VF180-1

Vacuum film

Back to range

► DESCRIPTION

Transparent nylon bagging film with good elongation which could be used for cure cycle by temperatures up to 180°C.

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

► TECHNICAL DATA

		Test method
Material type:	Nylon	
Color:	Clear	
Elongation at break:	380%	ASTM D882
Tensile strength:	75 MPa	ASTM D882
Recommended use temperature:	180°C	
Maximum use temperature:	200°C	
Materials to avoid:	Strong oxidizers	
Maximum recommended pressure:	14 bar	

► SIZE

Please, check dimensional chart in this section for dimensional information.

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Available thickness: from 19µm till 75µm
Available widths till 2,3m tubular and 4,60m v-sheet.
By special request MOQ has to be ordered.
Film available as: SHT - sheeting, CF - centerfold, LFT - lay-flat tubing

► DESCRIPTION

SK2VF200-1 – is soft transparent nylon bagging film with very good elongation for using in cure cycles by temperatures up to 200°C in autoclaves and ovens.

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

► TECHNICAL DATA

		Test method
Material type:	Nylon	
Color:	Pink/Green	
Elongation at break:	400%	ASTM D882
Tensile strength:	80MPa	ASTM D882
Recommended use temperature:	200°C	
Maximum use temperature:	204°C	
Melting Point:	215° C	
Materials to avoid:	Phenolic resins/Strong oxidizers	

► SIZE

Please, check dimensional chart in this section for dimensional information.

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Other thicknesses and width are available on special order:
Thickness available: 50 and 75µm
Max. widths available:
3000mm LFT or 6000mm CF for thickness of 50 µm.
4000mm LFT or 8000mm CF for thickness of 75 µm.
By special request MOQ has to be ordered.
Film available as: SHT - sheeting, CF - centerfold, LFT - lay-flat tubing.

SK2VF200-E1

Embossed nylon vacuum film

Back to range

► DESCRIPTION

SK2VF200-E1 – is soft transparent nylon bagging film embossed from one side with the «cracked ice» pattern. It allows for rapid air removal when placed under vacuum, eliminating need for separate layer of breather. The pattern has been developed to provide increased stiffness to assist in maintaining a breathable pattern. Bid width makes compacting large parts faster. For best results, place the raised side on top of a perforated release film against the laminate surface.

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

Pic.1 Embossing with «cracked ice» pattern

► TECHNICAL DATA

		Test method
Material type:	Nylon	
Color:	Pink/Green	
Elongation at break:	400 %	ASTM D882
Tensile strength:	80 MPa	ASTM D882
Recommended use T:	200°C	
Maximum use T:	204°C	
Melting Point:	215° C	
Materials to avoid	Phenolic resins/Strong oxidizers	

► SIZE

Thickness	Wide	Folding shape
75µm	1600mm	SHT
	3200mm	CF

Please, check dimensional chart in this section for dimensional information.

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Embossing is available for film width from 140 cm until 320 cm.
Film available as: SHT - sheeting, CF - centerfold.

► DESCRIPTION

SK2VF200-2 – is very soft transparent nylon bagging film with high elongation for using in cure cycles by temperatures up to 204°C in autoclaves and ovens. It is recommended for bagging applications where a higher softness is required.

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

► TECHNICAL DATA

		Test method
Material type:	Nylon	
Color:	Pink	
Elongation at break:	440 %	ASTM D882
Tensile strength:	80 MPa	ASTM D882
Maximum use temperature:	204°C	
Melting Point:	215° C	
Materials to avoid:	Phenolic resins/Strong oxidizers	

► SIZE

Please, check dimensional chart in this section for dimensional information.

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Available thickness: 50 and 75µm
Maximum available widths:
3000mm LFT or 6000mm CF for thickness of 50 µm.
4000mm LFT or 8000mm CF for thickness of 75 µm.
By special request MOQ has to be ordered.
Film available as: SHT - sheeting, CF - centerfold, LFT - lay-flat tubing.

TECHNICAL DATA SHEET

SK2VF200-5

Nylon vacuum film

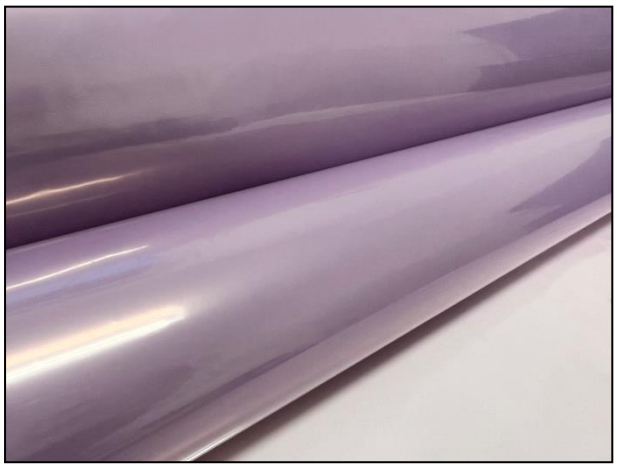
Back to range

► DESCRIPTION

SK2VF200-5 is a coextruded mononylon vacuum bagging film, developed to improve softness during handling. This film has twice lower Young modulus compared to the common nylon films, which are used in autoclave curing.

This film is suitable for contact with phenolic resins and can be used for oven and autoclave cure temperatures up to 204°C.

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



► TECHNICAL DATA

		Test method
Colour:	Purple	
Density:	1.13 g/cm^3	Internal
Thickness:	50µm	ISO 4593
Tensile strength:	70 MPa	ASTM D882
Elongation at break:	440%	ASTM D882
Maximum use temperature:	204°C	

► SIZE (STANDARD)

Thickness	Width	Length	Folding shape
50µm	700mm (1400mm)	150m	LFT
	3000mm	150m	CF
	3500mm	150m	CF

Shelf life: unlimited.

Storage conditions: Store in original packaging at ambient temperature between +5°C and +40°C, relative humidity between 25% and 60%, covered area protected from direct sunlight and UV light / radiation sources.

► NOTE

Other widths and colors are available under request depending on the volume of order.
Maximum use pressure and temperature should be determined under your actual process conditions.
This product can be recycled.

► DESCRIPTION

Transparent nylon bagging film is formulation of Nylon 6 and Nylon 66 resin. Film has very good elongation and could be used for cure cycle by temperatures up to 205°C.

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

► TECHNICAL DATA

		Test method
Material type:	Nylon	
Color	Green	
Elongation at break	400%	ASTM D882
Tensile strength	82.74 – 117.21 MPa	ASTM D882
Maximum use temperature	205°C	
Melting Point:	>240°	
Materials to avoid	Phenolic resins/Strong oxidizers	

► SIZE

Please, check dimensional chart in this section for dimensional information.

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Other thicknesses and width are available on special order:
Thickness: from 19µm till 76µm
Widths: 0,91m till 3,55m.
By special request MOQ has to be ordered.
Film available as: SHT - sheeting, CF - centerfold, LFT - lay-flat tubing.

TECHNICAL DATA SHEET

SK2VF230-1

High temperature resistant nylon vacuum film

Back to range

► DESCRIPTION

SK2VF230-1 – is a tough, high temperature resistant co extruded mono-nylon film designed for use in the production of advanced composite structures in aerospace industry. The film is resistant to most of common resins, as well as to bismaleimide resins.

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

► TECHNICAL DATA

		Test method
Material type:	Nylon	
Color:	Light sky blue	
Density:	1,12 g/cm^3	internal
Elongation at break:	380%	ASTM D638
Tensile strength:	75 MPa	ASTM D882
Maximum use temperature	230°C	

► SIZE

Thickness	Width	Length	Folding shape
50µm	1500mm	300m	SHT
75µm	1500mm	300m	SHT

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from +10°C until +30°C in original packing.

► NOTE

Other thicknesses and width are available on special order:
Thickness available: 50 and 75µm
Widths available: from 800mm to 1575mm LFT (1600mm till 3150mm open width).
Film available as: SHT - sheeting, CF - centerfolded and LFT - lay-flat tubing

► DESCRIPTION

SK2VF260-1 is a cast fluoropolymer vacuum film product that consists of a 100% PTFE film with a surface treatment/modification for adhesive bonding and/or lamination to various substrates. Several colors and several treatments are available.

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

► TECHNICAL DATA

Material type:	PTFE
Color:	Yellow
Working temperature:	-73°C to 260°C
Elongation at break:	400%
Tensile strength minimum:	2000 psi
Surface tension minimum:	40 dynes

► SIZE

Reference	Thickness	Width	Length
SK2VF260-1YW7512753	75µm	1,27m	53m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Length of roll can be modified according to the client needs.
Maximum available width is 1,42m.
Available colors at request: Red, White, Blue, Tan
Maximum use temperature should be determined under your actual process conditions.

► DESCRIPTION

SK2VF400-1 – is polyimide vacuum film that provides excellent electrical, thermal, physical, and chemical properties over a wide temperature range from -265°C until +400°C making it superior for a wide array of applications. Product advantages include high electric strength, isotopic property, dimensional stability, scratch and abrasion resistance.

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

► TECHNICAL DATA

		Test method
Material type:	Polyimide	
Color:	Amber	
Elongation at break:	85%	ASTM D882
Tensile strength:	25 Kgf/mm²	ASTM D882
Density:	1.46 g/cm²	ASTM D1505
Max. use T*:	up to 400°C	

► SIZE

Thickness	Width	Length
12µm	1570mm	152m
25µm	1570mm	152m
50µm	1570mm	152m
75µm	1570mm	152m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Maximum roll length 1524 m.
* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature is dependent upon the duration at maximum temperature and is process specific, we recommend testing prior to use.

► DESCRIPTION

SK2VR145-1 is an economical self-releasing multilayer vacuum bagging film that can be used for cure cycles up to 145°C, which provide antiadhesion from most resins used in manufacturing in aerospace, marine and entertaining products industries. It can be used as vacuum bag and as release film. Due to multilayer structure the film has improved strength and heat resistance characteristics. It is suitable both for polyester, vinylester and epoxy resins.

► TECHNICAL DATA

		Test method
Material type:	Multilayer Polyolefin + Nylon	
Color:	Light green, Pink	
Thickness:	30 µm, 50 µm and 75µm	ISO 4593
Density:	0,97 g/cm^3	
Tensile strength at break:	65 MPa	ASTM
Elongation at break:	410%	ASTM
Recommended working temperature:	145°C	ASTM
Maximum use temperature*:	158°C	

► SIZE

Thickness	Width	Folding shape
30µm	1500mm	SHT - sheet

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Perforation PJ, PK and PL is available for this film.
* Maximum use temperature should be determined in actual process conditions.

TECHNICAL DATA SHEET

SK2VR160-1

Multilayer vacuum release film

Back to range

► DESCRIPTION

SK2VR160-1 is a self-releasing multilayer vacuum bagging film designed for processing of hollow advanced composite structures where easy removal of the bag following the cure is desirable to as to avoid damage to the component. It can be used for manufacturing of hollow parts such as bicycle components, masts, fishing rods, etc. The film is ideal for use in both oven and autoclave cures, up to a maximum recommended temperature of 160°C. It is compatible with phenolic, polyester and epoxy resins.

► TECHNICAL DATA

		Test method
Material type:	Polyolefin nylon mixture	
Color:	Green	
Thickness:	70µm	
Elongation at break:	445 %	ASTM D882
Tensile strength (at break)	42 MPa	ASTM D882
Maximum use temperature:	160°C	

► SIZE

Thickness	Width	Folding shape
70µm	3000mm – 8000mm	LFT – lay-gusseted tube
70µm	860mm - 2500 mm	LGS - lay-gusseted slit

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

By ordering of a narrow sleeve this film can supplied as LGT folding shape, thus simplifying laying in the closed contractions.

This film is also available in 30 micron thinness with PJ perforation. In this case the reference for ordering is SK2VR164-1GNPJ30150500SHT.

► DESCRIPTION

SK2VR400-3 – is high temperature polyimide film. It is widely used in composite applications for thermoplastic operations and for insulation purpose in electrical appliances which are used in special environment. Using the polyimide film in electrical appliances means reducing volume and weight of the electrical appliances while retaining the same output or increasing the capacity without increasing in frame size. It can also prolong the service life of the electrical appliances and increase their reliability.

► TECHNICAL DATA

- High temperature resistance
- Excellent dielectric withstand
- Good mechanical property
- Chemical resistance
- Flame retardant
- UL approved
- RoHS / REACH compliant

Technical properties				
Thickness, µm		25µm	50µm	75µm
Density		1.42 +/- 0.02 g/cc		
Maximum use temperature*		400°C		
Tensile strength, min	MD, MPa	135		
	TD, MPa	160		
Elongation, %, min		50		
Dielectric strength, min		4.5kv		
Shrinkage at 400°C, MD and TD, %, max		3		
Volume Resistance at 200+/-5°C, Ohm.m, min		10^{10}		
Surface Resistance at 200+/-5°C, Ohm, min		10^{13}		
Dielectric Constant, 48~62 Hz		3.5 +/-0.4		
Dissipation Factor,48~62 Hz, max		0.004		

The features are tested under room temperature (23°C) unless otherwise described.

► DIMENSIONS

- Core: 76mm and 152mm paper or plastic core
- Width: 25µm: 1040mm
  50µm and 75µm: 540mm / 980mm as standard
- Length: 500m without splice

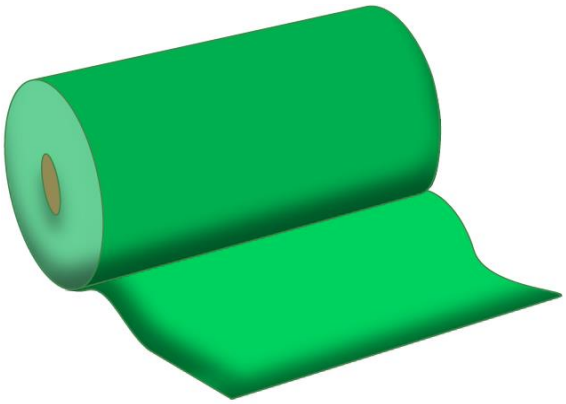
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

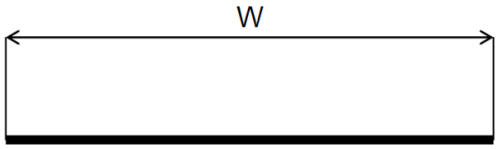
► NOTE

This film can be ordered as standard - in this case both sides have release properties. In case SK2VR400-3 is planned to be sealed and used as vacuum film, or for bonding on surface of laminate, it can be ordered corona surface treated one side (BOS - once side bondable) or both sides (BBS - bondable both sides).

* Maximum use temperature depends from the impacting duration and should be determined in actual process conditions.

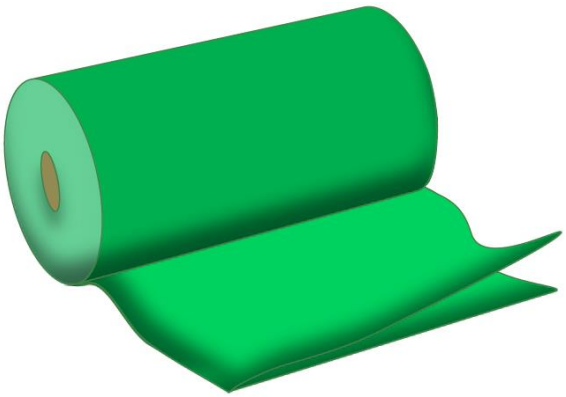
▶ SHT = sheeting

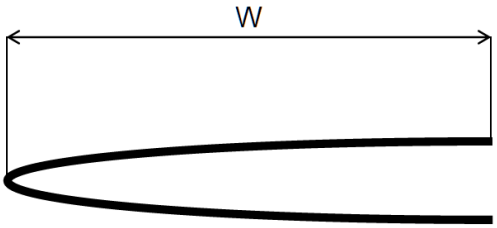




SHT: The width of the film indicated in the reference corresponds to W.

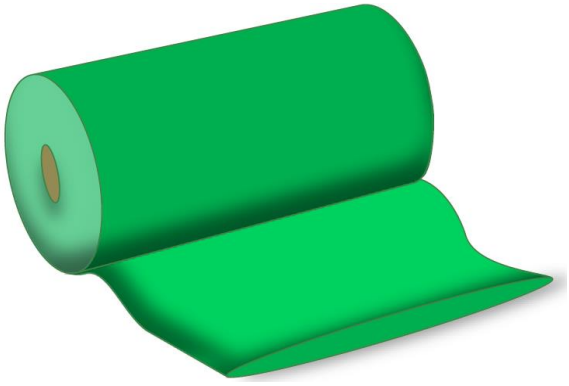
▶ CF = centerfold

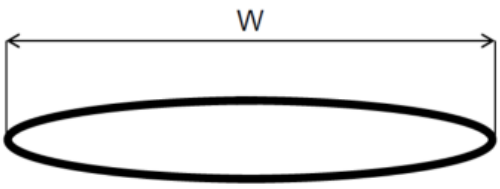




CF: The width of the film indicated in the reference corresponds to 2W.

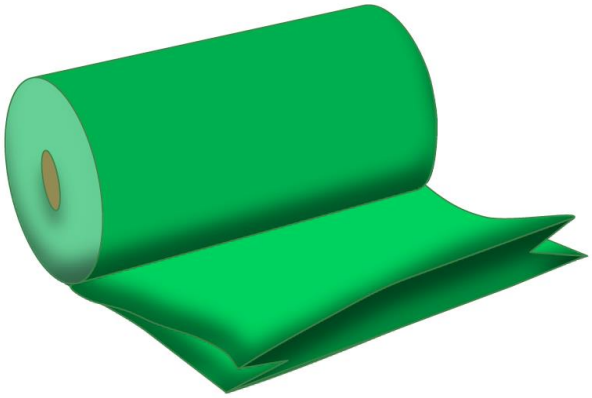
▶ LFT = lay-flat tubing

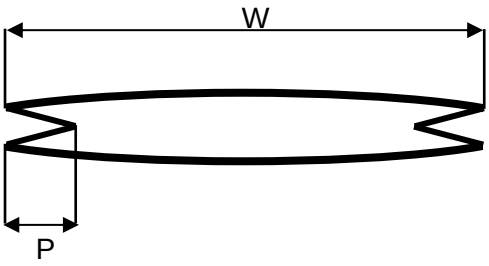




LFT: The width of the film indicated in the reference corresponds to W.

► LGT = lay-gusseted tubing

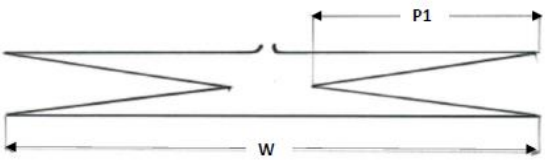




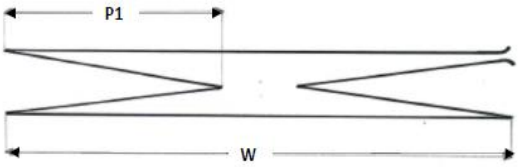
LGT: The width of the film indicated in the reference corresponds to 2W+4P.

► LGS = lay-gusseted slit

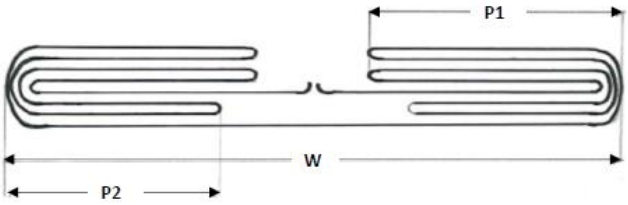
Depends on the thickness and width the film can be pleated in 3 possible ways:



V1: The width of the film indicated in the reference corresponds to 2W+4P.



V2: The width of the film indicated in the reference corresponds to 2W+4P1.



V3: The width of the film indicated in the reference corresponds to 2W+4P1+2P2.

Resin compatibility

Vacuum bag film selection guide

Back to range

The following guideline is intended for reference only. VIK-Composite cannot control processing parameters or test all the materials available at the market. Risk reduction panel testing is strongly recommended before serial production. Please ask us for sample of vacuum film for testing. Film selection should be based on temperature requirement.

Compatible: V **Compatible, but till spec. temperature:** V-T_L **To avoid: X**

Name	Max. use T°C	Resins					Using in autoclave
		Epoxy	Polyester & Vinylester	Phenolic	BMI	Cyanate Ester	
SK2VF120-1	120°C	V	V	X	X	X	NO
SK2VR145-1	158°C	V	V	X	X	X	NO
SK2VR160-1	160°C	V	V	V	X	X	YES
SK2VF170-1	180°C	V	V	V-T_L	X	X	YES
SK2VF170-2	177°C	V	V	V	X	X	NO
SK2VF170-5	170°C	V	V	V	X	X	YES
SK2VF180-1	180°C	V	V	X	V	V	YES
SK2VF200-1	204°C	V	V	X	V	V	YES
SK2VF200-E1	204°C	V	V	X	V	V	YES
SK2VF200-2	204°C	V	V	X	V	V	YES
SK2VF200-5	204°C	V	V	V	X	X	YES
SK2VF205-1	205°C	V	V	X	V	V	YES
SK2VF230-1	230°C	V	V	V	V	V	YES
SK2VF260-1	260°C	V	V	V	V	V	YES

SK2VF400-1	400°C	V	V	V	V	V	YES
SK2VR400-3	400°C	V	V	V	V	V	YES

Name	Description	Max. use T°C	Elongation on break	Color
SK2RF120-1	Polyolefin low temperature release film	125°C	550%	Blue
SK2RF155-1	Polyolefin release film for debulking and low temperature curing cycles	157°C	620%	Red
SK2RF200-1	Polymethylpenten (PMP) low cost high temperature release film	200°C	250%	Purple, light purple
SK2RF230-1	High performance fluoropolymer (ETFE) release film	260°C	350%	Blue / Red
SK2RF230-2	High performance fluoropolymer ETFE release film	260°C	350%	Blue / Red
SK2RF260-1	High performance fluoropolymer (FEP) release film	260°C	320%	Red
SK2RF260-2	High performance fluoropolymer (FEP) release film	260°C	320%	Red
SK2RF316-1	Fluoropolymer (PFTE) release film for mold released applications	316°C	400%	Blue
SK2RF400-1	Polyimide release film	400°C	85%	Amber
SK2VR145-1	Economical self-releasing multilayer vacuum bagging film	158°C	410%	Light green
SK2VR160-1	Self-releasing multilayer vacuum bagging film	160°C	445%	Green
SK2VR400-3	High temperature polyimide film for thermoplastic operations and for insulation purpose in electrical appliances	400°C	50%	Amber
Available perforations	-	-	-	-

► DESCRIPTION

SK2RF120-1 is low temperature release film designed for use in the processing of advanced composite structures in wet lay-up, resin infusions, oven and autoclave conditions.
It is compatible for use with a wide range of epoxy, polyester and vinylester resin systems, however we recommend small scale trials prior to committing to large infusion mouldings.

► TECHNICAL DATA

		Test method
Material type:	Polyolefin	
Color:	Blue	
Elongation at break:	550%	ASTM D882
Tensile strength at break:	47 MPa	ASTM D882
Maximum use temperature:	125°C	
Density:	0,97g/cm³	ASTM D1505

► SIZE

Reference	Thickness	Width	Length	Folding shape	Perforation
SK2RF120-1BLNP28230250SHT	28µm	2,30m	250 m	SHT - Sheeting	Not perforated
SK2RF120-1BLNP28460250CF	28µm	4,60m	250 m	CF - Centrefold	Not perforated
SK2RF120-1BLPJ28150250SHT	28µm	1,50m	250 m	SHT - Sheeting	with PJ
SK2RF120-1BLPK28150250SHT	28µm	1,50m	250 m	SHT - Sheeting	with PK

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.
Maximum width of perforated film is 1,75 mm SHT
Other roll sizes are available on special order.

► NOTE

Perforations PJ and PK are available for this film.

► DESCRIPTION

SK2RF155-1 is a mid-temperature range, highly flexible polypropylene based release film. It is suitable for use with low temperature epoxy and phenolic prepregs up to 150°C.

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

► TECHNICAL DATA

		Test method
Material type:	Polypropylene	
Color:	Red	
Elongation at break:	620%	ASTM D882
Tensile strength at break:	40 MPa	ASTM D882
Density:	0,91 g/cm³	
Recommended working temperature:	150°C	
Maximum use temperature*:	157°C	

► SIZE

Thickness	Width	Length
30µm	1500mm	400m
40µm	1500mm	400m
50µm	1500mm	400m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Perforations PJ, PK and PL are available for this film.
Perforated film maximum width is 1600 mm.
Other widths upon 2200 mm are available to specific order.
* Maximum use temperature should be determined in actual process conditions.

SK2RF200-1

Release film

Back to range

► DESCRIPTION

SK2RF200-1 – release film manufactured from Polymethylpentene (PMP) copolymer resin. Film offer manufacturers of composite products a material which will perform up to 200°C, depending on the specific application, for autoclave constructions.
Film is recommended for high temperature vacuum infusion process (mono-component resins). This release film does not contaminate the composite. SK2RF200-1 is strong and has high elongation. This film can be used with contour surfaces or flat surfaces. SK2RF200-1 is a release film with all the resins. Film is available in two perforations.

► TECHNICAL DATA

Material	Polymethylpenten
Color	Purple, light purple
Elongation:	250%
Tensile strenght:	24 MPa
Max.used temperature	200°C
Perforation	NP
Aspect	Faces lisses
Packaging	Roll

► DIMENSIONS

Thickness	Width	Length	Surface weight
30µm	1,5m	200m	25g/m^2

► ORDER INFORMATION

Reference	Description
SK2RF200-1VTNP30150200SHT	Release film, PMP, purple, without perforation, T=200°C, 30 µm x 1,5 m x 200 m
SK2RF200-1VTPD30150200SHT	Release film, PMP, purple, with perforation PD, T=200°C, 30 µm x 1,5 m x 200 m
SK2RF200-1VTPE30150200SHT	Release film, PMP, purple, with perforation PE, T=200°C, 30 µm x 1,5 m x 200 m

Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► DESCRIPTION

SK2RF230-1 is a release film with an excellent elongation and could be used on complex shapes. It is capable of cure temperatures up to 230°C.
This film will release from most resin systems and will provide a glossy finish when used directly on the laminate.

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

► TECHNICAL DATA

		Test method
Material type:	ETFE	
Color:	Blue, red	
Elongation at break:	350%	ASTM D882
Tensile strength:	48 MPa	ASTM D882
Recommended working T:	230°C	
Maximum use T*:	up to 260°C	
Materials to avoid:	Compatible with most resin systems	
Surface weight (theoretical):	45 g/m² for 25µm	
Yield	22,2 m²/Kg/25µm	

► SIZE

Thickness	Width	Length	Weight appr.
25µm	1530mm	153m	10,5 kg

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Other widths and colors are available on special order:
Thickness: from 0,015mm up to 0,25mm
Max width of film: up to 1,58m
* Maximum use temperature should be determined in actual process conditions.
Product sustains short temperature spikes up to 260°C.

TECHNICAL DATA SHEET

SK2RF230-2

High quality ETFE release film

Back to range

► DESCRIPTION

SK2RF230-2 release film is manufactured from extruded ETFE with the highest technology available on the market with an accurate process parameters in line quality control.

SK2RF230-2 release film designed to suit different composite process application (Autoclave production of composite materials, vacuum bagging processes)

► PRODUCT BENEFITS

- High performance tough Fluoropolymer based film
- High thermal stability
- Excellent mechanical properties (highest through the fluoropolymer family)
- Very good yield strength producing an excellent surface finish on the cured composite
- Suitable for use with all commonly used resin systems
- Available perforated or non-perforated
- Standard width up to 1520 mm.

► TECHNICAL DATA

		Test method
Material type:	ETFE	
Colour:	Natural, Blue and Red	
Recommended working T:	232°C	
Maximum use T:	260°C	
Tensile strength*:	≥ 50 N/mm²	ASTM D882
Elongation at break*:	≥ 350%	ASTM D882
Standard thickness:	15 – 20 – 25 - 50 µm	
Standard width:	1220-1520 mm	ISO 4592
Standard length**:	76 and 153	

*Test performed with an extensometer (l0 = 10mm)
**For thickness ≤ 25 µm 153 m; for thickness 50 µm 76 or 153 m

► NOTE

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +35°C in original packing.

SK2RF260-1

Release film

Back to range

► DESCRIPTION

SK2RF260-1 is a temperature resistant release film with an excellent elongation and could be used on complex shapes. It is capable of cure temperatures up to 260°C. The special fluoropolymer gives to the product an outstanding resistance to chemical agents, so that this film will release from most resin systems and will provide a glossy finish when used directly on the laminate.

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

► TECHNICAL DATA

		Test method
Material type:	FEP	
Color:	Red	
Elongation at break:	320%	ASTM D882
Tensile strength:	21 MPa	ASTM D882
Recommended working T:	230°C	
Maximum use temperature:	260 °C	
Materials to avoid:	Compatible with most resin systems	
Surface weight (theoretical):	54 g/m² for 50µm	
Yield:	18,5 m²/Kg/50µm	

► SIZE

Thickness	Width	Length	Weight
Up to 50 µm	1530mm	153m	12,5 kg

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

This film can be ordered as standard - in this case both sides have release properties. In case SK2RF260-1 is planned to bonded on surface of laminate or on surface of pressure caul sheets, it can be ordered corona surface treated, either as BOS - one side bondable or BOSO - one side bondable with better bondability. BOSO is a specifically developed option, ideally suitable for solar panel lamination.

Other thicknesses and width are available on special order:
Thickness: from 13µm up to 50µm
Max width for film: up to 1,58m

* Maximum use temperature should be determined in actual process conditions.
Product sustains short temperature spikes up to 260°C.

TECHNICAL DATA SHEET

SK2RF260-2

High quality FEP release film

Back to range

► DESCRIPTION

SK2RF260-2 release film is manufactured from extruded FEP with the highest technology available on the market with an accurate process parameters in line quality control.

SK2RF260-2 release film designed to suit different composite process application (Autoclave production of composite materials, vacuum bagging processes).

► PRODUCT BENEFITS

▪ High performance Fluoropolymer based film and aerospace industry standard for many years.
▪ High thermal stability
▪ Very good yield strength producing an excellent surface finish on the cured composite
▪ Suitable for use with all prepreg systems including polyester, epoxy, phenolic and BMI
▪ Excellent release properties
▪ Available perforated or non-perforated
▪ Standard width up to 1520 mm.

► TECHNICAL DATA

		Test method
Material type:	FEP	
Colour:	Natural and Red	
Maximum use T:	260°C	
Tensile strength*:	21 N/mm²	ASTM D882
Elongation at break*:	320%	ASTM D882
Standard thickness:	13 – 20 – 25 - 50 µm	
Standard width:	1220-1520 mm	ISO 4592
Standard length**:	76 - 152	

*Test performed with an extensometer (l0 = 10mm)
**For thickness ≤ 25 µm 152 m; for thickness 50 µm 76 or 152 m

► NOTE

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +35°C in original packing.

► DESCRIPTION

SK2RF316-1 is a cast fluoropolymer film product, made of PFTE film designed for mold released applications. It is capable of continuous service temperatures up to 316°C. The product can withstand periodic service temperature increases close or above its melting point. It has excellent release properties at any temperature within range and superior ability to conform to even the most challenging shapes.

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

► TECHNICAL DATA

Material type:	PTFE
Color:	Blue
Width available:	1,22m
Elongation at break:	400%
Thicknesses available:	25 and 50 µm
Working temperature:	-73°C to 316 °C
Melting point:	327°C

► SIZE

Reference	Thickness	Width	Length
SK2RF316-1BL25122152	25µm	1,22 m	152m
SK2RF316-1BL5012276	50µm	1,22 m	76 m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Film available as: SHT - sheeting
Available colors at request: Red and Yellow

► DESCRIPTION

SK2RF400-1 – is polyimide release film that provides excellent electrical, thermal, physical, and chemical properties over a wide temperature range from -265°C until +400°C in a lightweight package making it superior for a wide array of applications. Product advantages include high electric strength, isotopic property, dimensional stability, scratch and abrasion resistance.

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

► TECHNICAL DATA

		Test method
Material type:	Polyimide	
Color:	Amber	
Elongation at break:	85%	ASTM D882
Tensile strength:	25 Kgf/mm²	ASTM D882
Density:	1.46 g/cm²	ASTM D1505
Dielectric constant:	3.3	
Heat shrinkage:	0.05	ASTM D5213-04
Recommended working T:	235°C	
Max. use T*:	up to 400°C	

► SIZE

Thickness	Width	Length
12µm	1570mm	152m
25µm	1570mm	152m
50µm	1570mm	152m
75µm	1570mm	152m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► **NOTE**

Maximum roll length 1524 m.
* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature is dependent upon the duration at maximum temperature and is process specific, we recommend testing prior to use.

TECHNICAL DATA SHEET

SK2VR145-1

Multilayer vacuum release film

Back to range

► DESCRIPTION

SK2VR145-1 is an economical self-releasing multilayer vacuum bagging film that can be used for cure cycles up to 145°C, which provide antiadhesion from most resins used in manufacturing in aerospace, marine and entertaining products industries. It can be used as vacuum bag and as release film. Due to multilayer structure the film has improved strength and heat resistance characteristics. It is suitable both for polyester, vinylester and epoxy resins.

► TECHNICAL DATA

		Test method
Material type:	Multilayer Polyolefin + Nylon	
Color:	Light green, Pink	
Thickness:	30 µm, 50 µm and 75µm	ISO4593
Density:	0,97 g/cm^3	
Tensile strength (at break):	65 MPa	ASTM D882
Elongation at break:	410%	ASTM D882
Recommended working temperature:	145°C	
Maximum use temperature*:	158°C	

► SIZE

Thickness	Width	Folding shape
30µm	1500mm	SHT - sheet

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

Perforation PJ, PK and PL is available for this film.
* Maximum use temperature should be determined in actual process conditions.

TECHNICAL DATA SHEET

SK2VR160-1

Multilayer vacuum release film

Back to range

► DESCRIPTION

SK2VR160-1 is a self-releasing multilayer vacuum bagging film designed for processing of hollow advanced composite structures where easy removal of the bag following the cure is desirable to as to avoid damage to the component. It can be used for manufacturing of hollow parts such as bicycle components, masts, fishing rods, etc. The film is ideal for use in both oven and autoclave cures, up to a maximum recommended temperature of 160°C. It is compatible with phenolic, polyester and epoxy resins.

► TECHNICAL DATA

		Test method
Material type:	Polyolefin nylon mixture	
Color:	Green	
Thickness:	70µm	
Elongation at break:	445%	ASTM D882
Tensile strength (at break):	42 MPa	ASTM D882
Maximum use temperature:	160°C	

► SIZE

Thickness	Width	Folding shape
70µm	3000mm – 8000mm	LFT – lay-gusseted tube
70µm	860mm - 2500 mm	LGS - lay-gusseted slit

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

By ordering of a narrow sleeve this film can supplied as LGT folding shape, thus simplifying laying in the closed constructions.

This film is also available in 30 microns thinness with PJ perforation. In this case the reference for ordering is SK2VR164-1GNPJ30150500SHT.

► DESCRIPTION

SK2VR400-3 – is high temperature polyimide film. It is widely used in composite applications for thermoplastic operations and for insulation purpose in electrical appliances which are used in special environment. Using the polyimide film in electrical appliances means reducing volume and weight of the electrical appliances while retaining the same output or increasing the capacity without increasing in frame size. It can also prolong the service life of the electrical appliances and increase their reliability.

► TECHNICAL DATA

- High temperature resistance
- Excellent dielectric withstand
- Good mechanical property
- Chemical resistance
- Flame retardant
- UL approved
- RoHS / REACH compliant

Technical properties				
Thickness, µm		25µm	50µm	75µm
Density		1.42 +/- 0.02 g/cc		
Maximum use temperature*		400°C		
Tensile strength, min	MD, MPa	135		
	TD, MPa	160		
Elongation, %, min		50		
Dielectric strength, min		4.5kv		
Shrinkage at 400°C, MD and TD, %, max		3		
Volume Resistance at 200+/-5°C, Ohm.m, m		10^{10}		
Surface Resistance at 200+/-5°C, Ohm, mir		10^{13}		
Dielectric Constant, 48~62 Hz		3.5 +/-0.4		
Dissipation Factor,48~62 Hz, max		0.004		

The features are tested under room temperature (23°C) unless otherwise described.

► DIMENSIONS

- Core: 76mm and 152mm paper or plastic core
- Width: 25µm: 1040mm
  50µm and 75µm: 540mm / 980mm as standard
- Length: 500m without splice

Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTE

This film can be ordered as standard - in this case both sides have release properties. In case SK2VR400-3 is planned to be sealed and used as vacuum film, or for bonding on surface of laminate, it can be ordered corona surface treated one side (BOS - once side bondable) or both sides (BBS - bondable both sides).

* Maximum use temperature depends from the impacting duration and should be determined in actual process conditions.

Available perforations

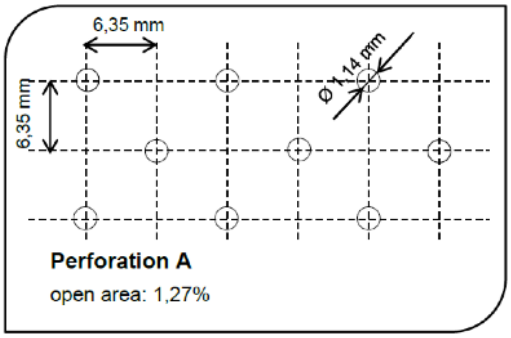
Release film

Back to range

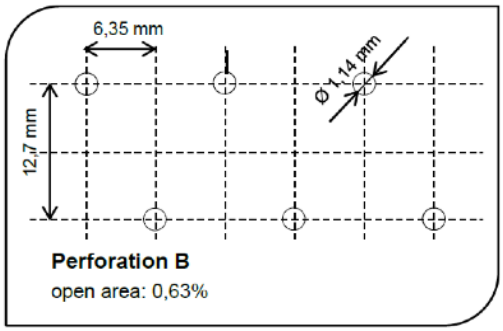
Perforation	Ø Hole	X (Width direction)	Y (Roll direction)	Type	Open area
PA	1,14mm	6,35mm	6,35mm	staggered	1,27%
PB	1,14mm	6,35mm	12,70mm	staggered	0,63%
PC	0,38mm	6,35mm	6,35mm	staggered	0,14%
PD	0,50mm	3,57mm	7,00mm	staggered	3,45%
PE	0,50mm	7,14mm	14,00mm	staggered	0,86%
MP	0,15mm	2,00mm	2,00mm	staggered	0,22%
MU	0,09mm	4,00mm	2,00mm	staggered	0,078%
PF	1,14mm	50,8mm	50,8mm	staggered	0,04%
PG	0,38mm	203mm	203mm	straight	0,0003%
PH	1,14mm	89mm	89mm	staggered	0,013%
PI	0,38mm	76mm	76mm	staggered	0,0019%
PJ	0,4mm	5mm	10mm	staggered	0,126%
PK	0,6mm	3,5mm	2,5mm	staggered	1,616%
PL	0,3mm	3,5mm	2,5mm	staggered	0,404%

Available perforations

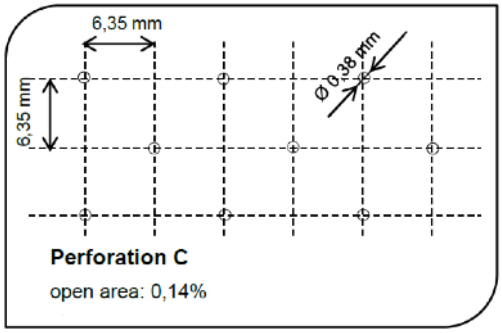
Release film



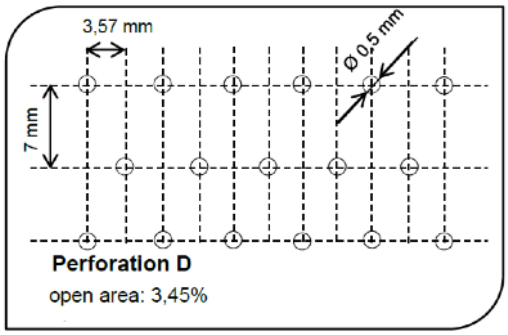
Perforation A
open area: 1,27%



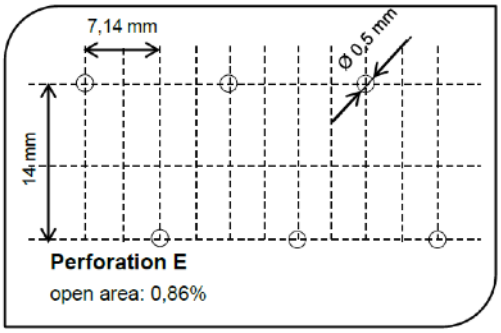
Perforation B
open area: 0,63%



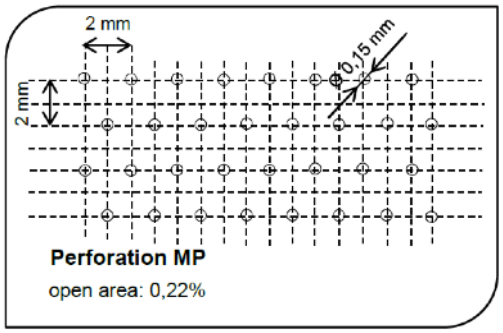
Perforation C
open area: 0,14%



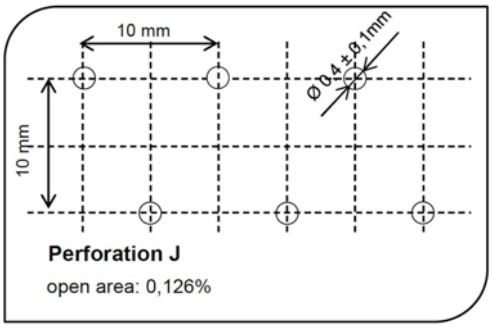
Perforation D
open area: 3,45%



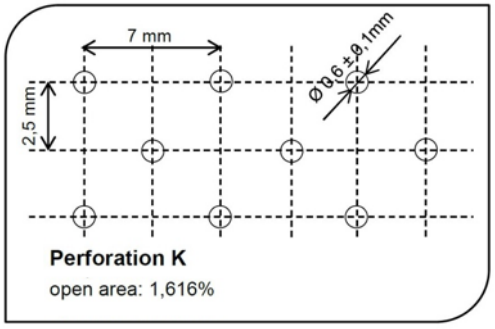
Perforation E
open area: 0,86%



Perforation MP
open area: 0,22%



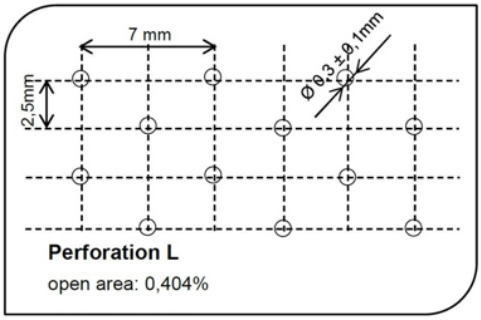
Perforation J
open area: 0,126%



Perforation K
open area: 1,616%

Available perforations

Release film



Perforation L

open area: 0,404%

Name	Description	Max. use T°C	Color
SK2ST120-3	Economical sealant tape for debulking and low temperature applications	120°C	Black
SK2ST130-1	Vacuum bagging sealant tape for debulking and low temperature applications	130°C	Light grey
SK2ST150-2	Economical sealant tape	150°C (bag to tool) 180°C (bag to bag)	Yellow
SK2ST200-1	Efficient multifunctional sealant tape	204°C	Yellow
SK2ST210-2	Sealant tape with high tack and clean remove	210°C	Yellow
SK2ST399-1	Sealant tape for high temperature processes	399°C	Dark brown

SK2ST120-3
Sealant Tape

Back to range

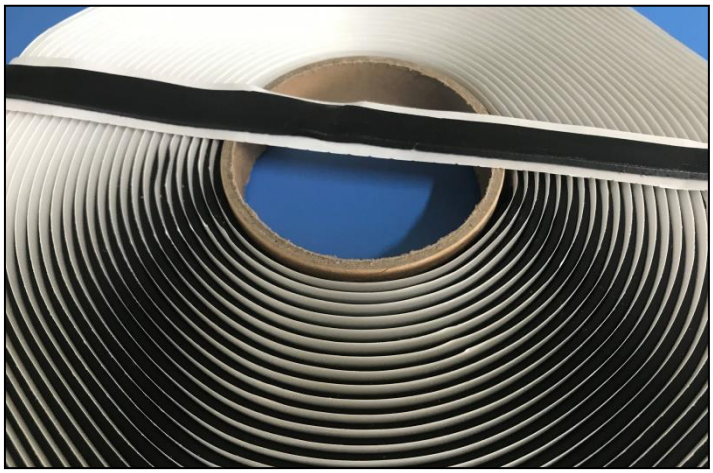
► DESCRIPTION

SK2ST120-3 is economical sealant tape for vacuum bagging applications where cost is a primary consideration. This tape maintains a good vacuum seal for vacuum bagging applications from room temperature to 120°C. It removes easily from all types of tools without residues.
It is ideally suited for debulking operation and resin infusion processes.
For clean removal, it is recommended to strip the tape from the mould surface once it has cooled down to room temperature.

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

► TECHNICAL DATA

Material:	Synthetic rubber
Colour:	Black
Maximum use temperature:	120°C



► SIZE

Thickness	Width	Length	Packing
3mm	12mm	15m	20 rolls per case

Shelf life: 18 months.
Storage conditions: it is recommended to store flat in original packing at temperatures between +10°C and +30°C.

► NOTE

All surfaces should be clean, dry and free from grease and loose materials. Apply directly from the reel onto one surface and press sufficiently along its whole length to achieve good initial adhesion. Remove backing paper at the joint between the tapes, place the second tape overlapping to the first and push firmly to seal across the joint. After placing the tape onto the surface remove backing paper, lay vacuum film on the strip. Apply pressure by hand or roller SK3ROL-1 to ensure tight connection. The maximum use temperature is dependent upon the duration at maximum temperature and is process specific, we recommend testing prior to use.

SK2ST130-1

Sealant Tape

Back to range

► DESCRIPTION

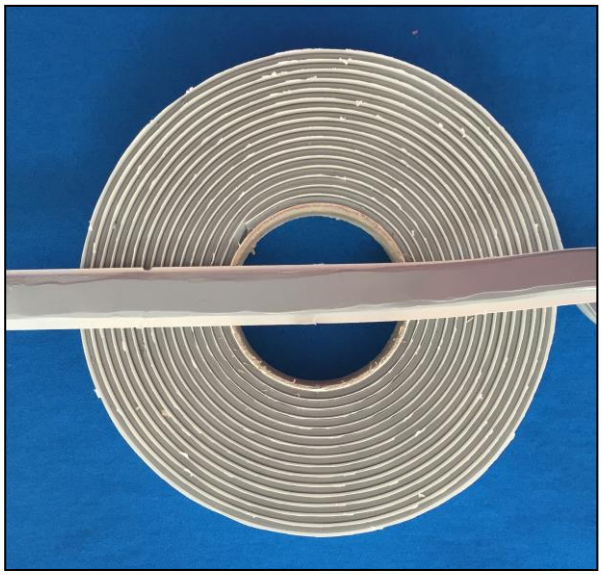
SK2ST130-1 is sealant tape for applications at room temperature and up to 130°C. It has been designed for ply compaction and debulking operations. This sealant tape provides excellent adhesion to films and tool surfaces and allows multiple sealing without loss of adhesive performance or vacuum tightness.

Apply on clean and dry tool silicon coated side paper on top. Remove the silicon paper and press the bagging film on the tapes. Roll-press and compress the sealant in order to ensure adherence and quality of the vacuum.

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

► TECHNICAL DATA

Material:	Synthetic polymer butyl based
Color:	Light grey
Maximum use temperature:	130°C



► SIZE

Thickness	Width	Length	Packing
3mm	12mm	15m	22roll/cs

Shelf life: 12 months.
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing. Not recommended to store by temperature over 30°C.

► **NOTE**

For clean removal, it is recommended to strip the tape from the mould surface once it has cooled down to room temperature.

TECHNICAL DATA SHEET

SK2ST150-2

Sealant Tape

Back to range

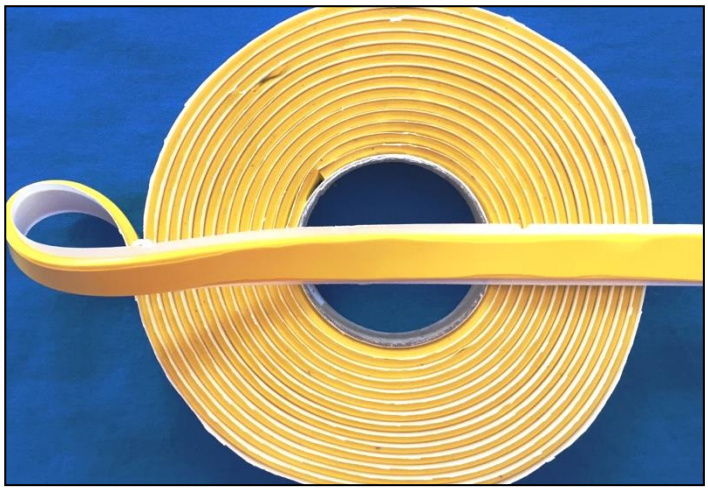
► DESCRIPTION

SK2ST150-2 is economical sealant tape for vacuum bagging applications where cost is a primary consideration. This tape maintains a good vacuum seal for vacuum bagging applications from room temperature to 150°C. It removes easily from all types of tools without residues.
It is ideally suited for debulking operation and resin infusion processes.
For clean removal, it is recommended to strip the tape from the mould surface once it has cooled down to room temperature.

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

► TECHNICAL DATA

Material:	Synthetic rubber
Colour:	Yellow
Maximum use temperature:	150°C (bag to tool) 180°C (bag to bag)



► SIZE

Thickness	Width	Length	Packing
3mm	12mm	15m	18 rolls per case

Shelf life: 18 months.
Storage conditions: it is recommended to store flat in original packing at temperatures between +10°C and +30°C.

► **NOTE**

All surfaces should be clean, dry and free from grease and loose materials. Apply directly from the reel onto one surface and press sufficiently along its whole length to achieve good initial adhesion. Remove backing paper at the joint between the tapes, place the second tape overlapping to the first and push firmly to seal across the joint. After placing the tape onto the surface remove backing paper, lay vacuum film on the strip. Apply pressure by hand or roller SK3ROL-1 to ensure tight connection. The maximum use temperature is dependent upon the duration at maximum temperature and is process specific, we recommend testing prior to use.

SK2ST200-1

Sealant Tape

Back to range

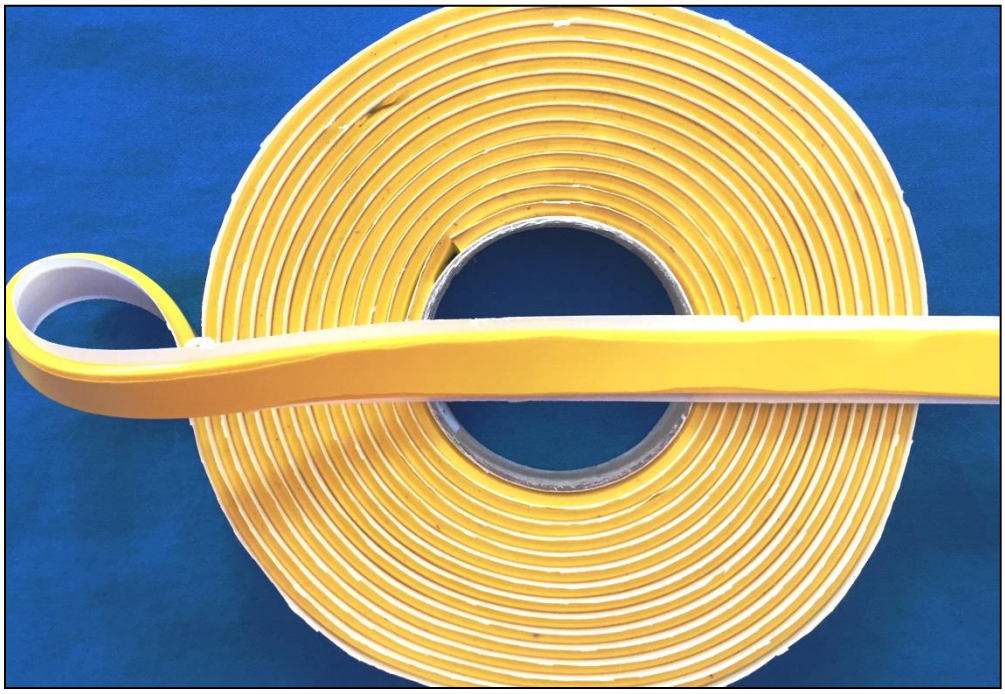
► DESCRIPTION

SK2ST200-1 is a sealant tape developed for vacuum bagging operations. This product has been formulated to outperform all tapes in its class. With aggressive initial tack, it will maintain an air-tight seal during the cure cycle, yet strip clean from the tool, with virtually no trace to residue. SK2ST200-1 provides easy de-bagging and minimal to no clean-up between production cycles. It exhibits these excellent usage and release characteristics from composite and metal tools, in both oven and autoclave applications.

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

The product has the following advantages:

- Easy to apply;
- Ideal for oven and autoclave cure;
- Excellent release for composite tooling;
- Uses include: debulking/compacting, envelope bagging, resin damming or as pressure strip;
- Maintains adhesion during low temperature cycling;
- Stripes clean from tool leaving no residue;
- Good adhesion to various films and tool surfaces;
- Non hazardous.



Instructions for application:

The surface should be clean, dry, smooth and dust-free.

- Place the stripe into the surface avoiding air bubbles with release paper on top;
- Remove the easy peel release film;
- Lay the film on top of the strip;
- Apply pressure by hand and/or roller SK3ROL-1 to ensure tight connection;

It is recommended to strip below 60°C to minimize the parts from becoming warped. The tape can be stripped without leaving a residue on metal and composite tool surfaces that have been cooled to room temperature.

► TECHNICAL DATA

Material:	Synthetic polymer butyl based	
Color:	Yellow	
Solids:	100%	
Hardness shore A	23 index	ASTM 2240
Loop Tack Test:	24,5N/25mm	ASTM D 1695
Probe Tack Test:	4N	ASTM D 2979
Application temperature:	5°C/50°C	
Recommended use T:	200°C	
Maximum use T:	204°C	

► SIZE

Thickness	Width	Length
3mm	12mm	9m

Shelf life: 12 months.
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing; if stored at a temperature between +10°C and +30°C the product must be used within 6 months; if stored at a temperature between +10°C and +25°C the product must be used within 12 months. The product is not affected by frost.

► NOTE

The quality and characteristics of materials remain unaltered for a very long time.
The product must be stored in a dry, covered place.

TECHNCAL DATA SHEET

SK2ST210-2

Sealant Tape with high tack and clean remove

Back to range

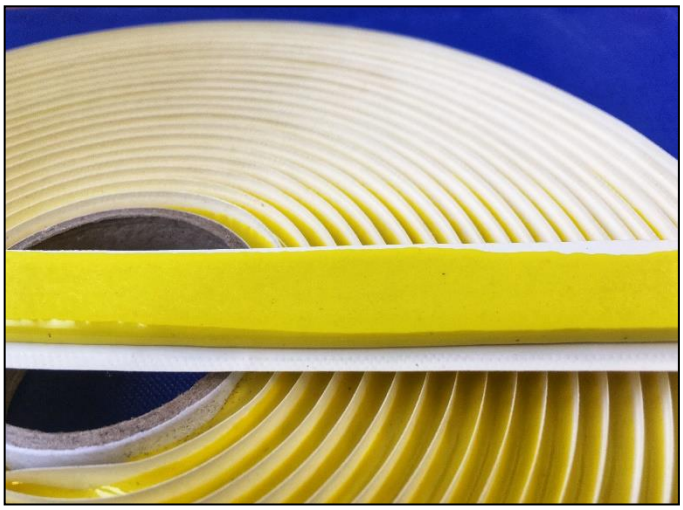
► DESCRIPTION

SK2ST210-2 is an economical multi-purpose sealant tape with high tack. It removes very easily from metal or composite tools without leaving any marks due to its new improved composition. Usable up to 210°C cures in oven or autoclave.
For clean removal, it is recommended to strip the tape from the mold surface once it has cooled down to room temperature.

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

► TECHNICAL DATA

Material:	Synthetic rubber
Color:	Yellow
Maximum use temperature:	210°C



► SIZE

Thickness	Width	Length	Packing
3mm	12mm	7,5m	40 rolls / case

Shelf life: 12 months with the respect to the storage conditions.

Storage conditions: it is recommended to store at temperatures between +10°C and +30°C stored flat in original packing.

► **NOTE**

All surfaces should be clean, dry and free from grease and loose materials. Apply directly from the reel onto one surface and press sufficiently along its whole length to achieve good initial adhesion. Remove backing paper and offer other surface to the tape and push firmly to seal across the joint.

TECHNCAL DATA SHEET

SK2ST399-1

Sealant tape for high temperature processes

Back to range

► DESCRIPTION

SK2ST399-1 is an advanced process vacuum bag tape sealant that was developed to fulfill the stringent requirements of very high temperature cure requirements. This sealant tape is formulated with a unique base polymer to function throughout a temperature range of 191°C to 399°C. Extended cure cycles of 12 hours or longer at intermediate temperatures of 204°C to 315°C are possible.

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

► TECHNICAL DATA

Color:	Dark brown
Percent solid:	100%
Maximum use temperature:	399°C
Consistency:	90-140
Cone penetration:	150 g load

► ADVANTAGES

- Easy to apply by hand (User friendly)
- Ideal for oven or autoclave cure
- 191°C to 399°C cure cycles
- Tenacious adhesion to polyimide films and tool surfaces
- Strips clean from tools surfaces
- Non-hazardous and thermally stable

► APPLICATION

Apply by hand to a clean dry tool or platen with release paper on top. When the sealant is in position remove the release paper and lay the film on top. Apply pressure by hand or roller on the sealant to obtain maximum adhesion and to ensure positive vacuum. A hot roller or iron (not to exceed 204°C) can be used to apply pressure on the sealant. It is recommended to strip below 66°C to minimize or reduce the parts from becoming warped. SK2ST399-1 can be stripped without leaving a residue on metal tool surfaces that have been cooled to room temperature.

Application Temperature Range:	7°C to 49°C
Service Temperature Range:	177°C to 399°C

► SIZE

Thickness	Width	Length	Packing
3mm	12mm	9m	24 rolls / case

Shelf life: 12 months from date of manufacture with the respect to the storage conditions.
Storage conditions: it is recommended to store at temperatures between +17°C and +27°C stored flat in original packing.

► NOTE

Material must be at room temperature for application.

Back to content

Name	Description	Max. use T°C	%PTFE	Thickness	Color
SK2RE260-1	Coated glass fabric, porous	260°C	38%	40µm	Brown
SK2RE260-2	Porous PTFE coated glass fabric	260°C	29%	60µm	Brown
SK2RE260-3	Coated glass fabric, not porous	260°C	68%	75µm	Brown
SK2RE260-4	Coated glass fabric, not porous	260°C	67%	150µm	Brown

SK2RE260-1

Porous PTFE coated release fabric

Back to range

► DESCRIPTION

PTFE coated very light fibreglass fabric, which provides controlled porosity and release from all conventional resin systems.

Product will allow excess resin, volatiles and trapped air to escape into the breather during cure.

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

► TECHNICAL DATA

Fibre type:	Glass
Color:	Brown
Weight:	40g/m²
Thickness:	40µm
Maximum use temperature:	260°C
PTFE content:	38%

► SIZE

Thickness	Width	Length
40 µm	1000mm	100m

Shelf life: 24 months
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

SK2RE260-2

Non porous PTFE coated release fabric

Back to range

► DESCRIPTION

PTFE coated fibreglass fabric, which provides controlled porosity and release from all conventional resin systems.

Product will allow excess resin, volatiles and trapped air to escape into the breather during cure.

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

► TECHNICAL DATA

Fibre type:	Glass
Color:	Brown
Weight:	68g/m²
Thickness:	60µm
Type of weave:	Plain
Maximum use temperature:	260°C
PTFE content:	29%

► SIZE

Thickness	Width	Length
60µm	1000mm	100m

Shelf life: 24 months
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Release fabric is also in 2000mm width available.

TECHNICAL DATA SHEET

SK2RE260-3

Non porous PTFE coated release fabric

Back to range

► DESCRIPTION

PTFE coated fibreglass fabric, is characterized by a highly consolidated of coating and smooth surface, resulting in excellent release from all conventional resin systems and insulation properties.

Non porous product will retain resin and provide extremely smooth surface.

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

► TECHNICAL DATA

Fibre type:	Glass
Color:	Brown
Weight:	155g/m²
Thickness:	75µm
Type of weave:	Plain
Maximum use temperature:	260°C
PTFE content:	68%

► SIZE

Thickness	Width	Length
75µm	1000mm	100m

Shelf life: 24 months
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

SK2RE260-4

Non porous PTFE coated release fabric

Back to range

► DESCRIPTION

PTFE coated heavy fibreglass fabric, is characterized by a highly consolidated of coating and smooth surface, resulting in excellent release from all conventional resin systems and insulation properties.

Non porous product will retain resin and provide extremely smooth surface.

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

► TECHNICAL DATA

Fibre type:	Glass
Color:	Brown
Weight:	315g/m²
Thickness:	150µm
Type of weave:	Plain
Maximum use temperature:	260°C
PTFE content:	67%

► SIZE

Thickness	Width	Length
150µm	1000mm	100m

Shelf life: 24 months
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

Polyester Peel Ply is specially designed for structural bonding by production of high performance composite parts.

Name	Description	Max. use T°C	Color	Stripes	Weight
SK2PP200-5	Tight woven peel ply for texturing the surface of composite laminate	200°C	White	-	60 g/m²
SK2PP200-3	Economical peel ply for resin infusion, autoclave and hand moulding	205°C	White	Blue (red)	92 g/m²
SK2PP200-8	Tight woven high-tenacity peel ply	200°C	White	-	99 g/m²
SK2PP180-5	Heavy peel ply for creation of textured surface of the laminate	200°C	White	Red	105 g/m²
SK2PP200-7	Tight woven high-tenacity peel ply	200°C	White	-	114 g/m²
SK2PP200-6	Tight woven high-tenacity peel ply	200°C	White	-	145 g/m²

Polyamide Peel Ply is more purpose material for standard application.

Name	Description	Max. use T°C	Color	Stripes	Weight
SK2PP170-3	Tight woven economial peel ply	180°C	White	-	60 g/m²
SK2PP230-3	High temperature tight woven peel ply	230°C	White	-	60 g/m²
SK2PP190-2	Tight woven polyamide peel ply	190°C	White	Red	64 g/m²
SK2PP230-1	Thermoset peel ply for high temperature processes	230°C	White	Red	82 g/m²
SK2PP170-1	Economical peel ply for application with epoxy and polyester resins	190°C	White	Red	85 g/m²
SK2PP220-1	Efficient peel ply for resin infusion, autoclave or hand lay-up processes	232°C	White	Red	85 g/m²
SK2PP190-3	Heat setted peel ply	205°C	Off-white	-	90 g/m²
SK2PP220-4	Inexpensive peel ply for resin infusion, autoclave or hand lay-up processes, taffeta	232°C	White	Red	90 g/m²

SK2PP220-2	High quality polyamide peel ply for resin infusion, autoclave or hand lay-up processes	232°C	White	Red or Green	95 g/m²
SK2PP232-3	Tight woven high-tenacity peel ply	232°C	White	-	105 g/m²
SK2PP250-1	Heavy duty peel ply for high temperature processes	250°C	White	-	110 g/m²
SKPP2232-2	Tight woven high-tenacity peel ply	250°C	White	-	120 g/m²
SK2PP232-1	High-tenacity peel ply without silicon coating	232°C	White	-	110 g/m²

Polyamide Peel Ply with release coating

Name	Description	Max. use T°C	Color	Stripes	Weight
SK2PP230-2	High temperature tight woven peel ply with silicon coating	230°C	White / Yellow / Light Blue	-	60g/m²
SK2PP230-4	High temperature tight woven peel ply with silicon coating	230°C	Light Blue/ Light Green	-	62 g/m²
SK2PP230-5	Tight woven nylon peel ply with silicon coating	230°C	Light Blue	-	60 g/m²

Polyamide Peel Ply with adhesive coating

Name	Description	Max. use T°C	Color	Stripes	Weight
SK2PP220-6	Polyamide peel ply for resin infusion, autoclave curing and hand lay-up, with adhesive coating, on liner	230°C	White	Red	85g/m²

SK2PP200-5

Tight woven peel ply

Back to range

► DESCRIPTION

SK2PP200-5 is a polyester tight woven peel ply for texturing the surface of composite laminate. It is used to texture the surface of a composite laminate. The peel ply surface is helpful for secondary bonding or painting of the composite laminate. SK2PP200-5 has no coating, assist or eliminate the need for sanding or abrasing on your composite laminate. The fabric is scoured and heat set to remove most contaminates and reduce shrinkage.

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

► TECHNICAL DATA

Material type:	Polyester
Color:	White
Surface weight:	60 g/m² ± 10%
Recommended use temperature:	190°C
Max. use temperature*:	204°C

► SIZE

Thickness	Width	Length
50µm	1500mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Peel plies are treated in order to remove all pollutant products (like silicones for example), which could be found on the laminate.
Hot knife slitting of the 1 master roll is possible upon request. 1 master roll is a minimum order quantity.
* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

SK2PP200-3

Peel ply

Back to range

► DESCRIPTION

SK2PP200-3 is a polyester peel ply designed to be drapable yet provide superior strength. It is used to texture the surface of a composite laminate. The peel ply surface is helpful for secondary bonding or painting of the composite laminate. SK2PP200-3 has no coating, assist or eliminate the need for sanding or abraiding on your composite laminate. The fabric is scoured and heat set to remove most contaminates and reduce shrinkage.

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

► TECHNICAL DATA

Material type:	Polyester
Color:	White
Stripes:	Blue, red
Surface weight:	92g/m²
Recommended use temperature:	190°C
Maximum use temperature:	205°C
Weave style:	Plain

► SIZE

Thickness	Width	Length
140µm	1520mm 1800mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Other weights or special sizes available on request.

► DESCRIPTION

SK2PP200-8 is a polyester tight woven high-tenacity peel ply for texturing the surface of composite part. The peel ply is made of high-tenacity polyester fiber. This high-tenacity version with good drapability is easy to use and to remove at the end of the process.

This high-tenacity polyester peel ply is used in processes with aggressive polymers, epoxy resins. The peel ply SK2PP200-8 leaves a textured surface which helps to reduce time for manual finishing.

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

► TECHNICAL DATA

Material type:	Polyester
Color:	White
Surface weight:	99 g/m² ± 10%
Max. use temperature*:	200°C

► SIZE

Reference for order	Width	Length
SK2PP200-8WH99N152100	1520mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Peel plies are treated in order to remove all pollutant products (like silicones for example), which could be found on the laminate.
Other weights or special sizes available on request.
* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

► DESCRIPTION

SK2PP180-5 – heavy polyester peel ply, for structural bonding, which are high in quality, yet inexpensive.
This peel ply is used to impart a textured fine surface impression to the molded component to improve adhesion of a composite laminate for priming and secondary structural bonding. Using of peel plies reduce or eliminate the need for sanding or abrading.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	Polyester
Color:	White
Stripes:	Red
Surface weight:	105g/m²
Maximum use temperature:	200°C
Weave style:	Plain
Tensile strength Warp:	1685 N
Tensile strength Weft:	1407 N

► SIZE

Thickness	Width	Length
140µm	1520mm	100m
140µm	1520mm	200m
140µm	1800mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30° in original packing.

► NOTE

Material is deoiled and heat set – thermic stabilized by heat treated to remove all possible pollutants and reduces shrinkage.
* Maximum use temperature should be determined in actual process conditions. The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

SK2PP200-7

Tight woven peel ply

Back to range

► DESCRIPTION

SK2PP200-7 is a polyester tight woven high-tenacity peel ply for texturing the surface of composite part. The peel ply is made of high-tenacity polyester fiber. This high-tenacity version with good drapability is easy to use and to remove at the end of the process.

This high-tenacity polyester peel ply is used in processes with aggressive polymers, epoxy resins. The peel ply SK2PP200-7 leaves a textured surface which helps to reduce time for manual finishing.

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

► TECHNICAL DATA

Material type:	Polyester
Color:	White
Surface weight:	114 g/m² ± 10%
Max. use temperature*:	200°C

► SIZE

Reference for order	Width	Length
SK2PP200-7WH114N152100	1520mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Peel plies are treated in order to remove all pollutant products (like silicones for example), which could be found on the laminate.
Other weights or special sizes available on request.
* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

SK2PP200-6

Tight woven peel ply

Back to range

► DESCRIPTION

SK2PP200-7 is a polyester tight woven high-tenacity peel ply for texturing the surface of composite part. The peel ply is made of high-tenacity polyester fiber. This high-tenacity version with good drapability is easy to use and to remove at the end of the process.

This high-tenacity polyester peel ply is used in processes with aggressive polymers, epoxy resins. The peel ply SK2PP200-7 leaves a textured surface which helps to reduce time for manual finishing.

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

► TECHNICAL DATA

Material type:	Polyester
Color:	White
Surface weight:	114 g/m² ± 10%
Max. use temperature*:	200°C

► SIZE

Reference for order	Width	Length
SK2PP200-7WH114N152100	1520mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Peel plies are treated in order to remove all pollutant products (like silicones for example), which could be found on the laminate.
Other weights or special sizes available on request.
* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

► DESCRIPTION

SK2PP230-3 is high temperature tightly woven nylon fabric leaving a fine textured surface. This peel ply is scoured and heat set to remove contaminates and reduce shrinkage.

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

► TECHNICAL DATA

Fiber type:	Nylon (Polyamide)
Color:	White
Weight:	60g/m²
Maximum use temperature:	230°C
Extractable materials:	<0,2%
Tensile strength MD:	>280N/cm
Tensile strength TD:	>280N/cm

► SIZE

Thickness	Width	Length
50µm	1520mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in the original packing.

► NOTE

Other width or special sizes available on request.
Other colors available on request.

SK2PP170-3

Peel ply

Back to range

► DESCRIPTION

SK2PP170-3 is a tight woven economical peel ply with good performance. The product is designed to work in resin infusion or hand lay-up processes. SK2PP170-3 has no coating, assist or eliminate the need for sanding or abrading on your composite laminate. The fabric is scoured and heat set to remove most contaminates and reduce shrinkage.

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

► TECHNICAL DATA

Material type:	Nylon (Polyamide)
Color:	White
Surface weight:	60 g/m²
Maximum use temperature:	180 °C
Wrap tensile:	>118 N/cm
Weft tensile:	>85 N/cm

► SIZE

Thickness	Width	Length
50µm	1500mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Other weights or special sizes available on request.

SK2PP230-1

Peel Ply

Back to range

► DESCRIPTION

SK2PP230-1 is a peel ply, used to texture the surface of a composite laminate. The peel ply surface is helpful for secondary bonding or painting of the composite laminate. Peel ply fabrics may reduce or eliminate the need for sanding or abrading.

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

► TECHNICAL DATA

Fiber type:	Nylon (Polyamide)
Color:	White
Tracer:	Red
Weight:	82g/m²
Maximum use temperature	230°C
Weave style:	Plain
Warp count fil/cm:	19
Warp count fil/cm:	14,8
Warp resistance DaN/5cm:	155
Weft resistance DaN/5cm:	115
Warp elongation %:	23
Weft elongation %:	20,5
Extractable %:	0,02

► SIZE

Thickness	Width	Length
0,172 mm	1630mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Peel plies are treated in order to remove all pollutant products (like silicones for example) which could be found on the laminate.
Hot knife slitting of the 1 master is possible upon request. 1 roll is a minimum order quantity.

SK2PP190-2

Tight woven peel ply

Back to range

► DESCRIPTION

SK2PP190-2 is a light polyamide tight woven peel ply with good performance when used with epoxy, vinyl and polyester resins in the process till 190°C. It has red tracers with high visibility to reduce the risk of peel ply being left on the part. SK2PP190-2 gives a slightly textured surface to the laminate that allows making secondary operations such as bonding or painting.

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

► TECHNICAL DATA

Material type:	Nylon (Polyamide)
Color:	White
Stripes:	Red
Surface weight:	64 g/m² ± 10%
Max. use temperature*:	190°C

► SIZE

Thickness	Width	Length
70µm	1570mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Peel plies are treated in order to remove all pollutant products (like silicones for example), which could be found on the laminate.
Other weights or special sizes available on request.

* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

TECHNICAL DATA SHEET

SK2PP170-1
Peel Ply

Back to range

► DESCRIPTION

SK2PP170-1 is an economical polyamide peel ply with good performance when used with both polyester and epoxy resins. It has black tracers with high visibility to reduce the risk of peel ply being left on the part. The product is designed to work in resin infusion or hand lay-up processes. SK2PP170-1 has no coating, assist or eliminate the need for sanding or abraiding on your composite laminate. The fabric is scoured and heat set to remove most contaminates and reduce shrinkage.

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

► TECHNICAL DATA

Material type:	Nylon (Polyamide)
Color:	White
Stripes:	Red
Surface weight:	85g/m²
Maximum use temperature:	190 °C
Weave style:	Plain

► SIZE

Thickness	Width	Length
140µm	1800mm	200m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Other weights or special sizes available on request.

TECHNICAL DATA SHEET

SK2PP220-1

Peel Ply

Back to range

► DESCRIPTION

SK2PP220-1 is an economic peel ply, which is high in quality, yet inexpensive. It is designed to work in resin infusion, autoclave or hand lay-up processes. Using of SK2PP220-1 assists or eliminates the need for sanding or braiding on your composite laminate.

This peel ply could be used with epoxy, polyester and vinylester resins in the processes till 220°C.

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

► TECHNICAL DATA

Material type:	Nylon (Polyamide)
Color:	White
Stripers:	Red
Surface weight:	85g/m²
Maximum use temperature:	232 °C
Recommended use temperature:	220 °C
Thickness:	0,13 mm

► SIZE

Thickness	Width	Length
130µm	1520mm	200m

Shelf life: unlimited

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► **NOTE**

Peel plies are treated in order to remove all pollutant products (like silicones for example), which could be found on the laminate.
Hot knife slitting of the 1 master roll is possible upon request. 1 master roll is a minimum order quantity.
Other widths and length of roll available at special order. Maximum width of the roll is 1800mm.

Maximum use temperature should be determined under your actual process conditions.

► DESCRIPTION

High tenacity polyamide peel ply, which could be used with epoxy, vinylester and polyester resins in the processes till 205°C. This peel ply is used to impart textured surface to the molded component to allow secondary operations such as painting.

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

► TECHNICAL DATA

Material type:	Nylon (Polyamide)
Color:	Off-white
Stripers:	-
Surface weight:	90g/m²
Maximum use temperature:	205 °C
Weave style:	Plain

► SIZE

Thickness	Width	Length
180µm	1640mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Peel plies are treated in order to remove all pollutant products (like silicones for example) which could be find on the laminate.

Hot knife slitting of the 1 master is possible upon request. 1 roll is a minimum order quantity.

TECHNICAL DATA SHEET

SK2PP220-4

Peel Ply

Back to range

► DESCRIPTION

SK2PP220-4 - inexpensive high quality peel ply designed to work in resin infusion, autoclave or hand lay-up processes. Using of SK2PP220-4 assists or eliminates the need for sanding or braiding on your composite laminate.

This peel ply could be used with epoxy, polyester and vinylester resins in the processes till 232°C.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	Nylon (Polyamide)
Color:	White
Stripes:	Red
Surface weight:	90g/m²
Maximum use temperature:	232 °C

► SIZE

Thickness	Width	Length
140µm	1560mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTES

Peel plies are treated in order to remove all pollutant products (like silicones for example), which could be found on the laminate.
Hot knife slitting of the 1 master roll is possible upon request. 1 master roll is a minimum order quantity.

SK2PP220-2

Peel Ply

Back to range

► DESCRIPTION

SK2PP220-2 is a high quality polyamide peel ply of average surface weight with red stripes visible before and after curing, that reduce the risk to be left on the part surface. This peel ply can be used for infusion, autoclave or hand molding. Using of peel plies reduce or eliminate the need for sanding or abrading of composite laminate.

This peel ply could be used with epoxy, polyester and vinylester resins in the processes till 232°C.

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

► TECHNICAL DATA

Material type:	Nylon (Polyamide)
Color:	White
Stripes:	Red or green
Tensile strength wrap:	380N/cm
Tensile strength weft:	350N/cm
Surface weight:	95g/m²
Recomm. use temperature:	220°C
Maximum use temperature:	232°C
Weave style:	Plain

► SIZE

Thickness	Width	Length
130µm	1500mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Other weights or special sizes available on request.
Peel ply can be supplied with width varies from 25mm until 3000 mm.

TECHNICAL DATA SHEET

SK2PP232-3

Heat set peel ply

Back to range

► DESCRIPTION

SK2PP232-3 is a polyamide high-tenacity heat set peel ply used to texture the surface of a composite laminate. The clean, textured surface after using the peel ply allows the secondary bonding or painting. SK2PP232-3 peel ply may reduce or eliminate the need for sanding or abrading of the surface of a composite part. The peel ply is made of high-tenacity polyamide fiber.

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

► TECHNICAL DATA

		Standard
Material type:	Polyamide 66	
Color:	White	
Surface weight:	105 g/m² ± 5%	GB/T4669-2008
Density:	(22×20) ±5 % (yarn/cm)	FZ/T 01093-2008
Tensile strength (Warp):	≥1600	ISO13934.1
Tensile strength (Weft):	≥1500	ISO13934.1
Max. use temperature*:	232°C	

► SIZE

Thickness	Width	Length
130 - 200µm	1520mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Other weights or special sizes available on request.

* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

SK2PP250-1

Heavy duty peel ply

Back to range

► DESCRIPTION

for sanding or abrading by producing of composite laminates. This fabric is scoured and heat set to remove contaminates and reduce shrinkage.

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

► TECHNICAL DATA

		Test method
Composition:	Nylon (Polyamide)	
Color:	White	
Wrap:	Polyamide HT 235 DTEX	NF GO1074
Weft:	Polyamide HT 235 DTEX	
Weave count (yarn/cm):	22 x 21, 5 ± 1cm	NF GO7155
Normal weight:	110g/m²	NF GO7150
Width cm:	160 cm usable	
Weave:	Plain weave fabric	
Treatment:	Heat set	
Tensile strength warp:	>150 daN	ISO 13934-1
Tensile strength weft:	>150 daN	ISO 13934-1
Elongation warp %:	25%	ISO 13934-1
Elongation weft %:	25%	ISO 13934-1
Max use temperature:	250°C	

► SIZE

Thickness	Width	Length
200µm	1600mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between -20°C and +30°C in original packing.

SK2PP232-2

Peel ply

Back to range

► DESCRIPTION

SK2PP232-2 is a high-tenacity nylon, un-dyed, scoured and heatset peel ply, used to texture the surface of a composite laminate. The peel ply surface is helpful for secondary bonding or painting of the composite laminate. Peel ply fabrics may reduce or eliminate the need for sanding or abrading.

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

► TECHNICAL DATA

		Standard
Fiber type:	Nylon (Polyamide)	
Color:	Natural White	
Dtex:	233 ± 5%	
Weight:	120 ± 5 g/m²	GB/T4669-2008
Density:	(23×24) ± 5% yarn/cm	FZ/T 01093-2008
Maximum use temperature:	230°C	
Tensile strength (Warp):	≥1700	ISO13934.1
Tensile strength (Weft):	≥1700	ISO13934.1

► SIZE

Thickness	Width	Length
200µm	152cm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in the original packing.

► NOTE

Other width or special sizes available on request.

TECHNICAL DATA SHEET

SK2PP232-1

High-tenacity polyamide peel ply

Back to range

► DESCRIPTION

SK2PP232-1 is a high-tenacity, higly drapable polyamide peel ply without silicon coating used to texture the surface of a composite laminate. The clean, textured surface after using the peel ply allows the secondary bonding or painting. SK2PP232-1 peel ply may reduce or eliminate the need for sanding or abrading of the surface of a composite part. The peel ply is made of high-tenacity polyamide fiber.

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

► TECHNICAL DATA

		Standard
Material type:	Polyamide 66	
Color:	White	
Surface weight:	139 g/m² ± 5%	GB/T4669-2008
Max. use temperature*:	232°C	

► SIZE

Reference for order	Width	Length
SK2PP232-1WH139N152229	1524mm	229m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Other weights or special sizes available on request.

* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

► DESCRIPTION

SK2PP230-2 is high temperature tightly woven nylon fabric coated with a silicone release agent. It provides very good release after curing as silicone prevents the fabric from bonding to the laminate surface. It will provide easy release from most resin systems.

All silicone coated peel plies have the potential to transfer. This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Fiber type:	Nylon (Polyamide)
Coating:	Silicone
Color:	White / Yellow / Light blue
Weight:	60g/m²
Maximum use temperature	230°C
Extractable materials:	<0,2%
Tensile strength MD:	>280N/cm
Tensile strength TD:	>280N/cm

► SIZE

Thickness	Width	Length
85µm	1520mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in the original packing.

► NOTE

Other width or special sizes available on request.

TECHNICAL DATA SHEET

SK2PP230-4

Tight woven peel ply

Back to range

► DESCRIPTION

SK2PP230-4 is a tight woven nylon peel ply with silicon coating. It provides good release property and is widely used in molding process of wind energy, marine, aerospace. All coated peel plies have the potential to transfer of the part.

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

► TECHNICAL DATA

Fiber type:	Nylon (Polyamide)
Color:	Light blue/ light green
Weight:	62 g/m²
Maximum use temperature:	232°C

► SIZE

Thickness	Width	Length
100мкм	1520mm	91,44m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in the original packing.

► NOTE

Other width or special sizes available on request.
Other colors available on request.

TECHNICAL DATA SHEET

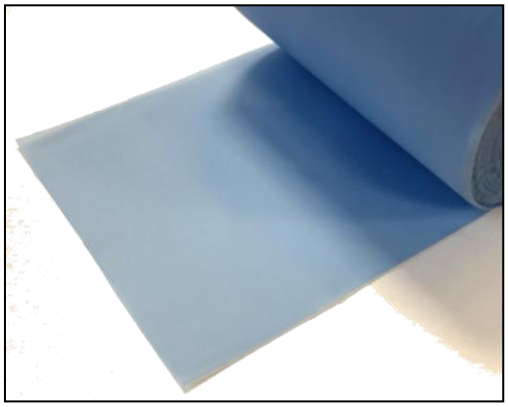
SK2PP230-5

Tight woven peel ply

Back to range

► DESCRIPTION

SK2PP230-5 is a tight woven nylon peel ply with silicon coating. It provides good release properties with most resin systems and is widely used in molding process of wind energy, marine and security glass production. All coated peel plies have the potential to transfer of the part.



► TECHNICAL DATA

Fiber type:	Nylon (Polyamide)
Color:	Light blue
Weight:	60 g/m²
Maximum use temperature:	232°C

► SIZE

Reference to order	Width	Length
SK2PP230-5LB60N7.5100	75mm	100m
SK2PP230-5LB60N10100	100mm	100m
SK2PP230-5LB60N12100	120mm	100m
SK2PP230-5LB60N14100	140mm	100m
SK2PP230-5LB60N16100	160mm	100m
SK2PP230-5LB60N152100	1520mm	100m

► NOTE

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in the original packing.
Other width or special sizes available on request.

TECHNICAL DATA SHEET

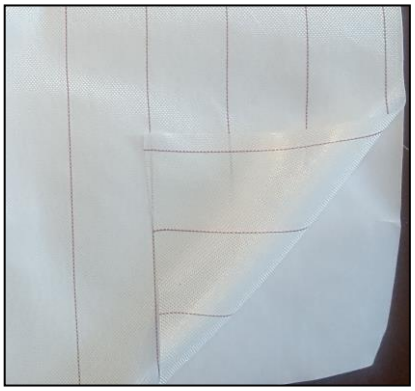
SK2PP220-6 AD

Peel Ply with adhesive coating

Back to range

► DESCRIPTION

SK2PP220-6 AD is an economic high-quality polyamide peel ply with adhesive coating, which could be used with epoxy and polyester resins in the processes till 230°C. There is no release agent or silicon in the fabric so there is no contamination. Peel ply removes easily without rests on the part. The structure of the material and its porosity allows a good migration of the resin excess into breeder during the process. With already applied adhesive on the surface and with liner, this peel ply avoids to use hazardous spray, it is solvent free and it keeps a very high permeability. The adhesive is soluble with resins.
SK2PP220-6 AD is not recommended for phenolic systems.
This product is used in various manufacturing processes of parts made of composite materials.



► TECHNICAL DATA

Material type:	Nylon (Polyamide)
Color:	White
Stripers:	Red
Surface weight without adhesive:	85g/m²
Maximum use temperature*:	230°C

► SIZE

Thickness	Width	Length
160µm	1000mm	50m
160µm	200mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in original packing.

► NOTE

Peel plies are treated in order to remove all pollutant products (like silicones for example), which could be found on the laminate.
Hot knife slitting of the 1 master roll is possible upon request. 1 master roll is a minimum order quantity.
* Maximum use temperature should be determined in actual process conditions. The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

Name	Description	Max. use T°C	Weight
SK2BB190-4	Economic, heavy, non-woven breather	190°C	340g/m²
SK2BB205-1	Ultra-light non-woven breather	205°C	100g/m²
SK2BB205-2	Light non-woven breather	205°C	140g/m²
SK2BB205-2 FR	Light non-woven fire retardant breather	205°C	140g/m²
SK2BB205-3	Medium non-woven breather	205°C	237g/m²
SK2BB205-4	Heavy non-woven breather	205°C	340g/m²
SK2BB205-4 FR	Heavy non-woven fire retardant breather	205°C	340g/m²
SK2BB205-5	High resistance non-woven breather	205°C	340g/m²
SK2BB205-6	Very heavy non-woven breather	205°C	600g/m²
SK2BB205-6 FR	Very heavy non-woven fire retardant breather	205°C	600g/m²
SK2BB205-7	Heavy, high resistance, non-woven polyester breather	205°C	400g/m²
SK2BB205-8	Medium non-woven polyester breather for high pressure cycles	205°C	300g/m²
SK2BB230-2	Light non-woven polyamide breather	230°C	200g/m²
SK2BB230-3	Medium weight non-woven polyamide breather	230°C	230g/m²
SK2BB230-4	Medium weight non-woven polyamide breather	230°C	340g/m²
SK2BB230-5	Heavy weight non-woven polyamide breather	230°C	440g/m²
SK2BB427-1	Fiberglass breather for high temperature applications	427°C	610g/m²

SK2BB190-4

Breather/bleeder

Back to range

► DESCRIPTION

SK2BB190-4 is an economic, heavy, non-woven polyester breather partly made from secondary material fibers. It can be used for debulking and autoclave processes. The breather is stretchable and has good drapability for complex shapes.

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

► TECHNICAL DATA

Material type:	Polyester
Weight:	340 g/m²
Maximum use temperature	190°C
Color:	White
Fibre thickness:	17dtex

► SIZE

Width	Length
1500mm	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

SK2BB205-1

Breather/bleeder

Back to range

► DESCRIPTION

This ultra-light weight non-woven polyester breather could be used for low pressure curing up to 2 bars. It is stretchable and conforms well. Material can be used as a bleeder at any pressure.

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

► TECHNICAL DATA

Material type:	Polyester
Weight:	100g/m²
Maximum use temperature	205°C
Color:	White
Fibre thickness:	6,7dtex

► SIZE

Thickness	Width	Length
2,5 - 3mm	1500mm	100m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4m.

SK2BB205-2

Breather/bleeder

Back to range

► DESCRIPTION

This light weight non-woven polyester breather could be used for medium pressure curing. It is stretchable and has good drapability.

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

► TECHNICAL DATA

Material type:	Polyester
Weight:	140g/m²
Maximum use temperature:	205°C
Color:	White
Fibre thickness:	6,7dtex

► SIZE

Thickness	Width	Length
3-3,5mm	1000mm	100m
3-3,5mm	1500mm	100m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4m.

SK2BB205-2 FR

Fire Retardant Breather/bleeder

Back to range

► DESCRIPTION

This light weight non-woven fire retardant polyester breather could be used for medium pressure curing. It is stretchable and has good drapability. All breathers with mark “FR” (fire retardant) are recommended for use in non-inert curing atmosphere.

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

► TECHNICAL DATA

Material type:	Polyester FR
Weight:	140g/m²
Maximum use temperature:	205°C
Recommended pressure:	up to 3,5 Bar
Color:	White

► SIZE

Width	Length
1500mm	100m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.

SK2BB205-3

Breather/bleeder

Back to range

► DESCRIPTION

This medium weight non-woven polyester breather could be used for medium pressure curing. It is stretchable and has good drapability.

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

► TECHNICAL DATA

Material type:	Polyester
Weight:	237g/m²
Maximum use temperature:	205°C
Color:	White
Fibre thickness:	17dtex

► SIZE

Thickness	Width	Length
4-5mm	1500mm	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4m.

► DESCRIPTION

This heavy weight non-woven polyester breather is used for high pressure cycles. It offers good elongation and avoids any sharp radius for vacuum bag protection.

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

► TECHNICAL DATA

Material type:	Polyester
Weight:	340g/m²
Maximum use temperature:	205°C
Color:	White
Fibre thickness:	17dtex

► SIZE

Thickness	Width	Length
5-6mm	1500mm	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4m.

TECHNICAL DATA SHEET

SK2BB205-4 FR

Fire Retardant Breather/bleeder

Back to range

► DESCRIPTION

This heavy weight non-woven fire retardant polyester breather is used for high pressure cycles. It offers good elongation and avoids any sharp radius for vacuum bag protection. All breathers with mark “FR” (fire retardant) are recommended for use in non-inert curing atmosphere.

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

► TECHNICAL DATA

Material type:	Polyester FR
Weight:	340g/m²
Maximum use temperature:	205°C
Recommended max. pressure:	up to 7 Bar
Color:	White

► SIZE

Width	Length
1500mm	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.

SK2BB205-5

Breather/bleeder

Back to range

► DESCRIPTION

This heavy, high resistance, non-woven polyester breather is used for high pressure long curing cycles. It offers good elongation and avoids any sharp radius for vacuum bag protection.

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

► TECHNICAL DATA

Material type:	Polyester
Weight:	340g/m²
Maximum use temperature:	205°C
Color:	White
Fibre thickness:	28dtex

► SIZE

Thickness	Width	Length
5-6mm	1500mm	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 3m.

SK2BB205-6

Breather/bleeder

Back to range

► DESCRIPTION

This very heavy, high resistance, non-woven polyester breather is used for high pressure long curing cycles. It avoids any sharp radius for vacuum bag protection.

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

► TECHNICAL DATA

Material type:	Polyester
Weight:	600g/m²
Maximum use temperature:	205°C
Color:	White
Fibre thickness:	17dtex

► SIZE

Thickness	Width	Length
6-7mm	1500mm	25m

Shelf life: not limited.
it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4m.

SK2BB205-6 FR

Fire Retardant Breather/bleeder

Back to range

► DESCRIPTION

Very heavy high resistance nonwoven fire retardant polyester breather is used for high pressure long curing cycles. It offers good elongation and avoids any sharp radius for vacuum bag projection. All breathers with mark “FR” (fire retardant) are recommended for use in non-inert curing atmosphere.
This product is used in various manufacturing processes of parts made of composite materials.

►TECHNICAL DATA

Material type:	Polyester FR
Weight:	600g/m²
Maximum use temperature:	205°C
Recommended max. pressure:	up to 14 Bar
Color:	White

► SIZE

Width	Length
1520 mm	22m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.

SK2BB205-7

Breather/bleeder

Back to range

► DESCRIPTION

This heavy, high resistance, non-woven polyester breather is used for high pressure long curing cycles. It offers good elongation and avoids any sharp radius for vacuum bag protection.

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

► TECHNICAL DATA

Material type:	Polyester
Weight:	400g/m²
Maximum use temperature	205°C
Color:	White
Fibre thickness:	17dtex

► SIZE

Thickness	Width	Length
7-7,5mm	1500mm	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4 m.

SK2BB205-8

Breather/bleeder

Back to range

► DESCRIPTION

This medium weight non-woven polyester breather is used for high pressure cycles. It offers good elongation and avoids any sharp radius for vacuum bag protection.

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

► TECHNICAL DATA

Material type:	Polyester
Weight:	300g/m²
Maximum use temperature:	205°C
Color:	White
Fibre thickness:	17dtex

► SIZE

Thickness	Width	Length
5,5mm	1,5m	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperatures between -20°C and +30 °C in original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4m.

SK2BB230-2

Breather/bleeder

Back to range

► DESCRIPTION

This light weight, non-woven polyamide breather is used for high temperature cycles with high pressure. It offers good elongation and avoids any sharp radius for vacuum bag protection conducting away volatiles at pressures exceeding 7 bars. The material can be used with all resin systems. This breather is reusable.

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

► TECHNICAL DATA

Material type:	Polyamide 6.6
Weight:	200g/m²
Maximum use temperature:	230°C
Color:	White
Fibre thickness:	17dtex

► SIZE

Thickness	Width	Length
3,5-4mm	1,5m	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4m.

SK2BB230-3

Breather/bleeder

Back to range

► DESCRIPTION

This medium weight non-woven polyamide breather could be used for high pressure curing. It is stretchable and has good drapability.

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

► TECHNICAL DATA

Material type:	Polyamide 6.6
Weight:	230g/m²
Maximum use temperature	230°C
Color:	White
Fibre thickness:	17dtex

► SIZE

Thickness	Width	Length
4-5 mm	1500mm	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4m.

SK2BB230-4

Breather/bleeder

Back to range

► DESCRIPTION

This medium weight, non-woven polyamide breather is used for high temperature cycles with high pressure. It offers good elongation and avoids any sharp radius for vacuum bag protection conducting away volatiles at pressures exceeding 7 bars. The material can be used with all resin systems. This breather is reusable.

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

► TECHNICAL DATA

Material type:	Polyamide 6.6
Weight:	340g/m²
Maximum use temperature:	230°C
Color:	White
Fibre thickness:	17dtex

► SIZE

Thickness	Width	Length
5-6mm	1,5m	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4m.

SK2BB230-5

Breather/bleeder

Back to range

► DESCRIPTION

This high weight, non-woven polyamide breather is used for high temperature cycles with high pressure. It offers good elongation and avoids any sharp radius for vacuum bag protection conducting away volatiles at pressures exceeding 7 bars. The material can be used with all resin systems. This breather is reusable.

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

► TECHNICAL DATA

Material type:	Polyamide 6.6
Weight:	440g/m²
Maximum use temperature:	230°C
Color:	White
Fibre thickness:	17dtex

► SIZE

Thickness	Width	Length
7,5-8mm	1,5m	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.
Max. width is 2,4m.

TECHNICAL DATA SHEET

SK2BB427-1

Fiberglass breather for high temperature applications

Back to range

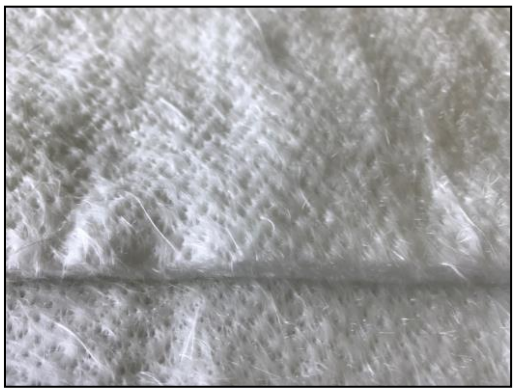
► DESCRIPTION

SK2BB427-1 is a non-woven fiberglass breather which is more convenient at usage than woven fiberglass breather due to the high drapability of material. This product is designed for high temperature thermoset and thermoplastic resins. It makes an easier transition for the vacuum bag and in any radius. Only one layer of breather provides good breathing at high temperatures until 427°C.

The product is incombustible and has excellent insulating properties and good vibration stability.

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

► TECHNICAL DATA



Raw material:	Glass fibres
Weight:	610g/m²
Maximum use temperature:	427°C
Color:	White

► SIZE

Width	Length
1,15m	50m

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other widths are available on special order.

Name	Description	Max. use T°C	Total thickness	Carrier type	Adhe-sive type	Color
SK2AT60-1	Double coated tape	60°C	280µm	Cloth	Rubber	White
SK2AT100-2	Double coated tape from fiber glass	100°C	300µm	Glass fiber	Acrylic	White
SK2AT130-2	Polyester tape with acrylic adhesive system	130°C	60µm	Polyester	Acrylic	Light blue transparent
SK2AT180-1	Masking and holding tape	180°C	64µm	Polyester	Rubber	Yellow
SK2AT180-2	Tape with high release properties, which could be used on the mould and cores	180°C	88µm	PTFE	Acrylic	Brown
SK2AT180-3	Polyester tape with rubber-based pressure sensitive thermosetting adhesive system	180°C	85µm	Polyester	Rubber	Yellow
SK2AT200-1	Double coated tape	200°C	210µm	Polyester	Acrylic	White with red liner
SK2AT200-3	High temperature double coated tape	205°C	100µm	Polyester	Acrylic	White
SK2AT204-1	Economical adhesive tape	204°C	60µm	Polyester	Silicone	Blue
SK2AT204-2	Economical adhesive tape	204°C	85µm	Polyester	Silicone	Blue
SK2AT204-3	Polyimide adhesive tape	204°C	70µm	Polyimide	Acrylic	Amber
SK2AT204-5	Economical adhesive tape	204°C	170µm	Polyester	Silicone	Blue
SK2AT205-1	Masking and holding tape	205°C	55µm	Polyester	Silicone	Blue
SK2AT205-2	Masking and holding tape	205°C	90µm	Polyester	Silicone	Blue
SK2AT205-3	Masking and holding tape	205°C	170µm	Polyester	Silicone	Blue
SK2AT205-4	High tack holding tape	205°C	100µm	Polyester	Silicone	Green
SK2AT205-5	Strong tear resistant polyester adhesive tape with non-silicone adhesive	205°C	100µm	Polyester	Rubber	Green

SK2AT205-6	All-purpose polyester adhesive tape with non-silicone adhesive	205°C	80µm	Polyester	Rubber	Green
SK2AT205-7	Tough abrasion-resistant adhesive tape	205°C	100µm	Polyester	Silicone	Red
SK2AT205-8	High strength polyester adhesive tape for application in extreme conditions	205°C	175µm	Polyester	Rubber	Green
SK2AT260-4	Release tape with high elongation for use on tooling blocks and other areas	260°C	88µm	PTFE	Silicone	Brown
SK2AT260-5	Extruded PTFE release tape with high elongation for use on tooling blocks and other areas	260°C	90µm	PTFE	Silicone	Orange
SK2AT260-8	PTFE coated glass fabric adhesive tape for self-wound adhesive	260°C	80µm	PTFE coated glass fabric	Silicone	Brown
SK2AT399-1	High temperature holding tape	399°C	65µm	Polyimide	Silicone	Amber
SK2AT399-2	High temperature double coated holding tape	399°C	100µm	Polyimide	Silicone	Amber

TECHNICAL DATA SHEET

SK2AT60-1

Double side coated adhesive tape

Back to range

► DESCRIPTION

The tape is an all-purpose double-backed holding tape. It is a cloth tape coated on both sides with rubber adhesive. Tape is designed to hold honeycomb cores during machining, spiral wrap in resin infusion process and fix table protection sheet SK3TUT-1 on the table.

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

► TECHNICAL DATA

Carrier type:	Cloth
Adhesive type:	Rubber
Color:	White
Total thickness:	280µm
Carrier thickness:	100µm
Adhesive thickness:	90µm x 2
Adhesion to steel:	13,9N/25mm
Maximum use temperature:	60°C
Elongation on break:	8%

► SIZE

Width	Length	Packaging
25mm	33m	36 rolls/cs
50mm	33m	16 rolls/cs

Shelf life: 18 months in original packing
Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

SK2AT100-2

Double side coated adhesive tape

Back to range

► DESCRIPTION

SK2AT100-2 is a double adhesive tape based on glass fiber of 45 g/m^2. It is used for local fixing of reinforcement in the processes with closed mould.

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

► TECHNICAL DATA

Carrier type:	Glass fiber
Adhesive type:	ACR
Color	White
Total weight:	72g/m2
Glue weight:	26 g/m2
Warp:	3,7 Ends / cm x 2 x 34 tex glass
Weft:	3 Ends / cm x 68 tex glass
Tensile strength MD:	800 N/5 cm
Tensile strength TD:	700 N/5 cm
Elongation at break MD:	3%
Elongation at break TD:	3%
Maximum use temperature:	100°C

► SIZE

Thickness	Width	Length
0,3mm	30mm	100m

Shelf life: 12 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Packaging: 34 rolls per carton, 36 cartons par pallet.

SK2AT130-2

Adhesive Tape

Back to range

► DESCRIPTION

SK2AT130-2 is a high temperature resistant polyester film with acrylic adhesive system. Designed to perform as a fixing and/or flash tape in production of composite parts/products in low temperature oven or autoclave cures. Also deployed in masking & splicing applications requiring high chemical and/or temperature resistance. The product is used in processes requiring temperature performance up to 130°C.

Advantages:

- Low/no residue applications
- Resistance to fumes and chemicals
- Controlled unwind enables easy manual or machine application
- Tough tape structure will not break or tear during application or removal

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Acrylic
Color:	Light blue transparent
Total thickness:	60µm
Carrier thickness:	25µm
Adhesive thickness:	35µm
Maximum use temperature:	130°C
Elongation:	100%
Tensile strength:	102 N/25mm

► SIZE

Width	Length
25mm	66m
50mm	66m

Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

SK2AT180-1

Adhesive tape

Back to range

► DESCRIPTION

SK2AT180-1 is polyester tape coated rubber adhesive. This tape is designed for holding vacuum bagging materials and thermocouple wires on metal or composites parts and tools in sensitive areas where silicone adhesive is not permitted.

The tape removes easily after the cure.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Rubber
Color:	Clear yellowish
Total thickness:	64µm
Carrier thickness:	34µm
Adhesive thickness:	30µm
Maximum use temperature:	180°C
Elongation on break:	100%

► SIZE

Width	Length	Packaging
25mm	66m	36 rolls/cs
50mm	66m	16 rolls/cs

Shelf life: 18 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2AT180-2

Adhesive tape

Back to range

► DESCRIPTION

SKAT180-2 is a skived & tensilized PTFE film coated with a high temperature acrylic adhesive. This tape is ideal for use on areas where high elongation and release properties are needed. It will conform to irregular shapes and mould surfaces while offering multiple releases. Tapes can be used as a semi-permanent release covering on pressure intensifiers and mandrels. SKAT180-2 will release from most resin systems. The acrylic PTFE tapes find application in composite shops where silicone adhesive tapes are not permitted. The tape removes easily after the cure without adhesive residues.

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

► TECHNICAL DATA

Carrier type:	PTFE	
Adhesive type:	Acrylic	
Adhesion (oz/in):	30	ASTM-D 1000
Color	Brown	
Total thickness:	88µm	
Carrier thickness:	50µm	
Adhesive thickness:	38µm	
Maximum use temperature	180°C	
Elongation on break:	100%	ASTM-D 3759

► SIZE

Width	Length	Packaging
25mm	33m	48 rolls/cs
50mm	33m	24 rolls/cs

Shelf life: 12 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other widths (6mm – 508mm) are available on special order.

SK2AT180-3

Adhesive tape

Back to range

► DESCRIPTION

SK2AT180-3 is a clear polyester tape with a yellow rubber-based pressure sensitive thermosetting adhesive system.

This tough and abrasion resistant tape is used for electrical applications requiring temperature performance up to 130°C and non-corrosive adhesive systems.

The tape is used to many irregular surfaces.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Rubber
Color:	Yellow
Total thickness:	85µm
Carrier thickness:	50µm
Adhesive thickness:	35µm
Maximum use temperature	180°C
Elongation:	100%

► SIZE

Width	Length	Packaging
25mm	66m	36 rolls/cs
50mm	66m	16 rolls/cs

Shelf life: 18 months in original packing.
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order

SK2AT200-1

Double side coated adhesive tape

Back to range

► DESCRIPTION

The tape is an all-purpose, high temperature resistant double-backed holding tape. It is a polyester film coated on both sides with acrylic adhesive. Tape is designed to hold secondary bonded details, spiral wrap in the high temperature resin infusion process, release plies, films and breathers in place during lay-up and machining operations. The tape can be used as well for holding in place honeycomb core during machining.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Acrylic
Color	White
Total thickness:	210µm
Carrier thickness:	80µm
Combined adhesive thickness:	130µm
Color of liner:	Red
Maximum use temperature:	200°C
Elongation on break:	50%

► SIZE

Width	Length
12mm	50m
19mm	50m
25mm	50m

Shelf life: 12 months in original packing
Storage conditions: It is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order. Maximum roll width is 1000mm.

TECHNICAL DATA SHEET

SK2AT200-3

High temperature double side coated adhesive tape

Back to range

► DESCRIPTION

It is an all-purpose double-backed polyester tape with a high tack pressure sensitive adhesive system. SK2AT200-3 is 13µm polyester film coated on both sides with a non-silicone adhesive. It is used in different applications like holding and fixing of release plies, release films and breathers and materials during lay-up, vacuum bagging operations and curing process to avoid process errors and to improve part quality. SK2AT200-3 provides fast, simple and clean application. Its high adhesive system is UV and chemical resistant. High quick stick offers fast and secure bond on different types of surfaces.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Acrylic
Color:	White
Total thickness:	100µm
Carrier thickness:	10µm
Adhesive thickness:	90µm
Tensile strength:	22.3 n/25.4 mm
Elongation:	<50%
Maximum use temperature:	205°C

► SIZE

Width	Length
25,4mm	33m
50,8mm	33m

Shelf life: 18 months in original packing
Storage conditions: It is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

SK2AT204-1

Economical adhesive tape

Back to range

► DESCRIPTION

SK2AT204-1 is a high temperature and tensile strength polyester film coated with pressure sensitive silicone adhesive. SK2AT204-1 could be used in oven and autoclave for flash breaking application, holding down vacuum bagging materials and thermocouples.
SK2AT204-1 is designed to perform in masking applications and chemical milling protection requiring high chemical resistance**.** It removes easily after the cure.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Silicone
Color	Blue
Total thickness:	60µm
Carrier thickness:	28µm
Adhesive thickness:	32µm
Maximum use temperature	204°C

► SIZE

Reference for order	Width	Length
SK2AT204-1BL60MC12.566	12,5 mm	66m
SK2AT204-1BL60MC2566	25mm	66m
SK2AT204-1BL60MC5066	50mm	66m

Shelf life: 12 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2AT204-2

Economical adhesive tape

Back to range

► DESCRIPTION

AT204-2 tape is a stronger version of AT204-1, used anywhere extra strength is needed. Tape is high temperature and tensile strength polyester film coated with pressure sensitive silicone adhesive. SK2AT204-2 could be used in oven and autoclave for flash breaking application, holding down vacuum bagging materials and thermocouples. This tape is designed to perform in masking applications and chemical milling protection requiring high chemical resistance**.** The tape removes easily after the cure.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Silicone
Color	Blue
Total thickness:	85µm
Carrier thickness:	50µm
Adhesive thickness:	35µm
Maximum use temperature	204°C

► SIZE

Reference for order	Width	Length
SK2AT204-2BL85MC12.566	12,5mm	66m
SK2AT204-2BL85MC2566	25mm	66m
SK2AT204-2BL85MC5066	50mm	66m

Shelf life: 12 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

SK2AT204-3

Polyimide adhesive tape

Back to range

► DESCRIPTION

SK2AT204-3 is a polyimide film with solvent resistance and high temperature stable acrylic adhesive system. Generally used as an insulation barrier but also commonly used as outer wrap on capacitors, coils, and transformers and in various manufacturing processes of parts made of composite materials. The product has insulation class 150C.
Polyimide film backing provides conformability, abrasion protection and excellent puncture resistance.

► TECHNICAL DATA

Carrier type:	Polyimide film
Adhesive type:	Acrylic
Color	Amber
Total thickness:	70µm
Carrier thickness:	30µm
Adhesive thickness:	40µm
Elongation:	50%
Maximum use temperature*:	204°C

► SIZES

Width	Length
25mm	33m
50mm	33m
300mm	33m

Shelf life: 12 months in original packing
Storage conditions: It is recommended to store the product in cool dry area in the original packing away from direct sunlight.

* Maximum use temperature should be determined in actual process conditions. We recommend to test the product before use in serial production.

► NOTE

Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2AT204-5

Economical adhesive tape

Back to range

► DESCRIPTION

SK2AT204-5 is used for adhesive flash clean-up over or next the bond lines or anywhere extra strength is needed. It can also be used to aid in potting inserts, drilling through SK2AT204-5. The tape is high temperature and tensile strength polyester film coated with pressure sensitive silicone adhesive. SK2AT204-5 could be used in oven and autoclave, such as to perform in protection in chemical milling or acid bath etching**.** There are multi-purpose functions for composite industry, like holding down vacuum bagging materials, thermocouple wires, masking-of and chemical milling protection. The tape removes easily after the cure.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Silicone
Color	Blue
Total thickness:	170µm
Carrier thickness:	125µm
Adhesive thickness:	35µm
Maximum use temperature	204°C

► SIZE

Reference for order	Width	Length
SK2AT204-5BL170MC2533	25mm	33m
SK2AT204-5BL170MC5033	50mm	33m

Shelf life: 12 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

SK2AT205-1

Adhesive Tape

Back to range

► DESCRIPTION

Tape is high temperature and tensile strength polyester film coated with pressure sensitive silicone adhesive. AT205-1 could be used in oven and autoclave for flash breaking application, holding down vacuum bagging materials and thermocouples.

This tape is designed to perform in masking applications and chemical milling protection requiring high chemical resistance**.**
The tape removes easily after the cure.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Silicone
Color	Blue
Total thickness:	55µm
Carrier thickness:	25µm
Adhesive thickness:	30µm
Maximum use temperature:	205°C
Elongation on break:	100%

► SIZE

Width	Length	Packaging
25mm	66m	36 rolls/cs
50mm	66m	16 rolls/cs

Shelf life: 12 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

► DESCRIPTION

AT205-2 tape is a stronger version of AT205-1, used anywhere extra strength is needed.

Tape is high temperature and tensile strength polyester film coated with pressure sensitive silicone adhesive. AT205-2 could be used in oven and autoclave for flash breaking application, holding down vacuum bagging materials and thermocouples.

This tape is designed to perform in masking applications and chemical milling protection requiring high chemical resistance**.** The tape removes easily after the cure.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Silicone
Color:	Blue
Total thickness:	90µm
Carrier thickness:	50µm
Adhesive thickness:	40µm
Maximum use temperature:	205°C
Elongation on break:	100%

► SIZE

Width	Length	Packaging
25mm	66m	36 rolls/cs
50mm	66m	16 rolls/cs

Shelf life: 18 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

► DESCRIPTION

AT205-3 tape is used for adhesive flash clean-up over or next the bond lines or anywhere extra strength is needed. It can be also used to aid in potting inserts, drilling through AT205-3.

Tape is high temperature and tensile strength polyester film coated with pressure sensitive silicone adhesive. AT205-3 could be used in oven and autoclave, such as to perform in protection in chemical milling or acid bath etching**.**
There are multi-purpose functions for composite industry, like holding down vacuum bagging materials, thermocouple wires, masking-of and chemical milling protection.
The tape removes easily after the cure.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Silicone
Color:	Blue
Total thickness:	170µm
Carrier thickness:	130µm
Adhesive thickness:	40µm
Maximum use temperature:	205°C
Elongation on break:	120%

► SIZE

Width	Length	Packaging
25mm	33m	36 rolls/cs
50mm	33m	16 rolls/cs

Shelf life: 18 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2AT205-4

High tack adhesive Tape

Back to range

► DESCRIPTION

Tape is high temperature and tensile strength polyester film coated with high tack pressure sensitive silicone adhesive. AT205-4 could be used for heavy duty hold down applications where a high level of adhesion is required.

This tape is designed to perform in masking applications and chemical milling protection requiring high chemical resistance**.**

The tape removes easily after the cure.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Silicone
Color:	Green
Total thickness:	100µm
Carrier thickness:	30µm
Adhesive thickness:	70µm
Maximum use temperature:	205°C
Elongation on break:	100%

► SIZE

Width	Length	Packaging
25mm	66m	36 rolls/cs
50mm	66m	16 rolls/cs

Shelf life: 18 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2AT205-5

Strong tear resistant polyester adhesive tape

Back to range

► DESCRIPTION

SK2AT205-5 is a strong tear resistant polyester film combined with a high temperature resistant, proprietary blended, rubber adhesive.
The strong, conformable, polyester backing allows easy removal with no breaking or slivering. The high temperature, non-silicone adhesive will strip clean leaving only minimum residue. This tape is an excellent choice in applications where silicone contamination is unacceptable.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	High temperature rubber
Color	Green
Total thickness:	100µm
Backing thickness	50 µm
Adhesive thickness:	50 µm
Temperature resistance 45 min.	205°C
Elongation on break:	100%

► APPLICATION

This tape is designed to meet the demanding temperature and pressure conditions of autoclave and composite bonding applications. It is also usable as a masking tape for powder coating applications.

► SIZE

Width	Length	Packaging
25mm	66m	36 rolls/cs
50mm	66m	16 rolls/cs

Shelf life: 18 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

The performance of adhesive products is affected by many factors: heat, humidity, type of substrate, texture, inks used, and application technique. However, the purchaser must test the suitability of this product for his intended use under his own operating conditions.
These products are not suitable for prolonged outdoor exposure.

TECHNICAL DATA SHEET

SK2AT205-6

All-purpose polyester adhesive tape with non-silicone adhesive

Back to range

► DESCRIPTION

SK2AT205-6 is a strong tear resistant polyester film combined with a high temperature resistant, proprietary blended, rubber adhesive.
The strong, conformable, polyester backing allows easy removal with no breaking or slivering. The high temperature, non-silicone adhesive will strip clean leaving only minimum residue. This tape is an excellent choice in applications where silicone contamination is unacceptable.

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

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	High temperature rubber
Color:	Green
Total thickness:	80µm
Backing thickness	30µm
Adhesive thickness:	50µm
Temperature resistance 45 min.:	205°C
Elongation on break:	90%

► APPLICATION

This tape is designed to meet the demanding temperature and pressure conditions of autoclave and composite bonding applications.

► SIZE

Width	Length	Packaging
25mm	66m	36 rolls/cs
50mm	66m	16 rolls/cs

Shelf life: 18 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

The performance of adhesive products is affected by many factors: heat, humidity, type of substrate, texture, inks used, and application technique. However, the purchaser must test the suitability of this product for his intended use under his own operating conditions. These products are not suitable for prolonged outdoor exposure.

SK2AT205-7

Adhesive Tape

Back to range

► DESCRIPTION

SK2AT205-7 is a 25-micron polyester film carrier with the silicone adhesive system. This is a tough, thin, abrasion resistant tape used in applications requiring temperature performance up to 205°C, non-corrosive adhesive system and good solvent resistance.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	Silicone
Color:	Red
Total thickness:	100µm
Carrier thickness:	30µm
Adhesive thickness:	70µm
Maximum use temperature:	205°C
Elongation on break:	100%

► SIZE

Width	Length	Packaging
25mm	66m	36 rolls/cs
50mm	66m	16 rolls/cs

Shelf life: 18 months in original packing
Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2AT205-8

High strength polyester adhesive tape

Back to range

► DESCRIPTION

SK2AT205-8 – high-strength, polyester tape, that combines high temperature resistance and rubber based patented adhesive for application in extreme conditions, that require high strength of tape.
Solid and easy to use polyester carrier allows to remove tape without rupture. High temperature, non-silicone adhesive provides clean removal without surface marks. This tape suits perfectly processes where no silicone is allowed.

► TECHNICAL DATA

Carrier type:	Polyester
Adhesive type:	High temperature rubber
Color:	Green
Total thickness:	175µm
Carrier thickness:	125µm
Adhesive thickness:	50µm
Thermal resistance:	205°C
Max. elongation:	120%

► APPLICATION

This tape is used at high temperature and pressure applications in autoclave at manufacturing of composite parts. Product can be used as masking tape at powder coating application.

► SIZE

Width	Length	Packaging
25mm	66m	36 rolls/cs
50mm	66m	16 rolls/cs

Shelf life: 18 months in original packing
Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Various factors influence technical characteristics of adhesive: heat, humidity, substrate type, texture, coloring agent used and application method. This product is not recommended to use at long-term external environment conditions.

TECHNICAL DATA SHEET

SK2AT260-4

Adhesive Tape

Back to range

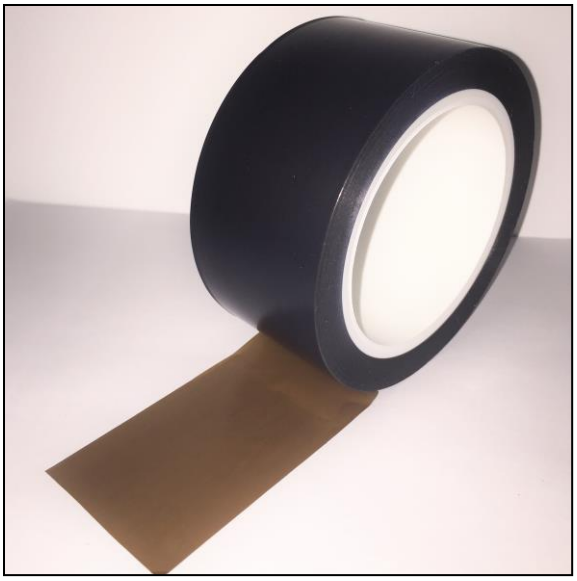
► DESCRIPTION

SK2AT260-4 is a PFTE tape with silicone adhesive. The product will release from most resin systems. It is ideal for use on tooling blocks and all areas where high elongation and release is needed. It forms to critical contours and mould surfaces while offering multiple releases or may be used to cover multiple detail mold seams. SK2AT260-4 provides a semi-permanent release on cured tooling rubber and pressure intensifiers and mandrels.

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

► TECHNICAL DATA

Carrier type:	PTFE
Adhesive type:	Silicone (standard version) Acrylic (A version)
Carrier thickness:	0.050 mm
Adhesive thickness:	0.038 mm
Total thickness:	0.088 mm
Max. elongation:	≥140%
Color:	Brown
Maximum use temperature	260°C



► SIZE

Reference	Width	Length	Adhesive type	Packaging
SK2AT260-4BR88MC2533	25mm	33m	Silicone	72 rolls/box
SK2AT260-4BR88MC5033	50mm	33m	Silicone	36 rolls/box
SK2AT260-4BR88MC2533A	25mm	33m	Acrylic	72 rolls/box

Shelf life: 12 months in original packing
Storage conditions: it is recommended to store at temperature from -20° C to +30°C in the original packing.

► NOTES

Other widths are available on request. Max. width is up to 600 mm

TECHNICAL DATA SHEET

SK2AT260-5

Adhesive Tape

Back to range

► DESCRIPTION

Adhesive tape SK2AT260-5 is manufactured from PTFE film coated with silicone pressure sensitive adhesive with the highest technology available on the market with an accurate process parameter in line quality control.
Main applications: high temperature insulation product for slip, anti-friction and release surfaces (composite lay-up; roller wrapping, plate masking, heat sealing in vacuum bagging application); excellent release surface on packaging and heat sealing equipment; in aerospace industry used in phase insulation for bundling end turns, spot bundling, anchor breakouts and to protect airframe wire harnesses.

Product advantages:

- High thermal stability thanks to the high temperature silicone adhesive
- Chemical inertness (non-adhesive side)
- Superior flame resistance
- Higher dielectric and tensile strength
- Elongation which enables it to be applied with automatic wrapping equipment

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

► TECHNICAL DATA

		Test method:
Carrier type:	PTFE	
Adhesive type:	High temperature silicone	
Color:	Orange	
Carrier thickness:	0.050 mm	ASTM D3652
Adhesive thickness:	0.040 mm	ASTM D3652
Total thickness:	0.090 mm	ASTM D3652
Tensile Strength:	≥43 N/cm	ASTM D3759
Elongation at break:	≥130%	ASTM D3759
Adhesion to steel:	≥2,8 N/cm	ASTM D3330
NEMA/UL Temperature Class*:	H (180°C)	
Breakdown Voltage:	6500 V	ASTM D150
Volume Resistivity:	≤10^{17} Ω•cm	ASTM D257
Surface resistivity:	≤10^{16} Ω	ASTM D257
Maximum use temperature	260°C	

* Max use temperature: 260°C (for single use max 315°C). Anyway testing prior to use is recommended.

► SIZE

Width	Length	Packaging
25,4 mm	33 m	72 rolls/cs
50,8 mm	33 m	36 rolls/cs

Shelf life: 12 months in original packing
Storage conditions: it is recommended to store at temperature from +10° C to +30°C in the original packing out of direct sunlight.

► NOTES

The product is available as master log form 33m x 635mm. Minimum available width is 12,7 mm.

TECHNICAL DATA SHEET

SK2AT260-8

PTFE coated glass fabric adhesive tape

Back to range

► DESCRIPTION

Adhesive tape SK2AT260-8 is PTFE coated glass fabric self-wound adhesive bundling end turns, spot bundling, anchor breakouts and to protect airframe wire harnesses. These tapes provide a slick surface on process machinery and offers an extremely low coefficient of friction which, in combination with a pressure sensitive silicone adhesive, creates a non-stick surface that performs at elevated temperatures.

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

► TECHNICAL DATA

Weight:	155 g/m^2
Nominal thickness:	0,08 mm
Tensile strength:	800 N/5 cm
PTFE content:	68%
Adhesive type:	Silicone
Temperature resistance:	-73°C +260°C

► SIZE

Thickness	Width	Length
0,08 mm	50 mm	33 lm
0,08 mm	200 mm	33 lm

Shelf life: 12 months in original packing
Storage conditions: it is recommended to store at temperature from +10° C to +30°C in the original packing out of direct sunlight.

SK2AT399-1

Adhesive tape

Back to range

► DESCRIPTION

SK2AT399-1 is polyimide tape coated with a fully cured silicone adhesive for using in high temperature curing processes up to 399°C. The tape is dimensionally stable at high temperatures, flame retardant and chemical resistant.

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

► TECHNICAL DATA

Carrier type:	Polyimide
Adhesive type:	Silicone
Color:	Amber
Total thickness:	65µm
Carrier thickness:	25µm
Adhesive thickness:	40µm
Maximum use temperature:	399°C
Elongation on break:	63%

Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► SIZE

Width	Length	Packaging
25mm	33m	36 rolls/cs
50mm	33m	16 rolls/cs

Shelf life: 18 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

SK2AT399-2

Double coated adhesive tape

Back to range

► DESCRIPTION

SK2AT399-2 is polyimide tape double side coated with a fully cured silicone adhesive for using in high temperature curing processes up to 399°C. The tape is dimensionally stable at high temperatures, flame retardant and chemical resistant.

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

► TECHNICAL DATA

Carrier type:	Polyimide
Adhesive type:	Silicone
Color	Amber
Total thickness:	100µm
Carrier thickness:	25µm
Adhesive thickness:	37,5µm x 2
Maximum use temperature	399°C
Elongation on break:	63%

► SIZE

Width	Length	Packaging
25mm	33m	36 rolls/cs
50mm	33m	16 rolls/cs

Shelf life: 18months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Other sizes are available on special order.

Name	Description	Max. use T°C	Elongation on break	Color
SKRS200-10	Two-component silicone sprayable	200°C	500%	Light Blue
SK2RS200-13	Pneumatic gun for sprayable silicone, wth kit of accessories for distrubution	-	-	-
SK2RS204-3	Uncured non-silicone tooling rubber	204°C	400%	Black
SK2RS230-1	Cured silicone rubber	250°C	750%	Transparent
SK2RS230-2	Uncured silicone rubber	250°C	650%	Transparent
SK2RS250-1	Highly-elastic silicone membrane for vacuum bagging	250°C	600%	Milky translucent
SK2RS300-2	Two component modified room temperature vulcanisation compound.	300°C	250%	Blue

TECHNICAL DATA SHEET

SK2RS200-10

Two-component silicon sprayable

Back to range

► DESCRIPTION

This product has been specifically developed for specifically developed to produce a silicone bag on moulds used for the processing of composites applying the “vacuum resin infusion” technology.

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

► TECHNICAL DATA

- Low viscosity, easy sprayable
- Re-usable
- Good mechanical properties
- High chemical resistance
- Short demoulding time
- Two version available (normal and Slov Curing)

PHYSICAL PROPERTIES			
Composition	**Resin**	**Catalyst**	**Mixed**
Mix ratio by weight	100	100	-
Aspect	Viscous liquid	Viscous liquid	Thixotropic liquid
Colour	Translucent	Light blue	Light blue
Viscosity Brookfield at 25 °C (mPa.s)	15000	15000	
Pot life at 23 °C (min)	SVB 20 SVB 20 SC	SVB 20 SVB 20 SC	3 60
Demoulding time at 23°C	-	-	15 min 12 hours
THERMAL & MECHANICAL PROPERTIES			
Hardness (Shore A)		-	20
Elongation at break (%)	-	-	500
Tensile strength at break (MPa)	-	-	4
Tear strength (kN/m)	-	-	15

► HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation
- Wear gloves, safety glasses and waterproof clothes

For further information, please consult the product safety data sheet.

► STORAGE CONDITIONS

Shelf life is 12 months in a dry place and in original unopened containers at a temperature between 10 and 30°C.

► PACKAGING

SVB 20	SVB 20 SC
10 cartridges 400 cm^3 6 cartridges 1500 cm^3 25 + 25 kg	6 cartridges 1500 cm^3 5 + 5 kg

► GUARANTEE

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of our products, under their own conditions before commencing with the proposed application. We refuse any guarantee about the compatibility of a product with any particular application. We disclaim all responsibility for damage from any incident which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

SK2RS200-13

Distribution pistolet

Back to range

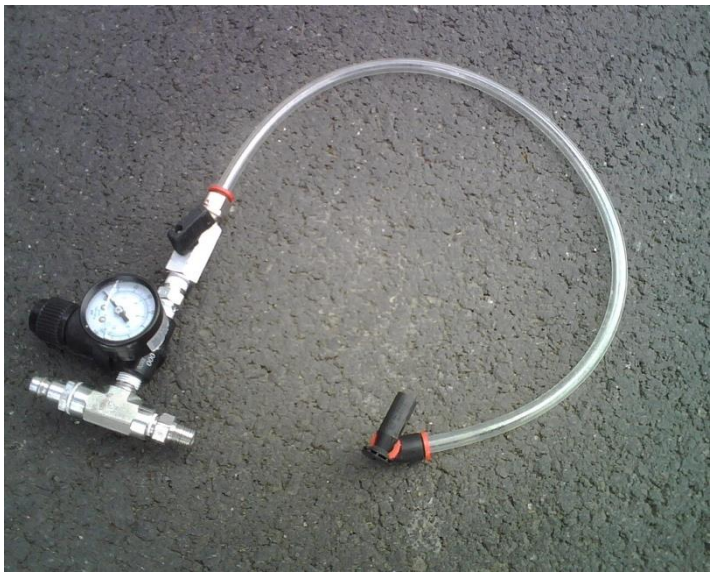
► DESCRIPTION

Distribution pistolet for application of two component sprayable silicone provides simultaneous feeding of two components through static mixer in ratio of 1:1 or 2:1.

Pneumatic pistolet is intended for active usage, provides high accuracy and productivity.

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

Pneumatic pistolet 400cm^3
compatible with cartridges 400 cm^3
Ratio (1:1 & 2:1)
Pression: 6 Bar



Set of accesoires for use with two component silicone

Assembled pistolet

► WARRANTY

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TECHNICAL DATA SHEET

SK2RS204-3

Uncured non-silicone tooling rubber

Back to range

► 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
- 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
1,6mm	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.

SK2RS230-1

Cured Silicon Elastomer

Back to range

► DESCRIPTION

SK2RS230-1 is a 50 durometer, high strength silicone compound for use as a reusable vacuum blanket in forming composite aerospace articles.

SK2RS230-1 possesses excellent durability, high temperature resistance and high elongation properties; the material is effective in the forming of intricate shapes. Widely used in vacuum and thermoforming presses and serving industries in the Composite sectors for parts within Aerospace.
The product has a service temperature range of -60°C and up to 250°C.

The mechanical properties shown below were obtained on ASTM samples.

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

► TECHNICAL DATA

General characteristics

Material type:	Silicone compound
Color	Transparent
Maximum use temperature	250°C
Recommended use temperature	230°C
Brittle point	-80°C
Limiting Oxygen Index	24.0 %
Thermal Conductivity	0.24 $W.m^{-1}.K^{-1}$
Radiation Resistance	>105 Grays (10^7 Rads) typical
Dielectric Strength	23 $kV.mm^{-1}$
Dielectric Constant	2.9
Dissipation Factor	$3x10^{-4}$
Volume Resistivity	$3x10^{15}\Omega.cm$

Mechanical properties

Hardness	50±5 Shore A
Tensile Strength	1233 psi min
Elongation to Failure	750% min
Tear Strength	228ppi min
Compression Set	24% max by 24 Hours at 150°C, 30 minutes recovery

► NOTE

Supplied in continuous roll lengths.
Widths of up 1800mm.
Capability to color match.

Available thicknesses: 0.76mm, 1.52mm, 2.16mm, 3.18mm
Standard width: 1220mm
MOQ is 10 sqm. MOQ has to be ordered.

Shelf life: 5 years
Storage conditions: It is recommended to store at temperature from -20°C until +30°C in the original packing.

TECHNICAL DATA SHEET

SK2RS230-2

Uncured Silicon Elastomer

Back to range

► DESCRIPTION

SK2RS230-2 is an uncured 50 durometer, high strength silicone compound for use as a reusable vacuum blanket in forming composite aerospace articles.

SK2RS230-2 possesses excellent durability, high temperature resistance and high elongation properties; the material is effective in the forming of intricate shapes. Widely used in vacuum and thermoforming presses and serving industries in the Composite sectors for parts within Aerospace.
The product has a service temperature range of -60°C and up to 250°C.

The mechanical properties shown below were obtained on ASTM samples.

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

► TECHNICAL DATA

General characteristics

Material type:	Silicone compound
Color	Transparent
Maximum use temperature	250°C
Recommended use temperature	230°C
Brittle point	-80°C
Limiting Oxygen Index	24.0 %
Thermal Conductivity	0.24 $W.m^{-1}.K^{-1}$
Radiation Resistance	>105 Grays (10^7 Rads) typical
Dielectric Strength	23 $kV.mm^{-1}$
Dielectric Constant	2.9
Dissipation Factor	$3x10^{-4}$
Volume Resistivity	$3x10^{15}\Omega.cm$

Mechanical properties

Hardness	50±5 Shore A
Tensile Strength	1015 psi min
Elongation to Failure	650% min
Tear Strength	200ppi min
Compression Set	35% max by 24 Hours at 150°C, 30 minutes recovery

► NOTE

Supplied in continuous roll lengths.
Widths of up 1800 mm.
Capability to color match.

Available thicknesses: 0.76mm, 1.52mm, 2.16mm, 3.18mm
Standard width: 1m.
MOQ is 10 sqm. MOQ has to be ordered.

Shelf life: 6 months
Storage conditions: It is recommended to store at temperature from -20°C until +4°C in the original packing.

TECHNICAL DATA SHEET

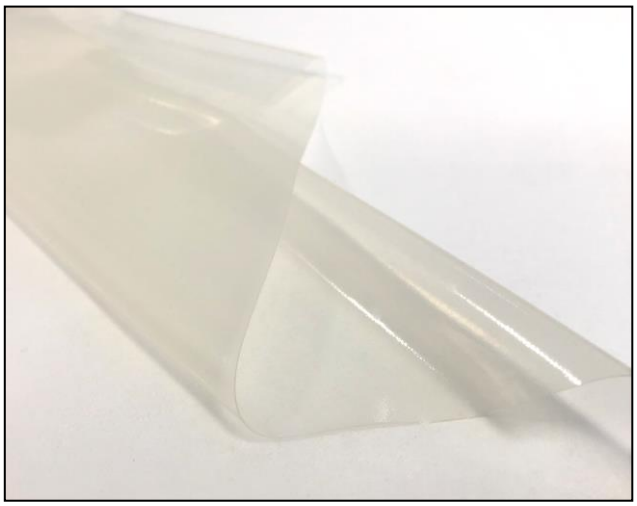
SK2RS250-1

Highly-elastic silicone membrane for vacuum bagging

Back to range

► DESCRIPTION

SK2RS250-1 is a high performance, reusable highly-elastic silicone membrane designed for composite manufacturing. It provides the reliable, high quality solution required in vacuum moulding and laminating methods of composite production.



SK2RS250-1 is reusable, providing a cost effective and environmentally-friendly alternative to disposable plastic bags in the VARTM (Vacuum Assisted Resin Transfer Moulding) and SCRIMP (Seemann Composites Resin Infusion Moulding) processes.

The silicone membrane is available in both cured SK2RS250-1 and SK2RS250-2 as uncured version. Cured material has a fine fabric impression to aid removal.

The silicone material of SK2RS250-1 is flame resistant which provides an extra level of safety within your application. The membrane also provides excellent UV and ozone resistance, as well as strong chemical resistance, making it the ideal solution in manufacturing processes of parts made of composite materials.

► ADVANTAGES

- Reusable up to 100 times* (less waste so more environmentally friendly, time and money saving)
- Repairable
- Improved ergonomics for operators
- Excellent UV and ozone resistance
- Cost effective alternative to disposable bags
- Good chemical resistance
- Highly durable over a wide temperature range (-40°C to 200°C)
- High tear resistance
- High elongation with low modulus
- Flame resistant
- Will not crease like nylon film
- Translucent sheeting means resin flow can be observed

* The number of cycles depends on application temperature and the aggressiveness of the medium in which the membrane is used.

TECHNICAL DATA SHEET

SK2RS250-1

Highly-elastic silicone membrane for vacuum bagging

► TECHNICAL DATA

Material type:	Silicone
Color:	Milky translucent
Maximum use temperature:	250°C
Cure Conditions:	116°C for 5 min with 1.4MPa (200 psi) of pressure

Mechanical properties of cured product

Property	Test method	Specification	Units
Hardness	ASTM D2240	51	Shore A
Density	ASTM D792	1.15	g/cm^3
Tensile strength	ASTM D412 DIE C	10	MPa
Elongation at break	ASTM D412 DIE C	600	%
Tear strength	ASTM 624 DIE B	33	KN/m
Compression set	ASTM D395 22h at 177°C	45 4 hours at 200°C	%
Dielectric Strength		20	Kv/mm
Thermal Expansion		6.5	m/m°C

Shelf Life: for uncured material: 6 months from date of manufacture when stored at 24°C wrapped as supplied.
For cured material: unlimited when stored in original packaging at 22°C.

► NOTE

Available thicknesses: from 0.3mm to 3.5 mm.
Standard widths of up to 1500mm

SK2RS300-2

Two-component modified room temperature vulcanization compound

Back to range

► DESCRIPTION

SK2RS300-2 two component modified room temperature vulcanisation compound designed for use in the manufacturing of flexible moulds and mandrels, as well as for casting pressure pads.

- Outstanding release properties
- Cures at room temperature within 16 hours or heat curable
- If required, the product cure can be heat accelerated
- High hardness
- Medium tear resistance
- Very low shrinkage and good dimensional stability
- Can be used for high-temperature casting applications
- High inhibition resistance

► TECHNICAL DATA

TYPICAL PROPERTIES		
Property	**Unit**	**Result**
Base		
Viscosity	mPa.s	130,000
Base Viscosity at 25°C	poise	1300
Appearance, Base		Beige
Base and Curing Agent Mixture 10:1		
Appearance		Regal Blue
Viscosity at 25°C	mPa.s (poise)	90,000 (900)
Working Time	Minutes	60
Cure Time at 25°C	hours	16

TYPICAL PROPERTIES (Cont.)		
Cured for 24 Hours at 25°C As Cured		
Durometer Hardness, Shore A	Points	59
Tensile strength	MPa (psi)	4,5 (650)
Elongation, Die C at Break	%	350
Tear strength Die B	kN/m (ppi)	16 (90)
Specific Gravity at 25°C	-	1,29
Linear shrinkage	%	< 0.1

(1) Average values obtained on standard specimens after hardening 7 days at room temperature.

► NOTE

If no vacuum de-airing equipment is available, air entrapment can be minimized by mixing a small quantity of base and curing agent, then using a brush, painting the original with a 12mm layer.
Leave at room temperature until the surface is bubble-free and the layer has begun to cure. Mix a further quantity of base and curing agent and proceed as follows to produce a final mold.

► HANDLING PRECAUTIONS

Normal health and security precautions should be observed when handling these products:

- Ensure good ventilation
- Wear gloves and safety glasses

For further information, please consult the material safety data sheets.

► STORAGE CONDITIONS

Shelf life: 12 months from date of shipment when stored in original packaging at or below 25 °C in original, unopened containers.

SK2RS300-2 can be sensitive to moisture and contamination. Ensure that containers are tightly closed after use.

► GUARANTEE

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Name	Description	Max. use T°C	Color
SEMI-PERMANENT TOOLING RELEASE FILMS			
SK2TR260-2	Medium weight glass fabric coated with PTFE and with silicone adhesive one side and liner	260°C	Brown
SK2TR260-3	Light glass fabric coated with PTFE and with silicone adhesive one side and liner	260°C	Brown
SK2TR260-4	PTFE film coated one side with silicone adhesive and liner with high elongation	260°C	Brown
CLEANING AGENTS			
SK2TR000-1	Cleaner for the removal of silicone, sealing compounds and release agents' rests	n/a	Colorless
SK2TR000-2	Universal cleaner for composite, steel and alumunium moulds	n/a	Colorless
SK2TR000-3	Tool cleaner for working tools for acetone replacement	n/a	Colorless
SK2TR000-5	Cleaner for the removal of silicone containing polish residue, sealing compounds and release agents	n/a	Colorless
SEALERS			
SK2TR300-1	Modelmaster sealer / primer	300°C	Clear
SK2TR450-1	Modelmaster sealer / primer for porous surfaces to seal them with a high gloss finish	450°C	Black / Pink
SK2TR450-2	Mould sealer for new or freshly cleaned mould surfaces	450°C	Colorless
SK2TR450-3	Mould sealer for new or freshly cleaned mould surfaces, multipropose, fast evaporating	450°C	Yellow
RELEASE AGENT SOLVENT BASED			
SK2TR300-2	Release agent for polyurethane processing	300°C	Clear
SK2TR400-1	Solvent-based multi-purpose mould release agent	400°C	Clear
SK2TR400-3	Semi-permanent, solvent-based, fast-evaporating release agent with excellent lubrication and release for smooth processing and a high-gloss surface finish	400°C	Colorless
SK2TR450-4	Semi-permanent, solvent-based mould release agent, multipropose	450°C	Colorless

SK2TR450-5	Semi-permanent, solvent-based mould release agent with high level of slipping, multipropose	450°C	Colorless
SK2TR450-6	Semi-permanent, solvent-based mould release agent, multipropose, fast curing, no sealing necessay	450°C	Colorless
SK2TR450-7	Semi-permanent, solvent-based mould release agent with high level of slipping, multipropose, fast curing	450°C	Colorless
SK2TR450-12	Semi-permanent, solvent-based mould release agent, very fast drying	450°C	Colorless
SK2TR450-13	Semi-permanent, solvent-based mould release agent with ultra fast curing	450°C	Colorless
SK2TR450-14	Semi-permanent, solvent-based mould release agent for thermoset resins	450°C	Colorless
RELEASE AGENT WATER BASED			
SK2TR400-4	Semi-permanent water-based release agent, no sealing necessary, fast drying, low build-up and cleaning	450°C	White
SK2TR400-5	Sprayable water-based semi-permanent release agent, no sealing necessary, fast drying, lowest mould build-up, less cleaning	450°C	White
SK2TR450-8	Water based semi-permanent release agent, no sealing necessary, fast drying	450°C	Cream colored
SK2TR450-9	Water based semipermanent release agent specialy developed for aircraft industry	450°C	White
SK2TR450-10	Water based PTFE release agent, without any silicones or silanes	450°C	Beige
SK2TR450-11	Sprayable water based semi-permanent release agent, no sealing necessary, fast drying	450°C	White
RELEASE AGENT WAX BASED			
SK2TR150-1	Release Paste / sealer wax based	150°C	Yellow
SK2TR150-2	Liquid solvent based wax for multiple demouldings for high gloss moulds	150°C	White
SK2TR250-1	Release liquid / sealer wax-water based	250°C	Blue

INTERNAL RELEASE AGENTS, ADDITIVES AND SPECIAL SURAFACE TREATMENT			
SK2TR150-3	Release agent for polymer concrete, fast drying, special for abrasive fillers	150°C	White
SK2TR000-4	Additive reducing the surface tension of mould, against fisheyes, increases the scratch resistance of the surface	n/a	Yellow
SK2TR250-2	Internal mould release agent for minimize consumption of external release agents by use with epoxy resins	250°C	Yellow
SK2TR250-3	Internal mould release agent for minimize consumption of external release agents by use with polyester resins	250°C	Colorless

TECHNICAL DATA SHEET

SK2TR260-2

Semi-permanent tool release

Back to range

► DESCRIPTION

SKTR260-2 is a PTFE-coated medium weight glass fabric with a high performance, silicone pressure-sensitive adhesive on one side. The PTFE surface exhibits good release properties in demanding high temperature applications. The product has a yellow corrugated liner to protect the adhesive surface and to ease identification and use.
This film is ideal for use on flat areas where release properties are needed, on the mould surfaces while offering multiple releases. SKTR260-2 will release from most resin systems.

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

► TECHNICAL DATA

Carrier type:	PTFE-coated glass	
Adhesive type:	Silicone	
Adhesion:	6,2N/cm	ASTM-D 330-83
Color	Brown	
Total thickness:	165µm	
Carrier thickness:	120µm	
Adhesive thickness:	45µm	
Maximum use temperature	260°C	

► SIZE

Product reference	Width	Length
SK2TR260-2BR165MC10033	1000mm	33m
SK2TR260-2BR165MC10016.5	1000mm	16.5m
SK2TR260-2BR165MC12230	1220mm	30m

Shelf life: 12 months in original packing
Storage conditions: It is recommended to store at temperature from +16°C until +24°C in the original packing.

► **NOTE**

Material is also available acrylic adhesive and selfwound (i.e. no liner)
Material should be applied carefully lifting the edge of the backing, then applying the adhesive side to the tool surface. The remainder of backing should be carefully removed while pressing of SK2TR260-2 onto tool surface with straight edge. After applying, we recommend to apply vacuum bag during 24 hours to remove any residual air. This cycle under vacuum will provide better results.

TECHNICAL DATA SHEET

SK2TR260-3

Semi-permanent tool release film

Back to range

► DESCRIPTION

SKTR260-3 is a PTFE-coated light glass fabric with a high performance, silicone pressure-sensitive adhesive on one side. The PTFE surface exhibits good release properties in demanding high temperature applications. The product has a yellow corrugated liner to protect the adhesive surface and to ease identification and use.

This film is ideal for use on flat areas where release properties are needed, on the mould surfaces while offering multiple releases. SKTR260-3 will release from most resin systems. This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Carrier type:	PTFE-coated glass	
Adhesive type:	Silicone	
Adhesion:	5,3N/cm	ASTM-D 330-83
Color	Brown	
Total thickness:	125µm	
Carrier thickness:	80µm	
Adhesive thickness:	45µm	
Maximum use temperature	260°C	

► SIZE

Width	Length
1000mm	50m

Shelf life: 12 months in original packing
Storage conditions: it is recommended to store at temperature from +16°C until +24°C in the original packing.

► NOTE

Material is also available acrylic and selfwound (i.e. no liner)
Material should be applied carefully lifting the edge of the backing, then applying the adhesive side to the tool surface. The remainder of backing should be carefully removed while pressing of SK2TR260-3 onto tool surface with straight edge. After applying, we recommend to apply vacuum bag during 24 hours to remove any residual air. This cycle under vacuum will provide better results.

TECHNICAL DATA SHEET

SK2TR260-4

Semi-permanent tool release film

Back to range

► DESCRIPTION

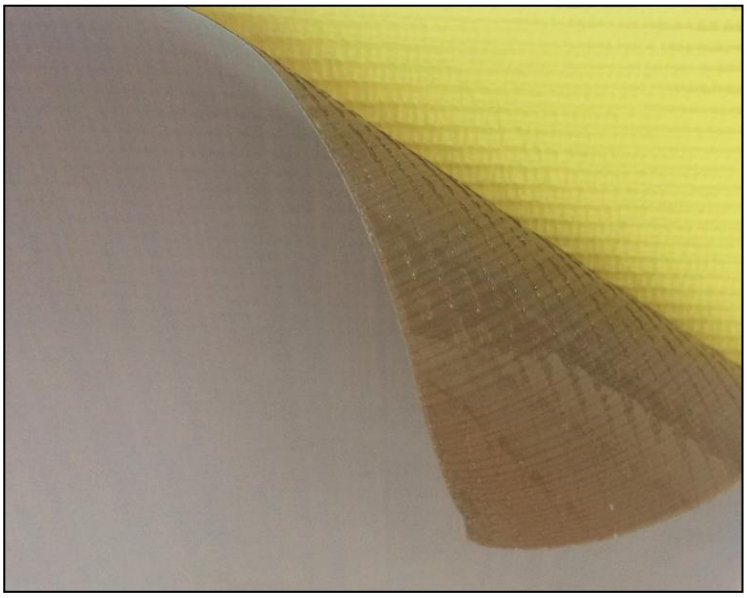
SKTR260-4 is high elongation PTFE film coated with a high temperature silicone adhesive and yellow liner.

This film is ideal for use on areas where high elongation and release properties are needed. It will conform to irregular shapes and mould surfaces while offering multiple releases. Film can be used as a semi-permanent release covering on moulds, pressure intensifiers and mandrels. SKTR260-4 will release from most resin systems.

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

► TECHNICAL DATA

Carrier type:	PTFE
Adhesive type:	Silicone
Color:	Brown
Total thickness:	165µm
Carrier thickness:	127µm
Adhesive thickness:	38µm
180° Peel adhesion (25°C):	5,8 N/cm
Maximum use temperature:	260°C
Tensile strength:	≥24 N/mm^2
Elongation on break:	≥300%
Dielectric strength:	≥70KV/mm



► SIZE

Width	Length
1000mm	30m

Shelf life: 12 months in original packing
Storage conditions: It is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

MOQ is 1 roll of 30 m^2.
Maximum width of 1200 mm is available on special order of 800 lm.

SK2TR000-1

Cleaner

Back to range

► DESCRIPTION

SK2TR000-1 is a solvent-based ‘heavy duty‘ cleaner to clean working tools and surfaces during the processing of polyester and epoxy resin systems. This cleaner is especially suited for the removal of silicone containing polish residues on parts, which will be varnished or glued afterwards. An additionally use is the removal of sealing compounds and release agents. SK2TR000-1 is suited for the cleaning of working tools and surfaces and for the preparation of the composite sector.
Compare to acetone our cleaner doesn't evaporate so quickly from a surface therefore has more thorough cleaning effect.

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

► APPLICATION

Cleaner can be applied with a brush or a cloth. You can as well dip or spray the objects which have to be cleaned into SK2TR000-1. After the cleaner has penetrated the surface for a couple of minutes, simply wipe it off. Remains of cleaner SK2TR000-1 can easily be removed with a dry cloth.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Mixture of solvents
Density [g/cm^3]:	Approx. 0.9
Flash Point [°C]:	30°C

► SIZE

Packaging
Can of 9 kg
Can of 27 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

SK2TR000-2

Cleaner

Back to range

► DESCRIPTION

SK2TR000-2 is a universal super effective solvent-based cleaner generally used to remove residues of additives, such as waxes and oils, and release agents from various industrially applied mould materials (e. g. steel, aluminium, polyester, epoxy resins or glass-fibre reinforced plastics). SK2TR000-2 is used as a multi-purpose mould cleaner.

After cleaning with SK2TR000-2, please use SK2TR000-1 to remover rests of deep cleaner and prepare surface for treatment.

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

► APPLICATION

The objects to be cleaned are usually dipped into cleaner SK2TR000-2, allowing the product to penetrate the surface for 5-30 min depending on the degree of fouling. The soaked residues can easily be removed together with excess of cleaner by means of wiping the surface with a dry, clean cloth. Alternatively, SK2TR000-2 can be applied with a brush.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Mixture of solvents
Density [g/cm^3]:	Approx. 0.8
Flash Point [°C]:	Approx. 26°C

► SIZE

Packaging
Can of 24.9 kg
Drum of 166 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

SK2TR000-3

Cleaner

Back to range

► DESCRIPTION

SK2TR000-3 is a solvent based high performance cleaner suitable for cleaning tools used for the processing of polyester- and epoxy resins. It can be used for the cleaning of any kind of tools.

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

► APPLICATION

The items to be cleaned can either be dipped into SK2TR000-3 or the product can be sprayed or brushed onto the items. After a few minutes the surface can be easily wiped dry with a clean cloth.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Solvent-based cleaner on glycol ether basis
Density [g/cm^3]:	Approx. 0.95
Flash Point [°C]:	80°C

► SIZE

Packaging
Can of 28.5 kg
Drum of 190 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

SK2TR000-5

Cleaner

Back to range

► DESCRIPTION

SK2TR000-5 is s a solvent-based, fast evaporating ‘heavy duty‘ cleaner, used to clean working tools and surfaces during the processing of polyester and epoxy resin systems. This cleaner is especially suited for the removal of silicone containing polish residues on parts, which will be varnished or glued afterwards. An additional use is the removal of sealing compounds and release agents.

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

► APPLICATION

SK2TR000-5 is suited for cleaning of working tools and surfaces as well as for mould preparation in the field of composite industry.
Dip or spray the objects to be cleaned into SK2TR000-5. After the cleaner has penetrated the surface for a couple of minutes, simply wipe it off. Instead of dipping the objects into SK2TR000-5, it may as well be applied with a brush or cloth. Remains of the cleaner can easily be removed with a dry cloth.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Mixture of solvents
Density [g/cm^3]:	Approx. 0.84
Flash Point [°C]:	4

► SIZE

Packaging
Can 5 L (4,2 kg)

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months. The expiry date is stated beneath the production date on the labels of each container

TECHNICAL DATA SHEET

SK2TR300-1

Mould sealer

Back to range

► DESCRIPTION

SK2TR300-1 is a specially designed surface sealer for porous surfaces especially block materials, MDF, plastic and metal moulds to seal them with a high-quality finish. The sealer convinces with its simple application. If handled properly, there will be no need to sand nor to polish. It can also be used for reprocessing surfaces of polyester or epoxy resin.

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

► APPLICATION

Sealer SK2TR300-1 is ready-to-use and should not be diluted. The surface to be sealed must be absolutely dust free and free of grease residues. Optimal results are obtained by applying the sealer with a suitable lint-free cotton cloth. Depending on the porosity of the surface, repeat until the desired surface quality has been achieved. Usually, 2 or 3 coatings with an evtual sanding using an abrasive fleece are sufficient. After each application a curing time of minimum 30 minutes at a room temperature of approx. 20°C should be respected. Only very thin layers of Sealer SK2TR300-1 must be applied as too thick layers tend to crack. For best release performance, we strongly recommend subsequent application of semi- permanent release agent SK2TR450-4 or SK2TR450-5. Both water- and solvent-based release agents will be adequate. Application equipment (brush or similar) should be thoroughly cleaned immediately from liquid residues using a suitable solvent. Cured Sealer SK2TR300-1 can only be mechanically cleaned / removed.

► TECHNICAL DATA

Appearance:	Clear liquid
Composition:	Resin solution
Density [g/cm^3]:	Approx. 0.90
Max. used T:	300°C
Flash Point [°C]:	-1°C

► SIZE

Packaging
Bottle of 0,9 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

TECHNICAL DATA SHEET

SK2TR450-1

Mould sealer/primer

Back to range

► DESCRIPTION

SK2TR450-1 is a specially designed surface sealer for porous surfaces to seal them with a high gloss finish. The sealing impresses with its simple application. If handled properly, you neither have to sand nor to polish. The product is used for sealing of porous surfaces, specifically block materials, MDF etc.

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

► APPLICATION

SK2TR450-1 is ready-to-use and should not to be diluted. The surface which has to be sealed must be absolutely dust free and free of grease residue. Optimal results are obtained by rubbing with a suitable lint free cotton cloth. Usually, two coatings with an eventual sanding using an abrasive fleece are sufficient for perfect sealing. However, the appropriate number of coating layers depends on the porosity of the surface. A minimum curing time of 1 h at room temperature (20 °C) has to be respected after each application in order to guarantee proper sealing of the surface. For a high-gloss surface we recommend a final paintwork with a spray gun. We recommend a spray gun nozzle of 0,5 mm diameter at 1-1,5 bar. For best release performance, we strongly recommend subsequent application of any semi-permanent release agent from category SK2TR. Both water- and solvent-based release agents will be adequate. Spray equipment should be thoroughly cleaned immediately from liquid residues using NC solvent, universal thinner or solvent naphtha. Cured Sealer SK2TR450-1 can only be mechanically cleaned / removed.

► TECHNICAL DATA

Appearance of liquid:	Black / Pink
Color:	Black / Transparent
Composition:	Resins solution
Density [g/cm^3]:	Approx. 1
Flashpoint:	44°C

► SIZE

Packaging
Bottle 1,2 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

SK2TR450-2

Mould sealer

Back to range

► DESCRIPTION

SK2TR450-2 is a solvent-based easy-to-use high-tech mould sealer. This product has specifically been developed for green, porous or repaired moulds to seal the mould before using regularly semi-permanent release agents from category SK2TR. The active ingredients contained in SK2TR450-2 help specifically sealing porous mould surfaces. The product has a thermal stability till 450°C, the application temperature range is between 10°C – 80°C. It is a multi-purpose sealer for the purpose of processing polyester, thermoset resins as well as epoxy or phenolic resins on any kind of mould surface.
This product is used in various manufacturing processes of parts made of composite materials.

► APPLICATION

Prior to the first application of SK2TR450-2, ensure to thoroughly clean the moulds from dirt and former release agent residues. For this specific purpose, we recommend using our product cleaner of category SK2TR. Proceed to clean the moulds with a fast-evaporating solvent to eliminate all residues of fat and wax. Use a cotton cloth to apply a thin layer of SK2TR450-2 to the mould surface. Immediately after the application of sealer, use a second cloth to polish the mould's surface with the formerly applied SK2TR450-2. We recommend applying a minimum of 2 layers. Each single layer needs approximately 5 minutes of curing time. After all layers of SK2TR450-2 have been applied, we recommend to apply our semi-permanent Release Agent SK2TR450-4 or SK2TR450-5 before starting production.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Mixture of resins in solvents
Density [g/cm^3]:	Approx. 0.76
Max. used T:	450°C
Flash Point [°C]:	>25°C

► SIZE

Packaging
Box of 6 x 0,38 kg
Can of 3,8 kg
Can of 7,6 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

TECHNICAL DATA SHEET

SK2TR450-3

Fast evaporating mould sealer

Back to range

► DESCRIPTION

SK2TR450-3 is a very fast evaporating solvent-based easy-to-use high-tech mould sealer. This product has specifically been developed for new, porous or repaired moulds to seal the mould before using regularly semi-permanent release agents from category SK2TR. The active ingredients contained in SK2TR450-3 help specifically sealing porous mould surfaces. The product has a thermal stabilitiy till 450°C, the application temperature range is between 10°C – 80°C. It is a multi-purpose sealer for the purpose of processing polyester, thermoset resins as well as epoxy or phenolic resins on any kind of mould surface. This product is used in various manufacturing processes of parts made of composite materials.

► APPLICATION

Prior to the first application of SK2TR450-3, ensure to thoroughly clean the moulds from dirt and former release agent residues. For this specific purpose, we recommend using our product cleaner of the category SK2TR. Proceed to clean the moulds with a fast-evaporating solvent to eliminate all residues of fat and wax. Use a cotton cloth to apply a thin layer of SK2TR450-3 to the mould surface. Immediately after the application of sealer, use a second cloth to polish the mould's surface with the formerly applied SK2TR450-3. We recommend applying a minimum of 2 layers. Each single layer needs approximately 5 minutes of curing time. After all layers of SK2TR450-3 have been applied, we recommend to apply our semi-permanent Release Agent SK2TR450-4 or SK2TR450-5 before starting production.

► TECHNICAL DATA

Appearance:	Yellowish liquid
Composition:	Mixture of resins in solvents
Density [g/cm^3]:	Approx. 0.78
Max. used T:	450°C
Flash Point [°C]:	0°C

► SIZE

Packaging
Box of 6 x 0,39 kg
Can of 3,9 kg
Can of 7,8 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

SK2TR300-2

Release agent

Back to range

► DESCRIPTION

Release agent SK2TR300-2 is a liquid external mould release agent generally used in polyurethane processing. The product provides a thin film that adheres strongly to the mould surface and provides good release performance. At the same time, SK2TR300-2 release agent consumption is significantly lower than for comparable products. The resulting release film is temperature stable up to 300°C / 572°F. Release agent SK2TR300-2 is completely free of any solvents that are subject to labelling and hence does not constitute a dangerous good. Furthermore, the product is odorless. Moulded parts comply to the high demands of the automotive industry.

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

► APPLICATION

Release agent SK2TR300-2 can be used as mould release agent for polyurethane processing and is especially suited for the processing of polyurethane elastomers (both polyether- and polyester-based systems).

Prior to the first application of Release agent SK2TR300-2, moulds need to be cleaned thoroughly. We recommend using one of our cleaners SK2TR000-1 or SK2TR000-2 for this purpose. Afterwards, Release agent SK2TR300-2 is applied as a thin and even film with the help of an airmix spray gun and allowed to dry. Processing can then be started without any further pre-treatments.

► TECHNICAL DATA

Composition:	mixture of resins
Appearance:	colourless liquid
Density [g/cm^3]:	approx. 0.96
Flashpoint [°C]:	> 75

► SIZE

Packaging
Box of 15 Cans x 1 L
Can 5 L

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months. The expiry date is stated beneath the production date on the labels of each container.

TECHNICAL DATA SHEET

SK2TR400-1

Release agent

Back to range

► DESCRIPTION

SK2TR400-1 is a solvent-based multi-purpose mould release agent commonly used in polymer and thermoplastics processing, especially elastomer processing. Exhibiting a high temperature stability up to 400 °C, SK2TR400-1 provides a fairly abrasion-resistant film that adheres strongly to most mould materials. Mould fouling resulting from residues of pigments, resins etc. is reduced notably when SK2TR400-1 is used.

► APPLICATION

Prior to the application of SK2TR400-1, moulds have to be cleaned thoroughly. It is further recommended to wash the moulds afterwards at room temperature with a fast evaporating solvent to eliminate all residues of grease or waxes. As a priming coat, 1-2 thin uniform layers of the release agent are applied to the mould. Between applications, the product should be allowed to cure. We recommend to set curing temperature to 120 °C (1-2 min). Alternatively, the resulting film can be tempered at processing temperature, adjusting curing time accordingly (lower temperatures usually require longer curing times and vice versa). According to experience, longer curing time and higher temperature will result in an improved durability of the releasing film. Processing can be started without further pre-treatments. During running production, the release film should be touched-up as soon as release performance decreases notably. Application of one single layer will be sufficient, considering the appropriate curing time.

► TECHNICAL DATA

Appearance:	Colorless fluid
Composition:	Mixture of resins in solvents
Density [g/cm^3]:	Approx. 0,72
Flashpoint:	<0

► SIZE

Packaging
Box of 15 Cans x 1 L
Can 5 L

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

SK2TR400-3

Semi-permanent mould release agent

Back to range

► DESCRIPTION

SK2TR400-3 is a fast-evaporating solvent-based semi-permanent mould release agent used for processing composites that features similar characteristics as our semi-permanent mould release SK2TR400-2. The versatile product provides excellent lubrication and release for smooth processing and a high-gloss surface finish. After cure, the release film is temperature stable up to 400°C / 752°F. However, the recommended application temperature ranges from 10 to 60°C (50 – 140°F). Release agent SK2TR400-3 does not transfer to the moulded parts, thereby allowing for post-processing, such as varnishing etc., without additional preparation. A build-up of release agent in the mould is highly unlikely if the product is used as directed.
Release agent SK2TR400-3 is universally applicable for processing epoxy resins (thermosets and prepregs), polyester and phenolic resins as well as thermoplastic composites.
This product is used in various manufacturing processes of parts made of composite materials.

► APPLICATION

Please note that Release agent SK2TR400-3 is a solvent-based product and hence should only be used in well-ventilated areas. Keep the container tightly closed during storage since the product reacts with moisture.

Mould cleaning:

Prior to the first application of Release agent SK2TR400-3 thoroughly clean the moulds. We recommend to use one of our SK2TR cleaners for this purpose. In case of larger deposits of resins you can also use a soft abrasive.

Mould sealing:

Release agent SK2TR400-3 usually does not require separate mould sealing. However, when using porous, or freshly repaired moulds, treating the mould with an adequate mould sealer from our range is recommended in order to achieve best release performance.

Base coat:

Release agent SK2TR400-3 can be applied by means of spraying, brushing or wiping. For spray application, we recommend to use dry air or an airless spray gun. It is recommended to apply Release agent SK2TR400-3 with the help of a soaked, yet not dripping clean lint-free cloth. Wipe the wet cloth over a mould surface covering an area of approx. 1 m^2 - evenly apply a thin continous layer of Release agent SK2TR400-3. Take care not to wipe or spray over the treated mould area before the applied film has been dried completely.

Continue by treating the adjacent mould areas in the same manner, frequently re-applying the product to the cloth. Special care should be taken to the overlap areas. Repeat this procedure until all parts of the mould are evenly coated.

We suggest wiping along the outer border first, approaching the inside. To ensure that the complete mould surface has been homogenously treated we recommend to apply a total of at least 2 layers of release agent SK2TR400-3. Please note that the solvent has to evaporate completely and each layer should be cured 5-10 min prior to application of the consecutive layer. The resulting release film should be dry and not sticky.
Please further note that spray application may lead to a matt surface finish. In this case, the dry surface can be polished with the help of a clean cotton rag to enhance the gloss.
In order to guarantee best release performance of SK2TR400-3, new moulds made of glass fiber or epoxy need to be fully cured prior to starting production.
When employing closed moulds make sure that all solvent has been evaporated completely before starting production. If necessary, use oil-free compressed air to dry the mould surface.

Mould touch-up:

When starting production, the release film should be touched-up after 5-6 demouldings to achieve best performance. During running production, the release film wears and hence has to be refreshed frequently. We highly recommend to perform the touch-up prior to a drastic decrease in release performance to guarantee a constant high product quality and keep mould build-up low. The appropriate frequency for touch-ups depends on the individual production conditons and has to be determined in on-site trials. For touch-up, applying one single layer of Release agent SK2TR400-3 considering the curing time will be sufficient.
Release agent SK2TR400-3 has been designed to chemically bond and integrate consecutively applied layers of itself, thereby allowing for partial touch-ups. However, we recommend refreshing the complete release film.

Partial release film repair:

Occasionally, a partial, drastic decrease in release performance might occur, requiring partial repair of the release film. In this case, remove the worn release film completely 10 cm around the affected area with the help of soft abrasion and wiping with solvent. Note that poor cleanings drastically impair the release film adhesion on the affected areas. Treat the cleaned areas as if they were new (cf. Base coat). Continue by refreshing the film after each demoulding for the first 4-6 releases after the repair. Keep in mind, that the repaired areas are more damageable than others.

TECHNICAL DATA SHEET

SK2TR400-3

Semi-permanent mould release agent

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Resin mixture in solvents
Density [g/cm^3]:	Approx. 0.72
Flashpoint:	7°C

► SIZE

Packaging
Box of 15 Cans x 1 L (0,72 kg)
Can 5 L (3,6 kg)

► STORAGE

This product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

SK2TR450-4

Semi-permanent mould release agent

Back to range

► DESCRIPTION

SK2TR450-4 is an easy-to-use semi-permanent mould release agent that dispenses with the need for application of any waxes. Since release agent SK2TR450-4 shows excellent adhesion to the mould's surface, there is no transfer of release agent to the moulded parts, rendering post processing possible without further treatments. It creates high gloss finished surfaces and minimizes release agent residues in the mould. The product exhibits a thermal stability up to 450 °C, the application temperature range is between 10–80 °C allowing for touch-ups on hot moulds. Release agent SK2TR450-4 is a multi-purpose product commonly used in the processing of thermoset resins, polyester, epoxy and phenolic resins.

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

► APPLICATION

Cleaning process:
We recommend to thoroughly clean mould surfaces prior to the application of release agent SK2TR450-4. Our cleaner SK2TR000-2 will be sufficient. In order to ensure all residues of fat and wax are removed completely, additional cleaning using a fast-evaporating solvent is advisable.

Sealing process:

New moulds, recently repaired moulds or moulds with a porous surface need to be treated with an appropriate sealer prior to their initial use. We recommend using our sealer SK2TR450-2 or SK2TR450-3, which has been specifically adjusted to incorporate our semi-permanent release agents of the category SK2TR.

Base Coating:

Release agent SK2TR450-4 can be sprayed, but application is commonly done by using a soaked, yet not dripping wet clean lint-free cotton cloth. Start by applying the release agent to a small manageable surface. After approx. 10–15 s, use a second, clean and dry cloth to absorb the release agent excess and proceed by wiping in circular motion until a clear and dry film emerges. We suggest beginning to wipe along the outer border, approaching the inside. Repeat this procedure with the adjacent areas until all parts of the mould are evenly coated. In order to obtain a smooth and homogenous base coat, a minimum of 2 layers of release agent SK2TR450-4 should be applied. Make sure, that the solvent is evaporated completely between each layer. After the final layer has been applied, allow the release agent to cure for about 40–60 min. Curing time can be reduced by heating the mould (approx. 50 °C, 20-30 min.).

Mould touch-up:

The first touch-up should be performed after 5-6 demouldings in order to prepare the mould for a high number of demoulding cycles. Since the release film wears during production touch-up coatings should be applied frequently. Release agent SK2TR450-4 has been designed to incorporate and chemically bond touch-up layers of itself. Hence, curing time after touch-up reduces to approx. 10 min at room temperature. The appropriate frequency of touch-ups for sufficient release depends on mould configuration and abrasion parameters and has to be determined in individual on-site trials. We highly recommend to apply the touch-up prior to an observed decrease in release efficiency. This procedure will significantly reduce mould fouling due to build-ups and lead to extended mould service lives while ensuring a constant high quality of the moulded parts. Release agent SK2TR450-4 can also be touched-up partially, refreshing the release agent film only on those mould areas experiencing higher wear. However, we recommend touch-up of the complete mould.

Partial release film repairs:

In the case of a partial, drastic decrease in release performance, the release coating should be partially repaired. Prior to doing so, the worn release film has to be removed completely 10 cm around the affected area with the help of soft abrasion, accompanied by wiping with solvent. Make sure that the mould's surface is thoroughly cleaned prior to application of a fresh base coat in the respective area in order to guarantee sufficient adhesion of the compensating layer to the mould.
Grounding is done as described above (Base coat). Even release of the moulded parts will be maintained if the repaired area is touched-up after each release for the first 4-6 demoulding cycles after the repair.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Resin mixture in solvents
Density [g/cm^3]:	Approx. 0.8
Max. used T:	450°C
Flashpoint:	>25°C

► SIZE

Packaging
Box of 15 Cans x 1 L
Can 5 L (3,9 kg)

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

TECHNICAL DATA SHEET

SK2TR450-5

Semi-permanent mould release agent

Back to range

► DESCRIPTION

SK2TR450-5 is an easy to use semi-permanent mould release agent for the processing of thermoset resins that provides excellent lubrication, rendering the product the release agent of choice when highly complex moulds with various undercuts are being used. Post processing, such as gluing or vanishing can be done without further treatments to the casting, since there is no transfer of SK2TR450-5 to the moulded parts. The product creates high gloss finished surfaces and minimizes build-up in the mould. It has a thermal stability till 450°C, the application temperature range is between 10°C - 80°C, allowing touch up coatings on hot moulds. Designated application fields include the processing thermoset resins, polyester, epoxy as well as phenolic resins. Especially highly complex mould geometries can reliably be casted.

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

► APPLICATION

Cleaning process:

Mould surfaces should be thoroughly cleaned prior to the application of release agent SK2TR450-5. We recommend using our cleaner SK2TR000-2 to do so. Additional cleaning using a fast-evaporating solvent is also recommended to ensure all residues of fat and wax are eliminated.

Sealing process:

New moulds, recently repaired moulds or moulds with a porous surface need to be treated with an appropriate sealer prior to their initial use. Our sealers SK2TR450-2 or SK2TR450-3 will be appropriate as these has been specifically adjusted to incorporate with our semi-permanent release agents of category SK2TR.

Base Coating:

Release SK2TR450-5 is usually applied with the help of a soaked, yet not dripping wet clean lint-free cotton cloth. However, the product can be sprayed. Commence by applying the release agent to a small surface area of about 1 m^2. After approx. 10 – 15 seconds, when the film is still moist, use a second, clean and dry cloth to absorb the release agent excess and proceed by wiping in circular motion until a clear and dry film emerges. We recommend to wipe along the outer border of the mould first, approaching the inside. Repeat this procedure with the adjacent areas until all parts of the mould are treated.

A minimum of 2 layers of release agent SK2TR450-5 should be applied to obtain a smooth and homogenous base coat. Ensure that the solvent evaporates completely between each application. After application of the final layer, release agent should be allowed to cure for about 40 – 60 minutes. Curing time can be reduced by increasing of mould's temperature (approx. 50°C, 20-30 min.).

Mould touch-up:

Good conditioning of the mould will be achieved if the release agent film is refreshed 5-6 demoulding cycles after the initial base coating process. The release film wears during production. Hence, touch-up coatings should be applied frequently, considering a curing time of approx. 10 min at room temperature after each touch-up. The appropriate frequency of touchups required for sufficient release depends on individual production conditions and has to be determined in on-site trials. Please contact our technical service for assistance. We highly recommend to apply the touch-up prior to an observed decrease in release efficiency as this will significantly reduce mould fouling and lead to extended mould service lives. Simultaneously, a constant high quality of the moulded parts can be achieved. Release agent SK2TR450-5 can also be touched-up partially, refreshing the release agent film only on those mould areas experiencing higher wear. Touch-up of the complete mould is preferred, though.

Partial release film repairs:

Occasionally, a partial, drastic decrease in release performance might occur, requiring partial repair of the coating. In order to do so, the worn release film has to be removed completely 10 cm around the affected area with the help of soft abrasion, accompanied by wiping with solvent. Make sure that the mould's surface is thoroughly cleaned prior to application of a fresh base coat in the respective area in order to guarantee sufficient adhesion of the compensating layer to the mould. Grounding is done as described above (Base coat). Even release of the moulded parts will be maintained if the repaired area is touched-up after each release for the first 4-6 demoulding cycles after the repair

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Mixture of resins in solvents
Density [g/cm^3]:	Approx. 0.8
Max. used T:	450°C
Flashpoint:	>25°C

► SIZE

Packaging
Box of 15 Cans x 1 L (0,78 kg)
Box of 4 Cans x 5 L (3,9 kg)

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

► DESCRIPTION

SK2TR450-6 is a fast evaporating semi-permanent mould release agent for the processing of thermoset resins. By using release agent SK2TR450-6, sealing the mould is no longer necessary. The product shows excellent adhesion to the mould's surface, thereby allowing for post-processing of moulded parts without the need for any further treatments. Moulded parts exhibit a high gloss surface finish. Release agent SK2TR450-6 is temperature-stable up to 450°C. Application is usually done at 10-80°C. It is a multi-purpose product used in the processing of thermoset resins, polyester, epoxy and phenolic resins. As release agent SK2TR450-6 dispenses without the need for any mould sealing, the product allows for significant time savings in mould preparation.

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

► APPLICATION

Cleaning process:

Mould surfaces should be thoroughly cleaned prior to the application of release agent SK2TR450-6. We recommend using our cleaner SK2TR000-2 to do so. Additional cleaning using a fast-evaporating solvent is also recommended to ensure all residues of fat and wax are eliminated.

Base Coating:

Release agent SK2TR450-6 can directly be applied to the mould, application of any mould sealer is not required. Use a soaked, yet not dripping wet clean lint-free cotton cloth to apply release agent SK2TR450-6 to a small surface area of about 1 m². After approx. 10–15 s, when the film is still moist, use a second, clean and dry cloth to absorb excess of release agent SK2TR450-6 and proceed by wiping in circular motion until a clear and dry film emerges. Beginning to wipe along the outer border of the mould approaching the inside is recommended. This procedure is repeated with the adjacent areas until all parts of the mould have been treated. We recommend application of a minimum of 2 layers of release agent SK2TR450-6 to ensure smooth and homogenous grounding. Make sure that the solvent is evaporated completely between each application. After application of the final layer, release agent SK2TR450-6 should be allowed to cure for about 30–60 min. Curing time can be reduced by increasing the mould's temperature (approx. 50°C, 15-30 min.).

Mould touch-up:

Good conditioning of the mould will be achieved if the release agent film is refreshed 5-6 demoulding cycles after the initial base coating process. The release film wears during production. Hence, touch-up coatings should be applied frequently, considering a curing

time of approx. 10 min at room temperature after each touch-up. The appropriate frequency of touchups required for sufficient release depends on individual production conditions and has to be determined in on-site trials. We highly recommend to apply the touch-up prior to an observed decrease in release efficiency as this will significantly reduce mould fouling and lead to extended mould service lives while maintaining a constant high quality of the moulded parts.
Release agent SK2TR450-6 can also be touched-up partially, refreshing the release agent film only on those mould areas experiencing higher wear. Touch-up of the complete mould is preferred, though.

Partial release film repairs:

Occasionally, a partial, drastic decrease in release performance might occur, requiring partial repair of the releasing film. Prior to doing so, the worn release film has to be removed completely 10 cm around the affected area with the help of soft abrasion, accompanied by wiping with solvent. Ensure that the mould's surface is thoroughly cleaned prior to application of a fresh base coat in the respective area in order to guarantee sufficient adhesion of the compensating layer to the mould.
Grounding is done as described above (Base coat). The repaired area should be touched-up after each release for the first 4-6 demoulding cycles after the repair in order to maintain best overall release performance.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Resin mixture in solvent
Density [g/cm^3]:	Approx. 0.8
Max. used T:	450°C
Flashpoint:	0°C

► SIZE

Packaging
Box of 15 Cans x 1 L
Can 5 L

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

► DESCRIPTION

SK2TR450-7 is a fast-evaporating semi-permanent mould release agent providing superior lubrication in the processing of thermoset resins. The product dispenses with the need for any mould sealing, thereby allowing for significant time savings. Since release agent SK2TR450-7 adheres strongly to the mould's surface, there is no transfer of release agent to the moulded parts which therefore can be post-processed without any further treatments. The product provides high gloss finished surfaces. When SK2TR450-7 is used, build-up in the mold is kept to a minimum. Thermal stability of this product reaches 450°C, however the application temperature range is between 10°C - 80°C. SK2TR450-7 is a multi-purpose product used in the processing thermoset resins, polyester, epoxy as well as phenolic resins. Thanks to its excellent lubrication properties, release agent SK2TR450-7 is the product of choice when highly complex moulds with various undercuts are being used.

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

► APPLICATION

Cleaning process:

We recommend to thoroughly clean mould surfaces prior to the application of release agent SK2TR450-7. Using our cleaner SK2TR000-2 will be sufficient. Additional cleaning using a fast-evaporating solvent is advisable to ensure all residues of fat and wax are eliminated

Base Coating:

Application of release agent SK2TR450-7 can be done without prior sealing of mould. Usually, a soaked, yet not dripping wet clean lint-free cotton cloth is used to apply the release agent. We recommend starting to treat a small manageable surface area first. After approx. 10 – 15 seconds, when the film is still moist, release agent excess is absorbed with the second clean cloth following by wiping in circular motion until a clear and dry film emerges. We suggest beginning to wipe along the outer border, approaching the inside. Repeat this procedure with the adjacent areas until all parts of the mould are evenly coated. Application of a minimum of 2 layers of release agent SK2TR450-7 is recommended in order to guarantee smooth and homogenous grounding. Make sure that the solvent evaporates completely between each layer. After the final layer has been applied, allow the release agent to cure for about 30 – 60 minutes. Curing time can be reduced by increasing the temperature of the mould (approx. 50°C, 15-30 min.).

Mould touch-up:

The first touch-up should be performed after about 5 - 6 releases, in order prepare the mould for a high number of release cycles. Since the release film wears out by use, refreshment

coatings should be applied frequently. Release agent SK2TR450-7 has been designed to incorporate and chemically bond touch-up layers of itself. Hence, curing time after touch-up reduces to approx. 10 min at room temperature. The appropriate frequency of touch-ups for a constant high release performance depends on individual production conditions and has to be determined in on-site trials. We highly recommend applying touch-up prior to an observed decrease in release efficiency. This procedure will significantly reduce mould fouling due to build-ups and lead to extended mould service lives while ensuring a constant high quality of the moulded parts. Release agent SK2TR450-7 can also be touched-up partially, refreshing the release agent film only on those mould areas experiencing higher wear. Touch-up of the complete mould is preferred, though.

Partial release film repairs:

In the case of a partial, drastic decrease in release performance, the release coating should be partially repaired. Prior to doing so, the worn release film has to be removed completely 10 cm around the affected area with the help of soft abrasion, accompanied by wiping with solvent. Ensure that the mould's surface is thoroughly cleaned prior to application of a fresh base coat in the respective area in order to guarantee sufficient adhesion of the compensating layer to the mould.
Grounding is done as described above (Base coat). The repaired area should be touched-up after each release for the first 4-6 demoulding cycles after the repair in order to maintain best overall release performance.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Mixture of resins in solvents
Density [g/cm^3]:	Approx. 0.8
Max. used T:	450°C
Flashpoint:	0°C

► SIZE

Packaging
Box of 15 Cans x 1 L
Can 5 L

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

► DESCRIPTION

Release agent SK2TR450-12 is a very fast-evaporating semi-permanent mould release agent used in the processing of thermoset resins. It is easy to handle and adheres excellent to the mould's surface (no transfer to the moulded parts), thereby rendering downstream processing, such as gluing or vanishing, possible without further treatments to the casting. Release agent SK2TR450-12 creates high gloss finished surfaces and minimizes release agent residues in the mould. The product designated application fields include the processing of thermoset resins, polyester, epoxy as well as phenolic resins.

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

► APPLICATION

Cleaning process:

Prior to the first application of release agent SK2TR450-12, ensure to thoroughly clean the moulds from dirt and former release agent residues. We recommend using the cleaner of the category SK2TR. Proceed to clean the moulds at room temperature with a fast-evaporating solvent to eliminate all residues of grease and wax.

Base Coating:

Apply Release Agent SK2TR450-12 by using a soaked, yet not dripping wet clean lint-free cotton cloth. Start by applying the release agent to a small surface area of approx. 1 m², letting the film dry completely (wipe on, leave on). We suggest beginning to wipe along the outer border, approaching the inside. Repeat this procedure with the adjacent areas until all parts of the mould are evenly coated. To complete the whole coating process, follow these guidelines and apply 3 - 4 layers of release agent SK2TR450-12 to the mould. Allow each layer to cure for about 10 minutes. After the last layer has been applied, allow the release agent to cure for about 40 – 60 minutes.

Mould touch-up:

The first release film refreshment should be performed after about 5 - 6 releases, in order to prepare the mould for a high number of release cycles. Since the release film wears during running production, touch-up coatings should be applied frequently. Release Agent SK2TR450-12 has been designed to incorporate and chemically bond touch-up layers of itself. Hence, curing time after touch-up reduces to approx. 10 min at room temperature. The appropriate frequency of touch-ups required for constant high release performance depends on individual production conditions and has to be determined in on-site trials. We highly recommend to apply the touch-up prior to an observed decrease in release efficiency

as this will significantly reduce mould fouling and maintain a constant high quality of the moulded parts.
Although Release Agent SK2TR450-12 can be touched-up partially, we recommend touch-up of the complete mould.

Partial release film repairs:

Occasionally, a partial, drastic decrease in release performance might occur, requiring partial repair of the releasing film. Prior to repairing the release film of a particular area of the mould, the worn release film needs to be removed completely 10 cm around the affected area. Semi-permanent release agents require soft abrasion as well as a wiping with solvent. Poor cleanings drastically impair the release film adhesion on the affected areas. Treat these cleaned areas as if they were a new mould (see Base coat). Continue by refreshing the film after each release for the first 4-6 demoulding cycles after the repair. Keep in mind, that the repaired areas are more damageable than others.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Resin mixture in solvents
Density [g/cm^3]:	Approx. 0.7
Flashpoint:	0°C

► SIZE

Packaging
Box of 15 Cans x 1 L (0,70 kg)
Set of 4 Cans of 5 L

► STORAGE

This product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

SK2TR450-13

Semi permanent release agent

Back to range

► DESCRIPTION

SK2TR450-13 is an ultra-fast evaporating, multi-purpose semi-permanent mould release agent that is used to release most thermosetting resins such as polyester, vinyl ester, epoxy and phenolic resins from all kind of mould materials. It has specifically been designed for application on non-gelcoated surfaces. The product features excellent slip and release properties and is especially easy and fast to apply (wipe on, leave on). After cure, the release film is temperature stable up to 450°C and very durable, thereby allowing for multiple releases per application. The moulded parts are not contaminated and hence can be varnished or glued directly after the demoulding without further treatments.

SK2TR450-13 series are coordinated separation systems with different sliding properties:

SK2TR450-13L stands for low sliding properties,
SK2TR450-13M stands for medium sliding properties
SK2TR450-13H stands for high sliding properties
The three SK2TR450-13 types are compatible with each other.

The product is also ideally suited for many other moulding processes where a room/low temperature below 60°C application is possible, such as rotational moulding. Note that the product is not suited to release isocyanate containing resins and silicone elastomers.
This product is used in various manufacturing processes of parts made of composite materials.

► APPLICATION

Please make sure that Release agent SK2TR450-13 is only handled in well-ventilated areas.

Cleaning process:

Ensure that the mould has been thoroughly cleaned from residues of wax and silicone with the help of a solvent-based cleaner. We recommend using our cleaner of the category SK2TR. Release agent SK2TR450-13 has been adjusted in formulation to allow application over existing semi-permanent release agents without a further cleaning step. However, ensure that the mould is clean and dry.

Base Coating:

When Release agent SK2TR450-13 is used in production, there is no need for an additional mould sealer, even when using porous mould surfaces. Application is done with the help of a soaked, yet not dripping clean lint-free cloth. Wipe the wet cloth over a mould surface covering an area of approx. 0,5 m² - do not rub or polish afterwards.

Continue by treating the adjacent mould areas in the same manner, frequently re-applying the product to the cloth. Special care should be taken to the overlap areas. Repeat this procedure until all parts of the mould are evenly coated. We suggest wiping along the outer border first, approaching the inside. When dry, allow a further 10-15 min before applying the consecutive release film layer. In total, 2-3 layers of Release agent SK2TR450-13 should be applied to the mould surface. In case of new, porous or freshly repaired moulds apply an extra 1-2 coating layers as described above. After the final layer has been applied, allow the film to cure for at least 30 min at room temperature. Note that longer curing times or curing at elevated temperatures (e. g. 5 min at 60°C) will result in an improved release film durability.

Mould touch-up:

During running production, the release film wears and hence has to be refreshed frequently. We highly recommend to perform the touch-up prior to a drastic decrease in release performance to guarantee a constant high product quality and keep mould build-up low. The appropriate frequency for touch-ups depends on the individual production conditons and has to be determined in on-site trials. For touch-up, applying one single layer of Release agent SK2TR450-13 considering the curing time will be sufficient.
Release agent SK2TR450-13 has been designed to chemically bond and integrate consecutively applied layers of itself, thereby allowing for partial touch-ups. However, we recommend refreshing the complete release film.

Partial release film repairs:

Occasionally, a partial, drastic decrease in release performance might occur, requiring partial repair of the release film. In this case, remove the worn release film completely 10 cm around the affected area with the help of soft abrasion and wiping with solvent. Note that poor cleanings drastically impair the release film adhesion on the affected areas. Treat the cleaned areas as if they were new (cf. Base coat). Continue by refreshing the film after each demoulding for the first 4-6 releases after the repair. Keep in mind, that the repaired areas are more damageable than others.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Resin mixture in solvents
Density [g/cm^3]:	Approx. 0.74
Flashpoint:	0°C

► SIZE

Packaging
Box of 15 Cans x 1 L (0,74 kg)
Set of 4 Cans x 5 L

► STORAGE

This product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

► DESCRIPTION

SK2TR450-14 is a sprayable solvent-based semi-permanent mould release agent used in the processing of thermoset resins such as polyester, vinyl ester, epoxy and phenolic resins, from non-porous or gel-coated moulds. The product combines straightforward handling with excellent release performance and allows for multiple releases per application. Since the release coating does not transfer to the moulded parts, downstream processes, such as varnishing, are not impaired. Being versatile with regard to the type of mould surface used, Release agent SK2TR450-14 minimizes mould build-up and provides an instant high gloss finish. The ability to spray apply remarkably fastens the release agent application as compared to traditional wax-based pastes. After curing, the release film is temperature stable up to 450°C. The product is ideally suited for non-skid or textured large open moulds.

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

► APPLICATION

As with all processes involving solvents, Release agent SK2TR450-14 should only be handled in a well-ventilated area.

Cleaning process:

Make sure to remove all residues of dirt and former release agents, especially wax- and silicone-based release agents, from the mould surface prior to applying Release Agent SK2TR450-14. Application on top of other semi-permanent release agents is possible, but not recommended. For cleaning we recommend using our Cleaners SK2TR000-1 and SK2TR000-2.

Base Coating:

Release Agent SK2TR450-14 is usually applied by means of spraying. Although using any spray gun capable of fine atomization will be sufficient, we highly recommend applying a high volume low pressure spray gun since according to experience this will result in best release performance and product quality. Set the pressure to approx. 2-2,5 bar and hold the nozzle (preferred < 1,5 mm) of the gun approx. 20-25 cm from the mould surface. The output should be adjusted to allow for film drying in about 2-3 s after spraying. Systematically coat the entire surface of the mould. Special care should be taken to the over-lap spray areas. Immediately after applying the first layer, apply a second coat rectangular to the first. To complete the whole coating process, follow these guidelines and apply 2-3 coating layers of Release Agent SK2TR450-14 to the mould. After application of the final layer, allow the release agent to cure for at least 30 min at room

temperature. In case of using new, repaired or porous moulds, apply a further 2 coats to ensure best release performance. In order to avoid hazing and poor durability of the release film, we recommend to test the gun settings as well as the spray technique on the mould edge first
and to immediately remove over application or drippings by means of wiping or rubbing with a clean dry cloth. Then, reapply release agent SK2TR450-14 in the same manner as described above.

Mould touch-up:

Since the release film wears during running production, touch-up coatings should be applied frequently. The appropriate frequency of touch-ups required for constant high release performance depends on individual production conditions and has to be determined in on-site trials. We highly recommend to apply the touch-up prior to an observed decrease in release efficiency as this will help maintaining a constant high quality of the moulded parts. We recommend touch-up of the complete mould.

Partial release film repairs:

Occasionally, a partial, drastic decrease in release performance might occur, requiring partial repair of the release film. In this case, remove the worn release film completely 10 cm around the affected area with the help of soft abrasion and wiping with solvent. Note that poor cleanings drastically impair the release film adhesion on the affected areas. Treat the cleaned areas as if they were new (cf. Base coat). Continue by refreshing the film after each demoulding for the first 4-6 releases after the repair. Keep in mind, that the repaired areas are more damageable than others.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Resin mixture in solvents
Density [g/cm^3]:	Approx. 0.72
Flashpoint:	0°C

► SIZE

Packaging
Box of 15 Cans x 1 L (0,72 kg)
Set of 4 Cans of 5 L

► STORAGE

This product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

TECHNICAL DATA SHEET

SK2TR400-4

Semi-permanent release agent

Back to range

► DESCRIPTION

Release agent SK2TR400-4 is an easy-to-use, semi-permanent, water-based mould release agent for composite processing which works without sealing the mould. The product provides a closed film on the mould. Though this film is micro-thin, it is very resistant after a short curing time and temperature stable up to 400°C / 752°F. The release film exhibits a strong chemical bonding to almost all mould materials, so that a single application allows multiple release. Release agent SK2TR400-4 does not transfer to the moulded parts, allowing further processing steps such as varnishing, gluing etc. without prior treatment. It is an air-drying system, heat curing is not necessary. Build-up on the moulds can be eliminated almost completely if the release agent is used as directed.

Release agent SK2TR400-4 can be used as a release agent for hot presses with thermosets such as polyester, epoxy, phenolic, melamin resins, PU-gelcoats as well as for RTM procedures.

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

► APPLICATION

Prior to the first application of Release agent SK2TR400-4, the moulds have to be cleaned thoroughly. Afterwards we recommend to clean the cold moulds with a fast evaporating solvent to eliminate all residues of grease and wax. Apply 1-2 thin and even layers of Release agent SK2TR400-4 as a priming coating. Application can be done by hand, with cotton cloths, with a brush, a sponge or, which would be the best, by spraying. According to experience, longer drying times and higher application temperatures will enforce the release film's stability and will increase the number of possible releases. After this pretreatment, the processing can be started. One single application of Release agent SK2TR400-4 is sufficient to refresh the release film as soon as release performance decreases.

► TECHNICAL DATA

Appearance:	White liquid
Composition:	Aqueous emulsion of synthetic resins
Density [g/cm^3]:	Approx. 1
pH-value (20°C):	Approx. 5

► SIZE

Packaging
Box of 15 Cans x 1 L
Can 5 L (5 kg)

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 12 months.

► NOTE

Other packaging (30 and 200 litres) is available upon request.

TECHNICAL DATA SHEET

SK2TR400-5

Semi-permanent release agent

Back to range

► DESCRIPTION

Release agent SK2TR400-5 is an easy-to-use, semi-permanent, water-based mould release agent for composite processing which works without sealing the mould. The product provides a closed film on the mould. Though this film is micro-thin, it is very resistant after a short curing time and temperature stable up to 400°C / 752°F. The release film exhibits a strong chemical bonding to almost all mould materials, so that a single application allows multiple release. Release agent SK2TR400-5 does not transfer to the moulded parts, allowing further processing steps such as varnishing, gluing etc. without prior treatment. It is an air-drying system, heat curing is not necessary. Build-up on the moulds can be eliminated almost completely if the release agent is used as directed.

Release agent SK2TR400-5 can be used as a release agent for hot presses with thermosets such as polyester, epoxy, phenolic, melamin resins, PU-gelcoats as well as for RTM procedures.

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

► APPLICATION

Prior to the first application of Release agent SK2TR400-5, the moulds have to be cleaned thoroughly. Afterwards we recommend to clean the cold moulds with a fast evaporating solvent to eliminate all residues of grease and wax. Apply 1-2 thin and even layers of Release agent SK2TR400-5 as a priming coating. Application can be done by hand, with cotton cloths, with a brush, a sponge or, which would be the best, by spraying. According to experience, longer drying times and higher application temperatures will enforce the release film's stability and will increase the number of possible releases. After this pretreatment, the processing can be started. One single application of Release agent SK2TR400-5 is sufficient to refresh the release film as soon as release performance decreases.

► TECHNICAL DATA

Appearance:	White liquid
Composition:	Aqueous emulsion of synthetic resins
Density [g/cm^3]:	Approx. 1
pH-value (20°C):	Approx. 5

► SIZE

Packaging
Box of 15 Cans x 1 L
Can 5 L (5 kg)

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 12 months.

► NOTE

Other packaging (30 and 200 litres) is available upon request.

SK2TR450-8

Semi-permanent release agent

Back to range

► DESCRIPTION

SK2TR450-8 is a water-based semi-permanent release agent enabling a straightforward processing of thermoset resins. Due to its well-balanced composition, release agent SK2TR450-8 provides superior release properties and excellent adhesion to the mould's surface. Downstream processing, such as gluing or varnishing, is possible without the need for any further treatments since SK2TR450-8 does not transfer to the moulded parts. The product provides a high gloss surface finish.
SK2TR450-8 is universally applicable on porous surfaces and releases all commonly used thermoset resins, such as polyester, epoxy and phenolic resins and PUR gelcoats. Especially if processing standards demand a high slip, SK2TR450-8 will be the perfect match.

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

► APPLICATION

Cleaning:

It is recommended to thoroughly clean and dry mould surfaces prior to the application of release agent SK2TR450-8. Our cleaner SK2TR000-2 will be sufficient. However, release agent SK2TR450-8 is also suitable for touch-up coatings.

Base coat:

Green or freshly repaired moulds can directly be coated with release agent SK2TR450-8. Any initial mould sealing is not required.
Apply release agent SK2TR450-8 by wiping with a soaked, but not dripping, clean lint-free cloth. Commence by applying the release agent to a small surface area of approx. 1 m². After about 30-60 s, when the film is still moist, use a second dry cloth to absorb excess of release agent SK2TR450-8 and proceed by wiping in circular motion until a clear and dry film emerges. In the case of occurring streaks or smears reduce the time before wiping off excess of release agent. We recommend beginning to wipe along the mould's outer border, approaching the inside. This procedure is repeated with the adjacent areas until all parts of the mould are evenly coated. In order to obtain a smooth and homogenous base coat, 2-3 layers of release agent SK2TR450-8 have to be applied. Allow each layer to cure for about 10 min. After the final layer has been applied, release agent SK2TR450-8 should be allowed to cure for about 15-30 min at 60 °C.

Mould touch-up:

Good conditioning of the mould will be achieved if the release agent film is refreshed 2-4 demoulding cycles after the initial base coating process. Since the release film wears during production touch-up coatings should be applied frequently.

Release agent SK2TR450-8 has been designed to incorporate and chemically bond touch-up layers of itself. Hence, curing time after touch-up reduces to approx. 15 min at room temperature. The required frequency of touch-ups for sufficient release depends on mould configuration and abrasion parameters and must be determined in individual on-site trials. We highly recommend to apply the touch-up prior to an observed decrease in release efficiency. This will significantly reduce mould fouling due to build-ups and lead to extended mould service lives while ensuring a constant high quality of the moulded parts.
Release agent SK2TR450-8 can also be touched-up partially, refreshing the release agent film only on those mould areas experiencing higher wear. Touch-up of the complete mould is preferred, though.

Partial release film repairs:

Occasionally, a partial, drastic decrease in release performance might occur, requiring partial repair of the coating. In order to do so, the worn release film has to be removed completely 10 cm around the affected area with the help of soft abrasion, accompanied by wiping with solvent. Make sure that the mould's surface is thoroughly cleaned prior to application of a fresh base coat in the respective area in order to guarantee sufficient adhesion of the compensating layer to the mould.
Grounding is done as described above (Base coat). Even release of the moulded parts will be maintained if the repaired area is touched-up after each release for the first 4-6 demoulding cycles after the repair.

► TECHNICAL DATA

Appearance:	Cream-colored liquid
Composition:	Aqueous emulsion of synthetic resins
Density [g/cm^3]:	Approx. 1
pH-value (20°C):	Approx. 4

► SIZE

Packaging
Box of 15 Cans x 1 L
Can 5 L (5 kg)

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 12 months.

► NOTE

Other packaging (30 and 200 litres) is available upon request.

TECHNICAL DATA SHEET

SK2TR450-9

Semi-permanent release agent

Back to range

► DESCRIPTION

Release agent SK2TR450-9 was specially developed for the aerospace sector. It is an easy-to-use, semi-permanent, water-based mould release agent which works without sealing the mould. The product forms a complete film on the mould. Though this film is micro-thin, it is very resistant after a short curing time and temperature stable up to 450°C.

It has a strong chemical bonding to almost all mould materials and a single application allows multiple releases. To meet the requirements of the aerospace sector, release agent SK2TR450-9 does not transfer to the moulded parts, allowing further processing steps such as varnishing, gluing etc. without prior treatment. It's an air-drying system, heat curing is not necessary. Build-up on the moulds can be eliminated almost completely if the release agent is used as directed. SK2TR450-9 can be used as a release agent for hot presses with thermosets such as polyester, epoxy, phenolic, melamin resins, PU-gelcoats as well as for RTM procedures.

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

► APPLICATION

Prior to the first application of release agent SK2TR450-9 the moulds have to be cleaned thoroughly. Afterwards we recommend to clean the moulds with a fast evaporating solvent to eliminate all residues of grease and wax. Apply 1 - 2 thin and even layers of release agent SK2TR450-9 as a priming coating. Application can be done by hand, with cotton cloths, with a brush, a sponge or, which would be the best, by spraying. Longer drying times and higher temperatures will enforce the release film`s stability and will increase the number of possible releases. After this pretreatment, the processing can be started. One single application of SK2TR450-9 is sufficient to refresh the release film considering the drying time.

► TECHNICAL DATA

Appearance:	White liquid
Composition:	Aqueous emulsion of synthetic resins
Density [g/cm^3]:	Approx. 1
pH-value (20°C):	Approx. 3

► SIZE

Packaging
Box of 15 Cans x 1 L
Can of 5 L (5 kg)

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 12 months.

► NOTE

Other packaging (30 and 200 litres) is available upon request.

SK2TR450-10

Release agent

Back to range

► DESCRIPTION

SK2TR450-10 is an external mould release agent on a basis of fluorocarbon polymers dispersed in water. Under optimum preconditions the product does not need additional mould sealers. The product forms a thin, yet highly stable release film to withstand operating temperatures of up to 450°C after the curing cycle. One single application of release agent SK2TR450-10 allows multiple mould release cycles. It possesses a strong chemical bond to almost any mould material, allowing a high number of possible releases per application. SK2TR450-10 is an air-drying system, rendering heat curing-cycles unnecessary. It will not cause build-up of release agent residues on the mould surface, if applied properly.
SK2TR450-10 is suited for the purpose of processing thermoset materials, such as polyester, epoxy resins, phenolic resins and melamine resins and PU gel coats.

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

► APPLICATION

Clean the moulds well prior to the initial use of release agent SK2TR450-10. We recommend an additional cleaning step with a suitable solvent to eliminate any persistent fatty, greasy or wax residue on the mould surface. Apply 1-2 thin, yet even layers of the product as a priming coat. Higher temperatures as well as the amount of time you allow the coating to dry will greatly enhance the number of possible release cycles per application. The manufacturing process can be started after this initial mould treatment. One single application of SK2TR450-10 is sufficient to recondition the release film, abiding by individual curing time parameters.

► TECHNICAL DATA

Appearance:	Beige liquid
Composition:	Dispersion of polymers in water
Density [g/cm^3]:	Approx. 1
pH-value (20°C):	Approx. 9.5

► SIZE

Packaging
Box of 12 cans x 1 L (1 kg)
Set of 4 Cans x 5 L (5 kg)

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 12 months.

► NOTE

Other packaging (30 and 200 litres) is available upon request.

TECHNICAL DATA SHEET

SK2TR450-11

Semi-permanent release agent

Back to range

► DESCRIPTION

SK2TR450-11 is a semi-permanent, water-based mould release agent which dispenses without need for any mould sealing. Requiring only a very short curing time, release agent SK2TR450-11 forms a highly resistant film on the surface of the mould that is temperature-stable up to 450 °C. Due to its strong adhesion to almost all mould materials the product allows for multiple releases. SK2TR450-11 does not transfer to the moulded parts, allowing further processing steps such as varnishing, gluing etc. without prior treatment. It is an air-drying system; heat curing is not necessary. Build-up on the moulds can be eliminated almost completely if the release agent is used as directed.

SK2TR450-11 can be used as a release agent for hot-forming processes with thermosets such as polyester, epoxy, phenolic, melamin resins, PU-gelcoats as well as for RTM procedures.

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

► APPLICATION

Prior to the first application of SK2TR450-11 moulds have to be cleaned thouroughly. Our cleaner SK2TR000-2 will be sufficient. Additional cleaning using a fast evaporating solvent is advisable in order to ensure elimination of all residues of grease and wax. Apply 1 - 2 thin and even layers of SK2TR450-11 as a priming coating. Application can be done by hand, with cotton cloths, with a brush, a sponge or, which would be the best, by spraying. Longer curing times and higher temperatures will enforce the release film`s stability and will increase the number of possible releases. After this pretreatment, the processing can be started. One single application of release agent SK2TR450-11 is sufficient to refresh the release film considering the curing time.

► TECHNICAL DATA

Appearance:	White liquid
Composition:	Aqueous emulsion of synthetic resins
Density [g/cm^3]:	Approx. 1
pH-value (20°C):	Approx. 4

► SIZE

Packaging
Set of 6 PE can of 5 kg each
Can of 30 kg
Set of 4 can of 30 kg each
Can of 160 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 12 months.

► NOTE

Other packaging (30 and 200 litres) is available upon request.

TECHNICAL DATA SHEET

SK2TR150-1

Release Paste

Back to range

► DESCRIPTION

SK2TR150-1 is a paste which can be easily applied on the mould and polished to mirror finish. The product is specially developed for the sealing of mould surfaces for processing of composites. It can be used as release paste / sealer for the purpose of processing polyester resins, gelcoats and epoxy resins.
This product is used in various manufacturing processes of parts made of composite materials.

► APPLICATION

Clean the mould thoroughly from residues of dirt and other release agents prior to the application of SK2TR150-1. Proceed to clean the moulds with a fast-evaporating solvent to eliminate all residues of grease and wax. The next step is to apply a thin layer of release paste and allow it to dry. Afterwards it has to be polished with a rag. In practice 4 – 5 layers of SK2TR150-1 and polishing afterwards have proved of value. Please note that polishing is required after each single application.

► TECHNICAL DATA

Appearance:	Yellowish paste
Composition:	Mixture of waxes in solvents
Density [g/cm^3]:	Approx. 0.8
Flash Point [°C]:	60°C

► SIZE

Packaging
Can of 0,5 l (0,35 kg)
12 x Can of 0,5 l (set of 4,2 kg)
8 boxes x 12 (can of 0,35 kg) - 96 cans (33,6 kg)
Bucket 30 l (22 kg)

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

► DESCRIPTION

Release agent SK2TR150-2 is a multi-purpose, liquid solvent-based wax for multiple demouldings for high gloss moulds with short drying time. The use of this product eliminates the need for repeated waxing and polishing, as a single application allows, after some starting time that demands frequent treatment of the mould, several releases. The product forms a monomolecular film that adheres to the mould and does not show any affinity to the moulded parts. This film is not peeled off and provides with its high release effect important improvements for the composite industry. It is silicone-free.
SK2TR150-2 can be used as a multi-purpose release agent for the purpose of processing thermoset resins, polyester (cold and hot forming), epoxy resins and phenolic resins. In particular, when the processing takes place at higher temperatures, excellent results are obtained. As the product forms a complete film, it can also be used as an anti-corrosive for steel moulds or as weather protection. At higher temperatures it can even be used as lubricant.
This product is used in various manufacturing processes of parts made of composite materials.

► APPLICATION

Prior to the first application of Release Agent SK2TR150-2, the moulds have to be cleaned thoroughly from residues of dirt and former release agent. We recommend to use our cleaner SK2TR000-2. The next step is to apply release agent SK2TR150-2 as an even, thin film and allow it to dry. The application can be done either by spraying, wiping or brushing. Before starting the production, ensure that the film is absolutely dry. Release agent should be stirred up or shaken prior to use.

► TECHNICAL DATA

Appearance:	Whitish paste
Composition:	Combination of waxes in solvents mixture
Density [g/cm^3]:	Approx. 0.78
Flash Point [°C]:	<0°C

► SIZE

Packaging
Can of 3,9 kg
Drum of 156 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

TECHNICAL DATA SHEET

SK2TR250-1

Release liquid/sealer

Back to range

► DESCRIPTION

SK2TR250-1 is a water-based release agent which can be easily applied on the mould and polished to mirror finish. The product is specially developed for the sealing of mould surfaces for processing of composites. It can be used as release agent / sealer for the purpose of processing polyester resins, gelcoats and epoxy resins.

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

► APPLICATION

Clean the mould thoroughly from residues of dirt and other release agents prior to the application of SK2TR250-1. We recommend to use a suitable cleaner, for example SK2TR000-1. Proceed to clean the moulds with a fast-evaporating solvent to eliminate all residues of grease and wax. The next step is to apply a thin layer of release agent SK2TR250-1 and allow it to dry. Afterwards it has to be polished with a rag. In practice 2 – 3 layers of the product and polishing afterwards have proved of value. Please note that polishing is required after each single application.

► TECHNICAL DATA

Appearance:	Blue liquid
Composition:	Aqueous dispersion
Density [g/cm^3]:	Approx. 1
Ph-value (20°C):	Approx. 4

► SIZE

Packaging
Can of 5 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 12 months.

TECHNICAL DATA SHEET

SK2TR150-3

Release agent

Back to range

► DESCRIPTION

Release agent SK2TR150-3 is a multi-purpose, liquid external mould release agent used in the processing of composites, especially polymer concrete. The product provides a fairly abrasion-resistant release film, rendering it especially suited for the procession of highly abrasive raw materials. Release agent SK2TR150-3 is a solvent-based formulation. Hence, drying time is low, allowing for an efficient production process. The product is completely free of silicone.
SK2TR150-3 is universally applicable in the processing of polymer concrete, polyester as well as epoxy resins. Since the product provides a coherent release film, it can further be used as an anti-corrosive for steel moulds or as weather protection. Additionally, it may be employed as lubricant at elevated temperatures.
This product is used in various manufacturing processes of parts made of composite materials.

► APPLICATION

Release Agent SK2TR150-3 should be thoroughly stirred directly before use. Prior to the first application, moulds have to be thoroughly cleaned from residues of dirt and former release agents. Cleaner SK2TR000-2 will be sufficient. Release agent SK2TR150-3 is applied as a thin and even film by means of spraying, brushing or wiping. Before starting production, ensure that the film is absolutely dry.

► TECHNICAL DATA

Appearance:	White liquid
Composition:	Selected waxes in solvents mixture
Density [g/cm^3]:	Approx. 0.74
Flash Point [°C]:	0°C

► SIZE

Packaging
Can of 22,2 kg
Drum of 148 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

TECHNICAL DATA SHEET

SK2TR000-4

Additive reducing the surface tension of mould

Back to range

► DESCRIPTION

Additive SK2TR000-4 has been developed and optimized to be used in combination with semi-permanent release agents. The combination results in an improved processability and improved surface quality of produced parts. Additive SK2TR000-4 is added to the uncured resin and reduces the surface tension. This not only improves flow and wetting properties of resins, but also helps to prevent pin holes and fish eyes from appearing. Moreover, employing the product increases the scratch resistance of the surface. Additive SK2TR000-4 is generally used in the processing of composites and employed as an additive in gelcoats.
This product is used in various manufacturing processes of parts made of composite materials.

► APPLICATION

SK2TR000-4 can be added any time during the production process. The recommended dosage varies depending on the formulation and the raw materials in the range 0,5 – 2 % relative to the total quantity of material. The appropriate concentration has to be determined individually in on-site trials. Please contact our technical service for assistance. It is generally advisable to start the tests with the lowest recommended level and to increase the dosage until the desired results are achieved.

► TECHNICAL DATA

Appearance:	Yellow liquid
Composition:	Solution of polymers and wetting agents
Density [g/cm^3]:	Approx. 0.92
Flash Point [°C]:	25°C

► SIZE

Packaging
Box of 6 x 0.46 kg
Can of 4.6 kg
Can of 9.2 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

TECHNICAL DATA SHEET

SK2TR250-2

Internal mould release agent

Back to range

► DESCRIPTION

Additive SK2TR250-2 is a liquid internal release agent used in the processing of composites, especially epoxy resins. This product minimizes the need for external release agents significantly thanks to its high release effect. Any post-moulding operation can be directly performed. As a consequence, the use of SK2TR250-2 results in an excellent overall economy. The product will not have an influence on the chemical and physical properties of the resin and does not contain any silicones or waxes. SK2TR250-2 is used as internal release agent for epoxy resins, polyester resins, acrylic resins and SMC.

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

► APPLICATION

Additive SK2TR250-2 is added directly into the resin. To achieve best release performance, thorough and careful admixing of the product is crucial. The recommended dosage varies depending on the formulation and the raw materials between 0.5 % and 1 % relative to the amount of resin. The adequate concentration has to be identified by individual on-site trials. Please contact our technical service for assistance. It is advisable to start the tests with the lowest recommended level and to increase the dosage until the desired results are achieved. Prior to the first application of SK2TR250-2, the moulds have to be cleaned from residues of dirt and release agents. Afterwards it is recommended to apply a mould sealer and to support the initial release by the single use of an external release agent. For these purposes we recommend the use of cleaner and sealers from the category SK2TR.

► TECHNICAL DATA

Appearance:	Yellow liquid
Composition:	Formulation of fatty acid derivatives
Density [g/cm^3]:	Approx. 0.92
Flashpoint [°C]:	115

► SIZE

Packaging
Can of 27.6 kg
Drum of 184 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

TECHNICAL DATA SHEET

SK2TR250-3

Internal mould release agent

Back to range

► DESCRIPTION

Additive SK2TR250-3 is a liquid internal release agent used in the processing of composites. Ideally, the use of external release agents can be reduced significantly. Any post-moulding operation can be performed without further steps. As a consequence, the use of SK2TR250-3 results in an excellent overall economy. The product will not have an influence on the chemical and physical properties of the resin and does not contain any silicones or waxes. SK2TR250-3 is used as internal release agent for polyester resins.

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

► APPLICATION

Additive SK2TR250-3 is added directly into the resin. To achieve best release performance, thorough and careful admixing of the product is crucial. The recommended dosage varies depending on the formulation and the raw materials between 0.5 % and 1 % relative to the amount of resin. The adequate concentration has to be identified by individual on-site trials. Please contact our technical service for assistance. It is advisable to start the tests with the lowest recommended level and to increase the dosage until the desired results are achieved. Prior to the first application of SK2TR250-3, the moulds have to be cleaned from residues of dirt and release agents. Afterwards it is recommended to apply a mould sealer and to support the initial release by the single use of an external release agent. For these purposes we recommend the use of cleaner and sealers from the category SK2TR.

► TECHNICAL DATA

Appearance:	Colourless liquid
Composition:	Mixture of active substances and high
molecular	hydracarbons
Density [g/cm^3]:	Approx. 0.85
Flashpoint [°C]:	200 °C

► SIZE

Packaging
Can of 25 kg
Drum of 160 kg

► STORAGE

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months.

VACUUM VALVES, CONNECTORS, MANOMETERS		
Name	**Description**	**Max. use T°C**
SK2VV000-2	Economical vacuum gauge	-
SK2VV000-3	Liquid filled vacuum gauge	-
SK2VV000-5	Vacuum test unit	-
SK2VV000-6	Vacuum leak indicator	-
SK2VV000-7	Digital vacuum gauge	70°C
SK2VV000-9	Vacuum level controller	-
SK2VV232-3	QRC Socket connector with female thread	232°C
SK2VV232-4	QRC plug with female thread	232°C
SK2VV232-5	Multi cartridge tree	232°C
SK2VV232-6	QRC blanking cap	232°C
SK2VV232-7	Vacuum bag valve	232°C
SK2VV232-8	Sockets with integral hosetail	232°C
SK2VV232-10	Repair tool kit	180°C
SK2VV232-91	Seals kit for socket SK2VV232-3	232°C
SK2VV232-92	Seals kit for blank cap SK2VV232-6	232°C
SK2VV232-93	Seals kit for bag valve SK2VV232-7	232°C
SK2VV232-94	Seals kit for plug SK2VV232-4	232°C
SK2VV232-95	Seals kit for multi cartridge tree SK2VV232-5	232°C

SK2VV260-3	QRC Socket connector with female thread	260°C
SK2VV260-4	QRC Plug with female thread	260°C
SK2VV260-7	Twist lock vacuum valve for high temperature processes	260°C
SK2VV260-8	High temperature self-cutting vacuum valve	260°C
SK2VV260-93	Seals kit for bag valve SK2VV260-7	260°C
SK2VV270-3	High temperature QRC socket female thread	270°C
SK2VV270-4	High temperature QRC plug	270°C
SK2VV270-5	High temperature multi cartridge tree 3x1	270°C
SK2VV270-6	High temperature QRC blanking cap	270°C
SK2VV270-7	Vacuum bag valve for high temperature process 270°C	270°C
SK2VV270-8	High temperature barb coupling fitting for vacuum hose	270°C
SK2VV270-13	Plug adaptor 1/4 inch male BSP O ring	270°C
SK2VV270-17	Adaptors for vacuum valves and quick connectors	270°C
SK2VV270-91	Seals kit for socket	270°C
SK2VV270-92	Seal kit for blanc cap	270°C
SK2VV270-93	Seals kit for bag valve	270°C
SK2VV270-94	Seals kit for plug	270°C
SK2VV270-95	Seals kit for multi cartridge tree	270°C
SK2VV400-3	Cartridge socket	400°C
SK2VV400-4	Cartridge plug	400°C

SK2VV400-7	Vacuum bag valve for high temperature process 400°C	400°C
VACUUM HOSES		
Name	**Description**	**Max. use T°C**
SK2VV60-1	Multi-Purpose Reinforced PVC Hose	-
SK2VV232-1	Standard vacuum hose with end fittings with male thread	232°C
SK2VV232-1HP	Vacuum hose for high temperature and high pressure	232°C
SK2VV232-1R	Reinforced vacuum hose for high temperature and high pressure process	232°C
SK2VV232-2	Standard vacuum hose assemblies	232°C
SK2VV232-12	Ferrule to secure the hose socket on the vacuum hose SK2VV232-1	232°C
SK2VV232-14	External spring for hose	232°C
SK2VV232-16	Swaging and Hose Assembly	-
SK2VV232-18	Standard vacuum hose in the roll	232°C
SK2VV260-1R	Reinforced vacuum hose for high temperature and high pressure process	260°C
SK2VV260-18R	Reinforced vacuum hose for high temperature and high pressure process in roll	260°C
SK2VV270-1	Vacuum hose for high temperature process	270°C
SK2VV270-1HP	Vacuum hose for high temperature and high pressure	270°C
SK2VV270-1R	Reinforced vacuum hose for high temperature and high pressure process	270°C
SK2VV270-2	High Temperature vacuum hose assemblies	270°C
SK2VV270-18	High temperature vacuum hose in the roll	270°C
SK2VV400-1	Vacuum hose for high temperature process 400°C	400°C

TECHNICAL DATA SHEET

SK2VV000-2

Vacuum gauge

Back to range

► DESCRIPTION

SK2VV000-2 is vacuum gauge to determine vacuum pressure under your vacuum bag. It is graduated in two units: scale outside (black) announces in BAR and scale inside (red), announces in PSI.

A blue rubber cap protects the gauge from damage by the using in the composite shop. The gauge stem is a 1/4 inch male BSP or male NTP thread fitting that fits easily into female Socket quick disconnect SK2VV232-3.

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

► TECHNICAL DATA

Screw thread:	1/4 inch male BSP or NTP
Assembly style:	Screwed
Size:	75mm
Protection:	Rubber cap
Range:	-1 bar till 0 bar
Graduations:	-0,02 bar
Accuracy:	+/-1,6 %
Use temperature range:	-40°C till +60°C

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

For vacuum test follow instruction:

1. Install one vacuum valve SK2VV232-7 in the opposite corner of installed vacuum hose, connected to the vacuum pump.
2. Screw gauge SK2VV000-2 into socket SK2VV232-3.
3. Put vacuum gauges with installed socket on the plug of vacuum valve SK2VV232-7 by using of quick disconnect system.
4. Wait till vacuum pump will sock out air from vacuum bag, and you will get stable vacuum.
5. Disconnect vacuum hose from vacuum bag.
6. The deviation of a manometer arrow informs about the leaks.

TECHNICAL DATA SHEET

SK2VV000-3

Liquid filled vacuum gauge

Back to range

► DESCRIPTION

SK2VV000-3 is a shock resistant, liquid (glycerin) filled vacuum gauge to determine vacuum pressure under your vacuum bag. It is graduated in two units: scale outside (black) announces in BAR and scale inside (red), announces in PSI.

A blue rubber cap protects the gauge from damage by the using in the composite shop. The gauge stem is a 1/4 inch male BSP or male NTP thread fitting that fits easily into female Socket quick disconnect SK2VV232-3 or SK2VV270-3.

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

► TECHNICAL DATA

Screw thread:	1/4 inch male BSP or NTP
Assembly style:	Screwed
Size:	75mm
Protection:	Rubber cap
Range:	-1 bar till 0 bar
Graduations:	-0,02 bar
Accuracy:	+/-1,6 %
Use temperature range:	-40°C till +60°C

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

For vacuum test follow instruction:

1. Install one vacuum valve SK2VV232-7 in the opposite corner of installed vacuum hose, connected to the vacuum pump.
2. Screw gauge SK2VV000-3 into socket SK2VV232-3 or SK2VV270-3.
3. Put vacuum gauges with installed socket on the plug of vacuum valve SK2VV232-7 by using of quick disconnect system.
4. Wait till vacuum pump will sock out air from vacuum bag, and you will get stable vacuum.
5. Disconnect vacuum hose from vacuum bag.
6. The deviation of a manometer arrow informs about the leaks.

TECHNICAL DATA SHEET

SK2VV000-5

Vacuum Test Unit

Back to range

► DESCRIPTION

SK2VV000-5 is a bench mounted multi-functional easy-to-use vacuum test unit for check of vacuum integrity of vacuum hoses, bagging valves, quick disconnect couplings as well as for pressure test of vacuum hoses. The Vacuum Test Unit SK2VV000-5 is ideally suited to test in-service equipment or to check equipment after maintenance like seal replacements on vacuum valves or end-fittings replacements on vacuum hoses.

This product allows saving time loading autoclaves with prechecked hoses, avoiding scrap and part rework due to vacuum loss from leaky hoses, reducing time spent for leak checking due to pretest of the vacuum valves.

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

► TECHNICAL DATA

Inlet:	Vacuum and Pressure
Controls:	Each line has ball valve control for Isolation
Read out:	Each line has 63 mm gauge Read out
Housing:	Powder coated steel casing

Reference	Connectors	Vacuum test unit version
SK2VV000-5	2 x quick disconnect plugs vacuum 1 x quick disconnect plugs pressure 1 x vacuum diaphragm 1 x vacuum gauge 1 x pressure gauge	single
SK2VV000-5DUAL	4 x quick disconnect plugs 2 x quick disconnect plugs pressure 2 x vacuum diaphragm 2 x vacuum gauges 1 x pressure gauge	dual

SK2VV000-5

► VACUUM LEAKEGES TEST

Vacuum hose test: attach both ends of hose equipped with a female quick disconnect to the plugs. Apply vacuum with an external source then isolate with valve corresponding to the used line. Vacuum drop on the corresponding gauge shows leakage in the vacuum hose.

Pressure hose test*: attach one end of the hose with a female quick disconnect to the plugs. Apply pressure through an external source then isolate with valve corresponding to the used line. Pressure drop on the corresponding gauge shows leakage in the vacuum hose.

* Note Inlet pressure is secondary reduced through an internal Test Unit regulator to 1.5 Bar (to prevent any damage to the vacuum hose).

Vacuum valve test: place vacuum valve onto seal diaphragm within base plate, apply vacuum with an external source then isolate with valve. Vacuum drop on the corresponding gauge shows leakage in the vacuum valve.

TECHNICAL DATA SHEET

SK2VV000-6

Vacuum leak indicator

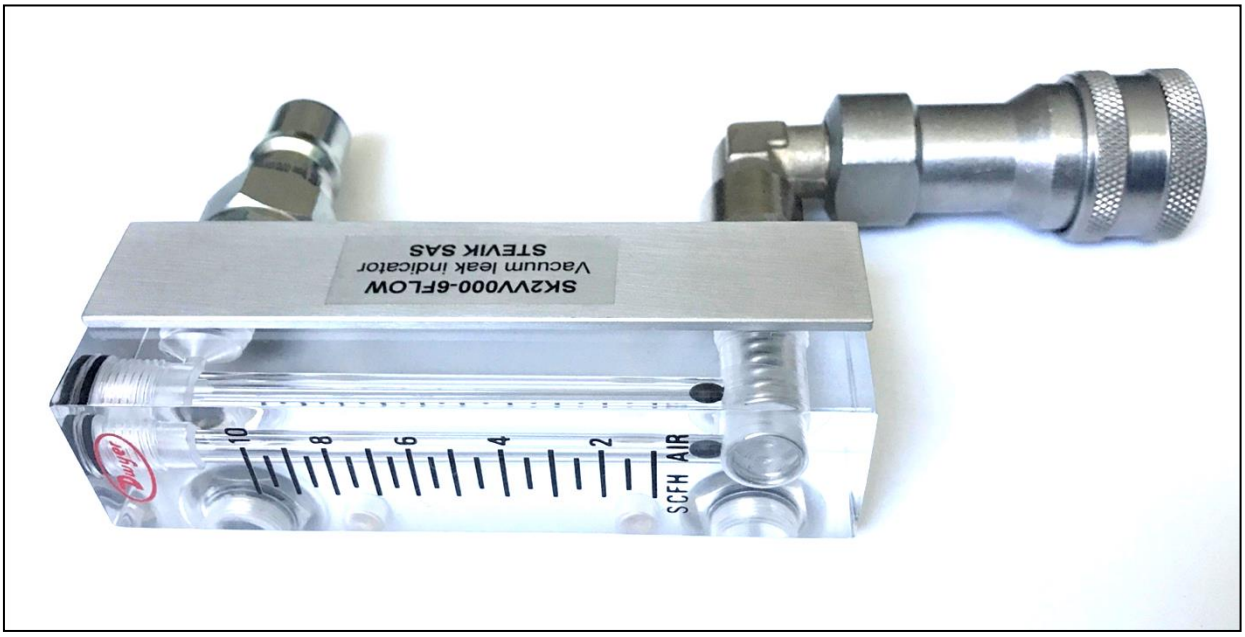
Back to range

► DESCRIPTION

SK2VV000-6 is compact indicator to be installed on the vacuum line for quick and easy detection within a vacuum bag, with the installed quick disconnection nipple and socket. Airflow through indicator cause the internal ball to oscillate and float inside acrylic body, displaying a definite airflow reading which can be read off against the scale. This device allows easy quantification of leak's size.

► TECHNICAL DATA

Construction:	Acrylic body with carbon steel connections (stainless steel at special request)
Range:	0 till 10 SCFH
Graduations:	0,5 SCFH



► VACUUM LEAKEGES TEST

1. Push socket of the SK2VV000-6 onto the through bag connector plug on tool (on your valve installed through bag).
2. Allow collar to retract fully ensuring a vacuum tight connection.
3. Connect vacuum source to plug of SK2VV000-6 and pull vacuum.
4. Any airflow will be indicated as internal ball floats and registers reading on scale.
5. Check bag for leaks until no airflow apparent.

TECHNICAL DATA SHEET

SK2VV000-7

Digital vacuum gauge

Back to range

► DESCRIPTION

SK2VV000-7 is a multipurpose digital vacuum gauge used for leak detection and vacuum determinations under your vacuum bag in standard and mobile applications. The gauge offers readings in different selectable units: bar, MPa, kPa, PSI and kg/cm².

Functions of gauge: Background lighting, on/off, zero point correction, units selection, display of battery level.

It is supplied with blue rubber cap, which protects the gauge from damage by the using in the composite shop. The gauge stem is a 1/4 inch male BSP or male NTP thread fitting that fits easily into female Socket quick disconnect SK2VV232-3.

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

► TECHNICAL DATA

Screw thread:	1/4 inch male BSP or NTP
Assembly style:	Screwed
Protection:	Rubber cap
Size w/o cap:	65mm
Weight w/o cap:	0,3 kg
Range:	-1 bar till 0 bar
Accuracy:	+/-1 %
Use temperature range:	-10°C till +70°C
Power:	2 x AAA
Battery life span:	12-24 months
Electric protection:	EN61326
Sampling frequency:	2 times / seconds

Bottom	Function	Description
Left bottom	On/Off	Long push = on/off
	Units selection	Short push = Units selection
Right bottom	Background lighting	Short push = background lighting is going on for 20 seconds
	0-point correction	5 sec push = 0-point correction

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

For vacuum test follow instruction:

1. Install one vacuum valve SK2VV232-7 in the opposite corner of installed vacuum hose, connected to the vacuum pump.
2. Screw gauge SK2VV000-7 into socket SK2VV232-3.
3. Put vacuum gauges with installed socket on the plug of vacuum valve SK2VV232-7 by using of quick disconnect system.
4. Wait till vacuum pump will sock out air from vacuum bag, and you will get stable vacuum.
5. Disconnect vacuum hose from vacuum bag.
6. The change of value at manometer informs about the leaks.

TECHNICAL DATA SHEET

SK2VV000-9

Vacuum level controller

Back to range

► DESCRIPTION

SK2VV000-9 is a small in-line vacuum level controller with integrated manometer and two male connections easy to use. It has been designed to provide accurate, controlled vacuum for manufacturing sensitive sandwich construction with honeycomb core. Controller is graduated in two units: scale outside (black) announces in BAR and scale inside (red), announces in PSI.
SK2VV000-9 can also be used as a means of regulating vacuum in the resin infusion application where full vacuum is not desirable with some resin systems such as polyesters.

A blue rubber cap protects the gauge from damage by the using in the composite shop. The controller stem is a 1/4 inch male NTP thread fitting that fits easily into female Socket quick disconnect SK2VV232-3.

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

► TECHNICAL DATA

Screw thread:	1/4 inch male NTP (or BSP)
Protection:	Rubber cap
Range:	-1 bar till 0 bar
Graduations:	-0,02 bar
Accuracy:	+/-1,6 %
Figure interval:	-0,2 bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► INSTRUCTION FOR USE

1. Attach quick disconnect couplings.
2. Connect vacuum hose.
3. Loosen locking ring and adjust thumb knob.
4. Tighten locking ring at the desired vacuum setting.
5. Attach coupling opposite the gauge to the vacuum bag.

TECHNICAL DATA SHEET

SK2VV232-3

QRC Socket Connector

Back to range

► DESCRIPTION

This Socket connector is for use in high temperature autoclaves and ovens, high temperature tooling and associated equipment. QRC Socket is female threaded connector. It is easily maintained by resealing without the need to be removed from the hose.

Socket has a threaded female fitting, designed in the way to receive vacuum hose SK2VV232-1 and applied with our plug SK2VV232-4 and vacuum bag valve SK2VV232-7. All coupling parts are manufactured from stainless steel and Manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Material type of O ring seals:	High temperature Viton 232°C
Coupling size:	1/4
Treaded size:	1/4 inch female BSP
Maximum use temperature:	232°C
Maximum autoclave pressure:	10 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

All end fittings are 100% vacuum tested after assembly.
Socket can be delivered with any tread style (for example NPT) on special order.
Recommended maintenance interval 1000hours based on operating temperatures up to 180°C when using with our connections.

SK2VV232-4

QRC Plug

Back to range

► DESCRIPTION

This plug is for use in high temperature autoclaves and ovens, high temperature tooling and associated equipment. From the vessel wall or tooling connection the standard plug or cartridge holder can be screwed or welded to form permanent connection to the vacuum line. The easy to remove cartridge plug is then connected into the holder. This can then be easily maintained by resealing or changed over to minimize downtime and maintenance.

All QRC connectors are internally valved to seal when disconnected so when the plug and socket are disconnected, the air flow is shut off in the both couplings. This allows your valves to retain vacuum after the vacuum source has been disconnected. Parts can now be moved from the bagging area to the curing area without loss of vacuum. A Blanking Cap can be fitted for further protection.

Plug has a threaded female fitting, designed in the way to receive vacuum hose SK2VV232-1 and applied with our Socket SK2VV232-3.

Quick disconnect plugs are fitted with high temperature seals and are fully resealable. All parts are manufactured from stainless steel and Manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Material type of O ring seals:	High temperature Viton 232°C
Coupling size:	1/4
Treaded size:	1/4 inch female BSP
Maximum use temperature:	232°C
Maximum autoclave pressure:	10 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

All end fittings are 100% vacuum tested after assembly.
Plug can be delivered with any tread style (for example NPT) on special order.
Recommended maintenance interval 1000hours based on operating temperatures up to 180°C when using with our connections.

SK2VV232-5

Multi cartridge tree

Back to range

► DESCRIPTION

The multi cartridge tree provides a multi-point connection for extra line capacity. A single threaded or QRC inlet can be adapted to either a threaded connection or used a quick disconnect, three outlet connectors provide extra capacity (any number of outlet connectors are available at special request).
Quick disconnect plugs are fitted with high temperature seals and are fully resealable. All parts are manufactured from stainless steel and Manufactured to ISO B.

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

► TECHNICAL DATA

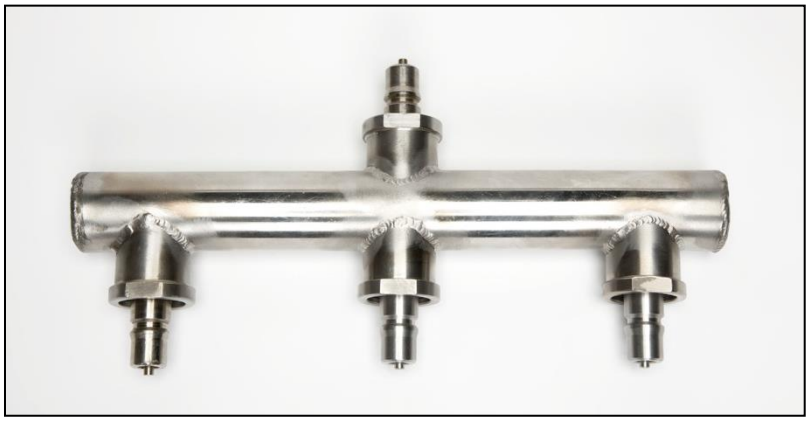
Material type:	Stainless steel
Material type of O ring seals:	High temperature Viton 232°C
Coupling size:	1/4
Treaded size:	1/4 inch female BSP
Maximum autoclave pressure:	10 Bar

Tree type	3 Connection	1 Inlet
SK2VV232-51/3QRCx1QRC	3 x QRC 1/4	QRC 1/4
SK2VV232-51/4QRCx1QRC	4 x QRC 1/4	QRC 1/4
SK2VV232-52/3QRCx1BSP1/4	3 x QRC 1/4	1/4 inch female BSP
SK2VV232-52/3QRCx1BSP1/4	2 x QRC 1/4	1/4 inch female BSP
SK2VV232-52/2QRCx1BSP1/4	8 x QRC 1/4	1/4 inch female BSP

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

SK2VV232-5

Multi cartridge tree



► NOTE

All end fittings are 100% vacuum tested after assembly.
Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV232-6

QRC blanking cap

Back to range

► DESCRIPTION

The Plug Blanking Cap safeguards autoclave, oven and ambient vacuum connectors by blocking potential leak paths through unused vacuum connections and protecting the valve from pressurization.

Autoclave pressure to vacuum line differential in excess of 3,5 bar will unseat spring loaded seals with quick disconnect plugs on the autoclave wall. This pressure ingress will reduce overall vacuum system performance, putting part quality at risk, it will also place a greater load on vacuum pumps reducing overall service life.
Blanking Caps can also be used with vac-valves to insure against vacuum loss through storage or valve tampering.

Quick disconnect blanking caps are fitted with high temperature seals and are fully resealable. All parts are manufactured from stainless steel and manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Material type of O ring seals:	High Temperature Viton 232°C
Coupling size:	1/4
Maximum use temperature:	232°C
Maximum autoclave pressure:	10 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

All end fittings are 100% vacuum tested after assembly.
Recommended maintenance interval 1000hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV232-7

Vacuum Valve

Back to range

► DESCRIPTION

The patented solid body design combines the function of the male quick disconnects and eliminates the threaded connection preventing leak paths. Robust stainless steel construction ensures corrosion resistance and long life. The SK2VV232-7 is fully compatible with all 1/4 ISO B style quick disconnect sockets.
Valves are fitted with high temperature seals and are fully resealable. All parts are manufactured from stainless steel and manufactured to ISO B.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	Stainless steel
Material type of O ring seals:	High temperature Viton 232°C
Maximum autoclave pressure:	10 Bar

► SIZE

Valve type	Base size	QRC Connection	Construction	Assembly style
SK2VV232-72	2 inch	1/4	3 pieces: body, pressure plate, locking ring	Solid body
SK2VV232-73	3 inch	1/4	3 pieces: body, pressure plate, locking ring	Solid body




► INSTRUCTION TO USE

- Cut a small opening in the vacuum bag and push the stem through the opening
- Insert the body under the vacuum bag.
- Apply the gasket and pressure plate on the outside of the vacuum bag
- Screw down the locking ring.

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

TECHNICAL DATA SHEET

SK2VV232-8

QRC Socket connectors with internal hosetail

Back to range

► DESCRIPTION

Couplings are for use in high temperature autoclaves and ovens, high temperature tooling and associated equipment. QRC Sockets are available as a straight connector with integral hosetail and 90 degree connector with integral hosetail. All connectors are easily maintained by resealing without the need to be removed from the hose.
Sockets with hosetails are manufactured from one piece (threadless). The thread-less system provides the highest vacuum performance, reliability and maximum flexibility when used in autoclaves and oven processes up to 232°C or 270°C. All coupling parts are manufactured from stainless steel and Manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Material type of O ring seals:	High temperature Viton
Maximum autoclave pressure:	10 Bar

► SIZE

Connector type	Coupling size	Treaded size	Max. using T°C
SK2VV232-8STR	1/4	3/8 Hose tail	232°C
SK2VV232-8C90	1/4	3/8 Hose tail	232°C
SK2VV270-8STR	1/4	3/8 Hose tail	270°C
SK2VV270-8C90	1/4	3/8 Hose tail	270°C

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

All end fittings are 100% vacuum tested after assembly. Recommended maintenance interval 1000hours based on operating temperatures up to 180°C when using with our connections.

SK2VV232-10

Tool Kit

Back to range

► DESCRIPTION

Each kit includes everything you need to reseal and maintain your couplings.

The tool kit contains:

Contain	For use with
O-Ring placement pick	Bag Valves, Sockets, blanking caps
O-Ring removal pick	Bag Valves, Sockets, blanking caps
T Bar	Sockets
Circlip pliers	Bag Valves, cartridges, plugs
Carry case	

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► **NOTE**

All end fittings are 100% vacuum tested after assembly.
Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

SK2VV232-91

Socket seals Kit

Back to range

► DESCRIPTION

All connectors in our range are fully resealable and seal kits are available as standard for all connectors. Each kit comes with necessary components for 10 sockets reseals.

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

► TECHNICAL DATA

Contain	Quantity in kit	Description	View
03-001160	10 pce	Socket srindle spring	
02-001050	20 pce	Socket body seal	
02-001060	10 pce	Socket top seal	
02-001040	10 pce	Socket cap seal	
02-001010	10 pce	Socket pin seal	

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV232-92

Blank cap seal kit

Back to range

► DESCRIPTION

All connectors in our range are fully resealable and seal kits are available as standard for all connectors. Each kit comes with necessary components for 10 blank caps reseals.

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

► TECHNICAL DATA

Contain	Quantity in kit	Description	View
02-001050	20 pce	Blanking cap body seal	
02-001060	10 pce	Blanking cap top seal	

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

SK2VV232-93

Bag valve seal kit

Back to range

► DESCRIPTION

All connectors in our range are fully resealable and seal kits are available as standard for all connectors. Each kit comes with necessary components for 10 vacuum bag valves reseals.

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

► TECHNICAL DATA

Contain	Quantity in kit	Description	View
03-001160	10 pce	Bag spindle spring	
02-001030	10 pce	Bag pin seal	
02-001100	10 pce	Bag int-cir-clip	
04-001010	10 pce	Bag red washer	

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

SK2VV232-94

Plug seal kit

Back to range

► DESCRIPTION

All connectors in our range are fully resealable and seal kits are available as standard for all connectors. Each kit comes with necessary components for 10 plugs reseals.

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

► TECHNICAL DATA

Contain	Quantity in kit	Description	View
03-001160	10 pce	Plug spindle spring	
02-001020	10 pce	Plug pin seal	
02-001070	10 pce	Plug base seal	
02-001100	10 pce	Plug int-cir-clip	

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

SK2VV232-95

Cartridge seal kit

Back to range

► DESCRIPTION

All connectors in our range are fully resealable and seal kits are available as standard for all connectors. Each kit comes with necessary components for 10 cartridge reseals.

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

► TECHNICAL DATA

Contain	Quantity in kit	Description	View
03-001160	10 pce	Cart spindle spring	
02-001100	10 pce	Cart int-cir-clip	
02-001030	10 pce	Cart pin seal	
02-001070	10 pce	Cart base seal	
02-001080	20 pce	Cart body seal	

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV260-3

QRC Socket Connector

Back to range

► DESCRIPTION

This QRC Socket connector is made of high-carbon steel specially treated to prevent oxidation. It is used in high temperature autoclaves and ovens, high temperature tooling and associated equipment. The socket is equipped with closing valve which guarantee vacuum tightness of vacuum bag after disconnection of vacuum hose. Parts can be moved from the bagging area to the curing area without loss of vacuum.

The socket has a threaded female fitting, designed to receive vacuum hose SK2VV270-1 and be used with our plugs SK2VV260-4, SK2VV270-4 and vacuum bag valves SK2VV260-7 and SK2VV270-7.

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

► TECHNICAL DATA

Material type:	Galvanised steel
Material type of O-ring seal:	Viton
Thread size:	1/4 inch female BSP
Maximum use temperature:	260°C

► NOTE

All connectors passed vacuum tightness test after assembly.
Socket can be delivered with any connection type (for example NPT) on special order.
Maximum working temperature depends on the process duration at the maximum temperature and process conditions. We strongly recommend you provide test before using.

TECHNICAL DATA SHEET

SK2VV260-4

QRC Plug

Back to range

► DESCRIPTION

This QRC Plug is made of high-carbon steel specially treated to prevent oxidation. It is used in high temperature autoclaves and ovens, high temperature tooling and associated equipment. The Plug is equipped with closing valve which guarantee vacuum tightness of vacuum bag after disconnection of vacuum hose. Parts can be moved from the bagging area to the curing area without loss of vacuum.

The Plug has a threaded female fitting, designed to receive vacuum hose SK2VV270-1 and be used with our QRC Socket Connectors SK2VV260-3, SK2VV270-3 and vacuum bag valves SK2VV260-7.

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

► TECHNICAL DATA

Material type:	Galvanised steel
Material type of O-ring seal:	Viton
Thread size:	1/4 inch female BSP
Maximum use temperature:	260°C

► NOTE

All connectors passed vacuum tightness test after assembly.
Plug can be delivered with any connection type (for example NPT) on special order.
Maximum working temperature depends on the process duration at the maximum temperature and process conditions. We strongly recommend you provide test before using.

TECHNICAL DATA SHEET

SK2VV260-7

Twist lock vacuum valve for high temperature processes

Back to range

► DESCRIPTION

Aluminium twist lock vacuum valve SK2VV260-7 is ideally suited for usage with our quick-release connections (QRC): QRC Plug SK2VV260-4 and QRC Socket Connector SK2VV260-3 in the ovens and autoclaves at the temperature up 260°C.

Valve is available in two different types: standard with red sealing ring and economy with black sealing ring.

This product is used in manufacturing processes of composite parts.

► TECHNICAL DATA

Material type:	Aluminium
Material type of O ring seals:	Silicon rubber
Maximum working temperature:	260°C
Design:	2 parts: base and upper part with sealing ring

Valve type	Base size	QRC Connection	Type
SK2VV260-7RD25BSP	2,5 inches	1/4 BSP	standard
SK2VV260-7RD25NPT	2,5 inches	1/4 NPT	standard
SK2VV260-7BK25BSP	2,5 inches	1/4 BSP	economy
SK2VV260-7BK25NPT	2,5 inches	1/4 NPT	economy

TECHNICAL DATA SHEET

SK2VV260-7

Twist lock vacuum valve for high temperature processes

► INSTRUCTION FOR USE

- Insert valve base under the vacuum bag.
- Cut a small hole in the vacuum bag
- Put upper part of the valve in the valve base through the hole in vacuum bag.
- Screw down upper part of the valve.

► NOTE

Maximum working temperature depends on the process duration at the maximum temperature and process conditions. We strongly recommend you provide test before using.

TECHNICAL DATA SHEET

SK2VV260-8

High temperature self-cutting vacuum valve

Back to range

► DESCRIPTION

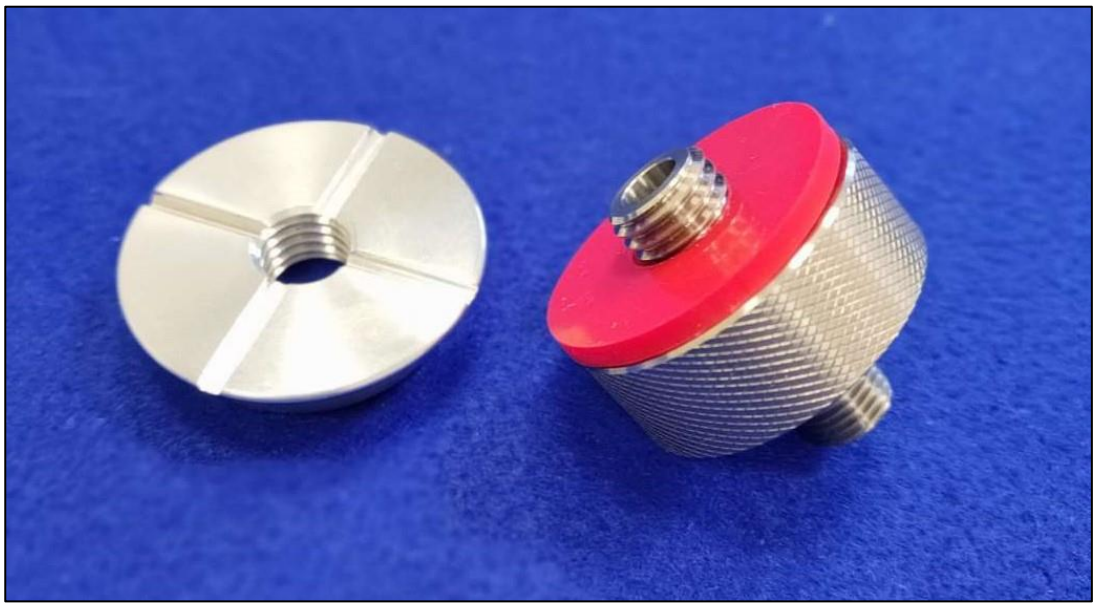
The machined vacuum valve SK2VV260-8 consists of two parts. The upper part cuts through the vacuum film while screwing it into the base. Using this type of connection eliminates the need to pre-cut the film.

The vacuum valves are ideally suited for using in combination with our quick connectors: QRC Socket connector SK2VV260-3 and QRC plug SK2V260-4 in ovens and autoclaves at temperatures up to 260°C. The vacuum valve is available in two sizes.

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

► TECHNICAL DATA

Material type of the upper part:	Stainless steel
Material type of the lower part (base):	Aluminium
Material type of the sealing gasket:	Silicone
Maximum use temperature:	260°C
Construction:	2 parts: base and upper part with the sealing ring



TECHNICAL DATA SHEET

SK2VV260-8

High temperature self-cutting vacuum valve

► SIZE

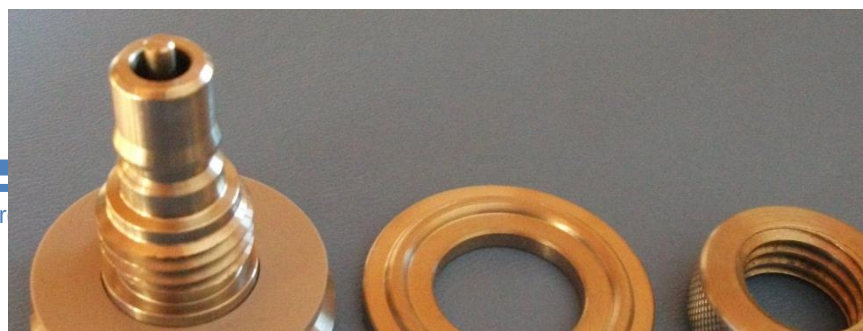
Valve type	Base size	External thread	Type of the valve
SK2VV260-8RD2BSP	2 inch	1/4 BSP	standard
SK2VV260-8RD3BSP	3 inch	1/4 BSP	standard

► INSTRUCTIONS TO INSTALL THE VALVE

Place the base of the valve under the vacuum bag.
Screw the upper part of the valve into the base.
Unscrew and remove pieces of the cut-out vacuum film.
Screw the upper part of the valve back into the base and tighten.

► NOTE

Maximum working temperature depends on the process duration at the maximum temperature and process conditions. We strongly recommend testing before use.



SK2VV260-93

Gaskets for valve

Back to range

► DESCRIPTION

Set of high temperature spare gaskets for our aluminium twist lock vacuum valves SK2VV260-7. Due to the aging of gaskets trough temperature, chemical evaporations and pressure influence, replacement is necessary for restoration of tightness of all systems of products.

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

► TECHNICAL DATA

Material type:	Silicone
Color:	Red
Outside diameter:	50mm
Inside diameter:	14,2mm
Thickness:	3mm
Maximum use temperature:	260°C

Reference to order	Color	Quantity in set, pce
SK2VV260-93	Red	10

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-3

QRC Socket Connector

Back to range

► DESCRIPTION

This Socket connector is for use in high temperature autoclaves and ovens, high temperature tooling and associated equipment. QRC Socket is female threaded connector. It is easily maintained by resealing without the need to be removed from the hose.
Socket has a threaded female fitting, designed in the way to receive vacuum hose SK2VV270-1 and applied with our plug SK2VV270-4 and vacuum bag valve SK2VV270-7.
All coupling parts are manufactured from stainless steel and Manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Material type of O ring seals:	High temperature Viton 270°C
Coupling size:	1/4
Treaded size:	1/4 inch female BSP
Maximum use temperature:	270°C
Maximum autoclave pressure:	10 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

All end fittings are 100% vacuum tested after assembly
Socket can be delivered with any tread style (for example NPT) on special order.
Recommended maintenance interval 1000hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-4

QRC Plug

Back to range

► DESCRIPTION

This plug is for use in high temperature autoclaves and ovens, high temperature tooling and associated equipment. From the vessel wall or tooling connection the standard plug or cartridge holder can be screwed or welded to form permanent connection to the vacuum line. The easy to remove cartridge plug is then connected into the holder. This can then be easily maintained by resealing or changed over to minimize downtime and maintenance.

All QRC connectors are internally valved to seal when disconnected so when the plug and socket are disconnected, the air flow is shut off in the both couplings. This allows your valves to retain vacuum after the vacuum source has been disconnected. Parts can now be moved from the bagging area to the curing area without loss of vacuum. A Blanking Cap can be fitted for further protection.

Plug has a threaded female fitting, designed in the way to receive vacuum hose SK2VV270-1 and applied with our Socket SK2VV270-3.

Quick disconnect plugs are fitted with high temperature seals and are fully resealable.
All parts are manufactured from stainless steel and Manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Material type of O ring seals:	High temperature Viton 270°C
Coupling size:	1/4
Treaded size:	1/4 inch female BSP
Maximum use temperature:	270°C
Maximum autoclave pressure:	10Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

All end fittings are 100% vacuum tested after assembly.
Plug can be delivered with any tread style (for example NPT) on special order.
Recommended maintenance interval 1000hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-5

Multi cartridge tree 3x1

Back to range

► DESCRIPTION

The multi cartridge tree provides a multi-point connection for extra line capacity. A single threaded or QRC inlet can be adapted to either a threaded connection or used a quick disconnect, three outlet connectors provide extra capacity (any number of outlet connectors are available at special request).

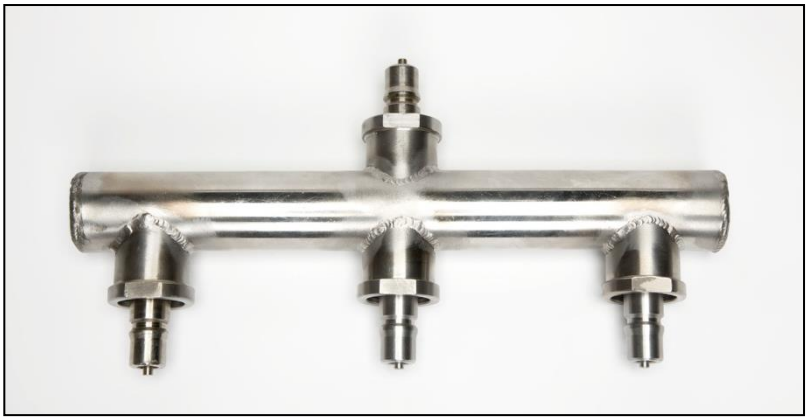
Quick disconnect plugs are fitted with high temperature seals and are fully resealable.
All parts are manufactured from stainless steel and Manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Material type of O ring seals:	High temperature Viton 270°C
Coupling size:	1/4
Treaded size:	1/4 inch female BSP
Maximum autoclave pressure:	10 Bar

Tree type	3 Connection	1 Inlet
SK2VV270-51	3 x QRC 1/4	QRC 1/4
SK2VV270-52	3 x QRC 1/4	1/4 inch female BSP



Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

All end fittings are 100% vacuum tested after assembly.
Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-6

QRC blanking cap

Back to range

► DESCRIPTION

The Plug Blanking Cap safeguards autoclave, oven and ambient vacuum connectors by blocking potential leak paths through unused vacuum connections and protecting the valve from pressurization.

Autoclave pressure to vacuum line differential in excess of 3,5 bar will unseat spring loaded seals with quick disconnect plugs on the autoclave wall. This pressure ingress will reduce overall vacuum system performance, putting part quality at risk, it will also place a greater load on vacuum pumps reducing overall service life.
Blanking Caps can also be used with vac-valves to insure against vacuum loss through storage or valve tampering.

Quick disconnect blanking caps are fitted with high temperature seals and are fully resealable. All parts are manufactured from stainless steel and manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Material type of O ring seals:	High temperature Viton 270°C
Coupling size:	1/4
Maximum using temperature:	270°C
Maximum autoclave pressure:	10 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

All end fittings are 100% vacuum tested after assembly.
Recommended maintenance interval 1000hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-7

Vacuum valve for high temperature process 270°C

Back to range

► DESCRIPTION

The patented solid body design combines the function of the male quick disconnects and eliminates the threaded connection preventing leak paths. Robust stainless steel construction ensures corrosion resistance and long life. The SK2VV270-7 is fully compatible with all 1/4 ISO B style quick disconnect sockets.
Valves are fitted with high temperature seals and are fully resealable. All parts are manufactured from stainless steel and manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Material type of O ring seals:	High temperature Viton 270°C
Maximum autoclave pressure:	10 Bar

► SIZE

Valve type	Base size	QRC Connection	Construction	Assembly style
SK2VV270-72	2 inch	1/4	3 pieces: body, pressure plate, locking ring	Solid body
SK2VV270-73	3 inch	1/4	3 pieces: body, pressure plate, locking ring	Solid body




► INSTRUCTION TO USE

- Insert the body under the vacuum bag.
- Cut a small opening in the vacuum bag and push the stem through the opening.
- Apply the gasket and pressure plate on the outside of the vacuum bag.
- Screw down the locking ring.

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

All end fittings are 100% vacuum tested after assembly.
Recommended maintenance interval 1000hours based on operating temperatures up to 180°C when using with our connections.

SK2VV270-8

Fitting for vacuum hose

Back to range

► DESCRIPTION

Barb coupling fitting with male screw end in 1/4 inches, connection size 3/8 inches for installation inside the hose and fixing internal spring.

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

► TECHNICAL DATA

Material type:	Brass
External diameter barbed side:	3/8 inch
End fittings:	1/4 inch male NTP or BSP
Maximum use temperature:	270°C

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-13

Adaptor

Back to range

► DESCRIPTION

This adaptor is for use in high temperature autoclaves and ovens, heating moulds and associated equipment. The adaptor can be easily maintained by resealing or changed over to minimize downtime during the maintenance.
All adaptors have high-temperature seals that can be replaced during operation. All parts are manufactured in accordance with ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Coupling size:	1/4 inch, male BSP
Treaded size:	1/4 inch, male BSP
Maximum use temperature:	270°C

Pic.: SK2VV270-13M14BSP/M14BSPO, with O ring seal made of Viton rubber

► NOTE

Different coupling sizes are possible: 1/2, 3/8 inches etc. as well as different treaded sizes: male, female, BSP, NPT.
All end fittings are 100% vacuum tested after assembly.
Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-17

Adaptor for vacuum valves

Back to range

► DESCRIPTION

Adaptors for vacuum valves and quick connectors for autoclave and oven applications. This kind of adaptors are used for changing of the carving type and size.

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

► TECHNICAL DATA

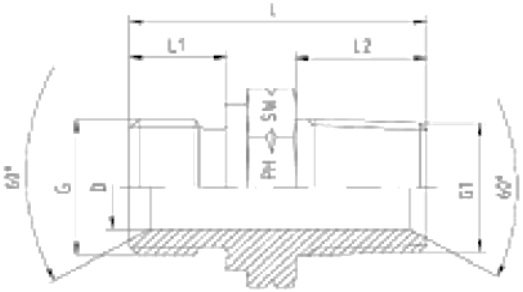
Material type:	Stainless steel
End Fittings:	Male/Male and Male/Female
Maximum use temperature:	270°C

► SIZE

BSP - Parallel – NPT

BSP – Male with 60°-Cone and sealing shoulder form B.

NPT – Male with 60°-Cone.



SK2VV270-17

Adaptor for vacuum valves

PRESSURE	THREAD		APPROX. DIMENSIONS				
PN	G=BSP	G1=NPT	L	L1	L2	D	SW

Series A

400	1/8"-28	1/8"-27	24,5	8	10,0	4,0	14
400	1/4"-19	1/4"-18	32,5	10	15,0	6,0	19
400	3/8"-19	3/8"-18	38,0	12	15,3	9,0	22
400	1/2"-14	1/2"-14	43,0	14	20,0	12,5	27
400	3/4"-14	3/4"-14	47,0	16	20,0	17,5	32
400	1"-11	1"-11,5	54,5	18	25,0	22,5	41
200	1 1/4"-11	1 1/4"-11,5	66,0	20	25,5	30,0	50
200	1 1/2"-11	1 1/2"-11,5	64,0	22	26,0	37,0	55
100	2"-11	2"-11,5	66,0	25	26,0	45,0	70

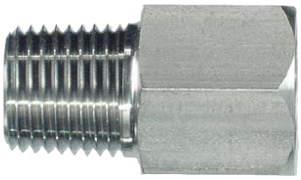
Series B

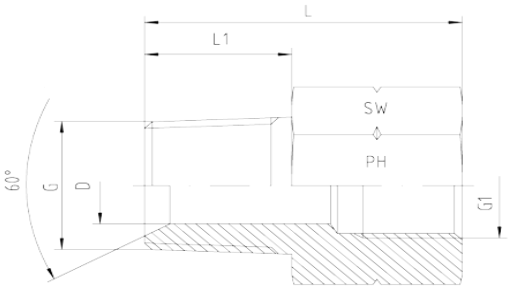
400	1/8"-28	1/4"-18	30,0	8	15,0	4,0	14
400	1/4"-19	1/8"-27	27,5	10	10,0	4,0	19
400	1/4"-19	3/8"-18	33,0	10	15,3	6,0	19
400	1/4"-19	1/2"-14	40,0	10	20,0	6,0	22
400	3/8"-19	1/4"-18	35,5	12	15,0	7,0	22
400	3/8"-19	1/2"-14	42,0	12	20,0	9,0	22
400	3/8"-19	3/4"-14	42,0	12	20,0	9,0	27
400	1/2"-14	1/4"-18	40,0	14	15,0	7,0	27
400	1/2"-14	3/8"-18	40,0	14	15,3	9,0	27
400	1/2"-14	3/4"-14	45,0	14	20,0	12,0	27
400	3/4"-14	1/2"-14	45,0	16	20,0	12,5	32

400	3/4"-14	1"-11,5	52,0	16	25,0	17,5	36
400	1"-11	3/8"-18	45,0	18	15,3	9,0	41
400	1"-11	1/2"-14	50,0	18	20,0	12,5	41
400	1"-11	3/4"-14	50,0	18	20,0	15,0	41

NPT - Male - NPT - Female - Form B

NPT – Male with 60°-Cone
NPT - Female





PRESSURE	THREAD		APPROX. DIMENSIONS				FORM
PN	G=NPT	G1=NPT	L	L1	D	SW	
630	1/8"-27	1/8"-27	25,0	10,0	4,0	14	B
630	1/8"-27	1/4"-18	31,0	10,0	4,0	19	B
630	1/4"-18	1/8"-27	30,0	15,0	6,0	14	B
630	1/4"-18	1/4"-18	36,0	15,0	6,0	19	B
630	1/4"-18	3/8"-18	37,0	15,0	6,0	24	B
630	1/4"-18	1/2"-14	42,0	15,0	6,0	27	B
630	3/8"-18	1/4"-18	36,0	15,0	9,0	19	B
630	3/8"-18	3/8"-18	37,0	15,0	9,0	24	B
630	3/8"-18	1/2"-14	41,0	15,0	9,0	27	B
630	1/2"-14	3/8"-18	39,5	20,0	12,0	24	B
630	1/2"-14	1/2"-14	46,0	20,0	12,0	27	B

630	1/2"-14	3/4"-14	48,0	20,0	12,0	36	B
630	3/4"-14	1/2"-14	42,0	20,0	15,0	27	B
630	3/4"-14	3/4"-14	48,0	20,0	18,0	36	B
400	3/4"-14	1"-11,5	50,0	20,0	18,0	36	B
400	1"-11,5	3/4"-14	34,0	25,0	22,6	36	B
400	1"-11,5	1"-11,5	57,0	25,0	21,0	41	B
400	1"-11,5	1 1/4"-11,5	57,0	25,0	21,0	50	B
400	1 1/4"-11,5	1"-11,5	54,0	25,5	28,5	46	B
400	1 1/4"-11,5	1 1/4"-11,5	55,0	25,5	30,0	50	B
400	1 1/4"-11,5	1 1/2"-11,5	62,5	25,5	30,0	55	B
400	1 1/2"-11,5	1 1/4"-11,5	55,0	26,0	36,0	50	B
400	1 1/2"-11,5	1 1/2"-11,5	63,0	26,0	36,0	55	B
315	1 1/2"-11,5	2"-11,5	64,0	26,0	36,0	70	B

Shelf life: not limited
Storage conditions: it is recommended to store at temperatures between -20°C and +30°C in original packing.

TECHNICAL DATA SHEET

SK2VV270-91

Socket seals Kit

Back to range

► DESCRIPTION

All connectors in our range are fully resealable and seal kits are available as standard for all connectors. Each kit comes with necessary components for 10 sockets reseals.
The maximum use temperature for SK2VV270-91 connectors is 270°C.

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

► TECHNICAL DATA

Contain	Quantity in kit	Description	View
03-001160	10 pce	Socket srindle spring	
02-001050	20 pce	Socket body seal	
02-001060	10 pce	Socket top seal	
02-001040	10 pce	Socket cap seal	
02-001010	10 pce	Socket pin seal	

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

SK2VV270-92

Blank cap seal kit

Back to range

► DESCRIPTION

All connectors in our range are fully resealable and seal kits are available as standard for all connectors. Each kit comes with necessary components for 10 blank caps reseals.
The maximum use temperature for SK2VV270-92 connectors is 270°C.

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

► TECHNICAL DATA

Contain	Quantity in kit	Description	View
02-001050	20 pce	Blanking cap body seal	
02-001060	10 pce	Blanking cap top seal	

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

SK2VV270-93

Bag valve seal kit

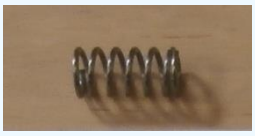
Back to range

► DESCRIPTION

All connectors in our range are fully resealable and seal kits are available as standard for all connectors. Each kit comes with necessary components for 10 vacuum bag valves reseals. The maximum use temperature for SK2VV270-93 connectors is 270°C.

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

► TECHNICAL DATA

Contain	Quantity in kit	Description	View
03-001160	10 pce	Bag spindle spring	
02-001030	10 pce	Bag pin seal	
02-001100	10 pce	Bag int-cir-clip	
04-001010	10 pce	Bag red washer	

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-94

Plug seal kit

Back to range

► DESCRIPTION

All connectors in our range are fully resealable and seal kits are available as standard for all connectors. Each kit comes with necessary components for 10 plugs reseals.
The maximum use temperature for SK2VV270-94 connectors is 270°C.

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

► TECHNICAL DATA

Contain	Quantity in kit	Description	View
03-001160	10 pce	Plug spindle spring	
02-001020	10 pce	Plug pin seal	
02-001070	10 pce	Plug base seal	
02-001100	10 pce	Plug int-cir-clip	

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-95

Cartridge seal kit

Back to range

► DESCRIPTION

All connectors in our range are fully resealable and seal kits are available as standard for all connectors. Each kit comes with necessary components for 10 cartridge reseals.
The maximum use temperature for SK2VV270-95 connectors is 270°C.

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

► TECHNICAL DATA

Contain	Quantity in kit	Description	View
03-001160	10 pce	Cart spindle spring	
02-001100	10 pce	Cart int-cir-clip	
02-001030	10 pce	Cart pin seal	
02-001070	10 pce	Cart base seal	
02-001080	20 pce	Cart body seal	

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

Recommended maintenance interval 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV400-3

Cartridge Socket

Back to range

► DESCRIPTION

SK2VV400-3 is a super high temperature cartridge socket which is used in high temperature autoclaves and ovens, high temperature tooling and associated equipment at working temperature of 400°C. It has a threaded female fitting and should be installed with high temperature sealant or welded to the vessel wall. It is applied with our plug SK2VV400-4 and vacuum bag valve SK2VV400-7.

All coupling parts are manufactured from stainless steel and Manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Coupling size:	1/4
Treaded size:	1/4 inch female BSP
Maximum use temperature:	400°C

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

All end fittings are 100% vacuum tested after assembly.

TECHNICAL DATA SHEET

SK2VV400-4

Cartridge Plug

Back to range

► DESCRIPTION

SK2VV400-4 is a super high temperature cartridge plug for using in high temperature autoclaves and ovens, high temperature tooling and associated equipment at working temperature of 400°C. It has male threaded fitting designed in the way to receive vacuum hose SK2VV400-1 and applied with our socket SK2VV400-3. SK2VV400-4 is screwed in and seals on a special taper system.

All parts are manufactured from stainless steel and Manufactured to ISO B.

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

► TECHNICAL DATA

Material type:	Stainless steel
Coupling size:	1/4
Treaded size:	1/4 inch male BSP
Maximum use temperature:	400°C

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

All end fittings are 100% vacuum tested after assembly.

TECHNICAL DATA SHEET

SK2VV400-7

Vacuum valve for high temperature process 400°C

Back to range

► DESCRIPTION

SK2VV400-7 is a super high temperature vacuum valve that is designed for processes having the working temperature of 400°C. Robust stainless steel construction ensures corrosion resistance and long life. The SK2VV400-7 is connected with the super high temperature hose SK2VV400-1 through 1/4" BSP male thread. The valve seals to the mould tool with a super high temperature flat seal and secured with a clamping washer and locking nut.

All parts are manufactured from stainless steel and manufactured to ISO B.

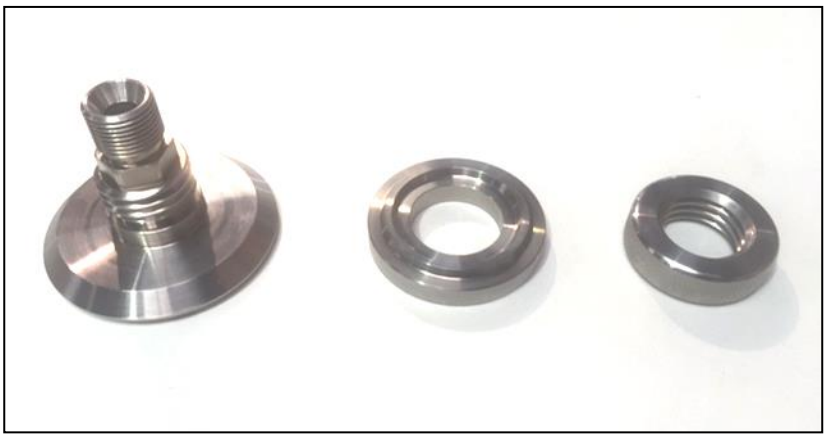
This product is used in various manufacturing processes of parts made of composite.

► TECHNICAL DATA

Material type:	316 stainless steel
Coupling size:	1/4
Treaded size:	1/4 inch male BSP
Working temperature:	400°C

► SIZE

Valve type	Base size	Connection	Construction	Assembly style
SK2VV400-72	2 inch	1/4	3 pieces: body, pressure plate, locking ring	Solid body
SK2VV400-73	3 inch	1/4	3 pieces: body, pressure plate, locking ring	Solid body



► INSTRUCTION TO USE

- Insert the body under the vacuum bag.
- Cut a small opening in the vacuum bag and push the stem through the opening.
- Apply pressure plate on the outside of the vacuum bag.
- Screw down the locking ring**.**

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

All end fittings are 100% vacuum tested after assembly.

TECHNICAL DATA SHEET

SK2VV60-1

Multi-Purpose reinforced PVC Hose

Back to range

► DESCRIPTION

SK2VV60-1 is a high quality, lightweight exceptionally flexible PVC hose from superior quality materials, supplied with end fittings with male thread 1/4 inch BSP. Its ergonomic design reduces operator fatigue and associated strains, helping to improve overall productivity without compromising on performance and durability.

►Advantages

- Extremely flexible
- Lightweight and user-friendly
- Excellent kink-resistance
- roHS compliant
- High resistance to acids and alkalis
- Good abrasion resistance.
- Silicone-free
- 4:1 safety factor at +20°C
- Service temperature -15°C to +60°C
- Conforms to ISO 5774

► Application

- Busy, high volume production lines
- Predominantly used for air supply
- Air applications such as pneumatic tools

► TECHNICAL DATA

Product	Value	Unit
Nominal size	6.0 x 10.5	mm
Internal diameter	6.3 ± 0.25	mm
External diameter	10.5 ± 0.30	mm
Length tolerance (BS En ISO 1307)	± 1	%
Maximum working pressure	18	Bar
Minimum Burst Pressure	72	Bar
Bend radius	28	mm
Working Temperature	- 15 to + 60	°C

SK2VV60-1

Multi-Purpose reinforced PVC Hose

Material	Flexible PVC	
Material softness	BSS45 / BSS60 FDa approved	
Flammability	Self-Extinguishing	
Weight per meter	0.074	Kg
Coil weight	2.23	Kg
Packaging	Strapped Ties and Shrink-wrap	
applicable Standards	BS En ISO 5774 (Plastic hoses. textile-reinforced types for compressed-air applications.) & BS En ISO 6224 (thermoplastics hoses, textile reinforced, for general-purpose water applications)	

► NOTE

Other colors and sizes available against minimum order quantity.
The length of the hose has to be chosen by 0,5m step. The maximum manufactured length is 30 meters.
Other types of male thread end fittings are available on request (e.g. NTP).

TECHNICAL DATA SHEET

SK2VV232-1

Standard vacuum hose

Back to range

► DESCRIPTION

This vacuum hose is a platinum cured silicone hose manufactured to the highest standard which has been developed specially for high temperature applications in autoclaves and ovens, rated to a temperature of 232°C. The internal steel spring prevents collapse under vacuum and pressure and prevents hose separation from the couplings. The external support spring prevents hose lacerations at the fitting ends, extending the hose life.

The hose is extremely durable and long lasting, very flexible and user friendly.
The hose has NO silicone loss meaning no contamination worries.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Hose color:	Green (Available in Black at special request)
Internal hose diameter:	3/8 inch
Outer hose diameter:	18mm
End fittings:	1/4 inch male BSP
Maximum use temperature:	232°C
Recommended autoclave pressure:	10 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

For pressure over 10 Bar we recommend hoses Version HP.
The length of the hose has to be chosen by 0,5m step. The maximum manufactured length is 25 meters.

Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV232-1HP

Vacuum hose for high temperature and high pressure process

Back to range

► DESCRIPTION

This vacuum hose is a platinum cured silicone hose manufactured to the highest standard which has been developed specially for high pressure till 20 Bar and high temperature applications in autoclaves, rated to a temperature of 232°C. The internal steel spring prevents collapse under vacuum and pressure and prevents hose separation from the couplings. The external support spring prevents hose lacerations at the fitting ends, extending the hose life.

The hose is extremely durable and long lasting, very flexible and user friendly.
The hose has NO silicone loss meaning no contamination worries.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Hose color:	Green or red
Internal hose diameter:	3/8 inch
Outer hose diameter:	19 mm
End fittings:	1/4 inch male BSP or NPT (on request)
Maximum use temperature:	232°C
Maximum autoclave pressure:	20 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

The length of the hose has to be chosen by 0,5m step.
The maximum manufactured length is 25 meters.
Maximum use pressure and temperature should be determined under your actual process conditions.
Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV232-1R

Reinforced vacuum hose for high temperature and high pressure process

Back to range

► DESCRIPTION

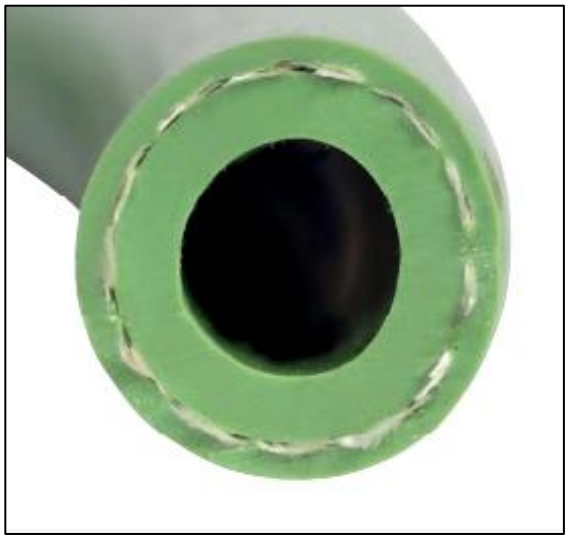
This vacuum hose is a platinum cured reinforced silicone hose manufactured to the highest standard which has been developed specially for high temperature applications in autoclaves and ovens, rated to a temperature of 232°C. The internal steel spring prevents collapse under vacuum and pressure and prevents hose separation from the couplings. The external support spring prevents hose lacerations at the fitting ends, extending the hose life.

The hose is extremely durable and long lasting, very flexible and user friendly.
The hose has NO silicone loss meaning no contamination worries.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Reinforcement type:	Glass fiber or aramid reinforcement
Hose color:	Green
Internal hose diameter:	3/8 inch
Outer hose diameter:	18 mm
End fittings:	1/4 inch male BSP or NPT (on request)
Maximum use temperature:	232°C



SK2VV232-1R

Reinforced vacuum hose for high temperature and high pressure process

Hose type	Reinforcement type	Working temperature	Burst pressure	Max. recommend work pressure
SK2VV232-1RA	Aramid fiber	232°C	> 80 bar	> 25 bar
SK2VV232-1RG	Glass fiber	232°C	35 bar	> 25 bar

The glass fiber reinforced hose SK2VV232-1RG is a tough, durable hose ideal for industrial high temperature environments.

The aramid fiber reinforced hose SK2VV232-1RA provides maximum durability, robustness and high tear resistance. Designed for demanding high temperature aerospace environments.

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

The length of the hose has to be chosen by 0,5m step.
The maximum manufactured length is 25 meters.
Maximum use pressure and temperature should be determined under your actual process conditions.
Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV232-2

Standard vacuum hose assemblies

Back to range

► DESCRIPTION

This vacuum hose assembly is made from platinum cured silicone hose manufactured to the highest standard (gives off no free silicone particles) and is fitted with stainless steel one-piece couplings. This thread-less system provides the highest vacuum performance, reliability and maximum flexibility when used in autoclaves and oven processes up to 232°C. Assemblies are fitted with internal and external support springs. Couplings are fully resealable, without removal from the hose. All couplings are manufactured to ISO B.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Material type of socket:	Stainless steel
Hose color:	Green (Available in Black at special request)
Maximum use temperature:	232°C
Recommended autoclave pressure:	10 Bar

► SIZE

Hose type	Socket type	QRC Connection	Hose i.d.	Hose o.d.	Length
SK2VV232-2STR/STR	Straight socket	1/4	3/8	18 mm	1,0m till 25,0m
SK2VV232-2STR/C90	Elbow socket	1/4	3/8	18 mm	1,0m till 25,0m

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

For pressure over 10Bar we recommend hoses Version HP.
The end fittings are 100% vacuum tested after assembly. The length of the hose has to be chosen by 0,5m step. Recommended maintenance interval: 1000hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV232-12

Ferrule

Back to range

► DESCRIPTION

A lightweight ferrule to secure the hose coupling for SK2VV232-1.

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

► TECHNICAL DATA

Material type:	Stainless steel
Material type for O-ring seal:	Viton rubber
Connection size:	1/4 inch
End fittings:	1/4 inch, female screw thread BSP
Maximum use temperature:	232°C
Maximum pressure in autoclave:	10 bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV232-14

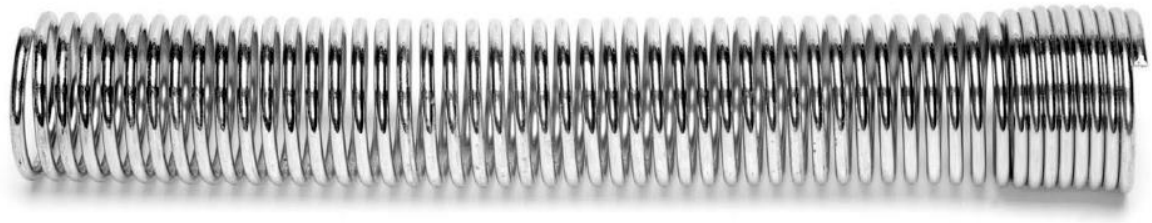
External spring

Back to range

► DESCRIPTION

The external spring provides support to the swaged area and prevents kinking. Simply pull over the ferrule after swaging.

The product is used in different processes of manufacturing and repair of parts from polymer composite materials.



► TECHNICAL DATA

Color:	Silver
Maximum use temperature:	232°C

► SIZE

Reference for order	Hose external diameter
SK2VV232-14	3/8
SK2VV232-14A	1/2

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► NOTE

Recommended maintenance interval 1000 hours based on operating temperatures 180C° when used with our connections.

TECHNICAL DATA SHEET

SK2VV232-16

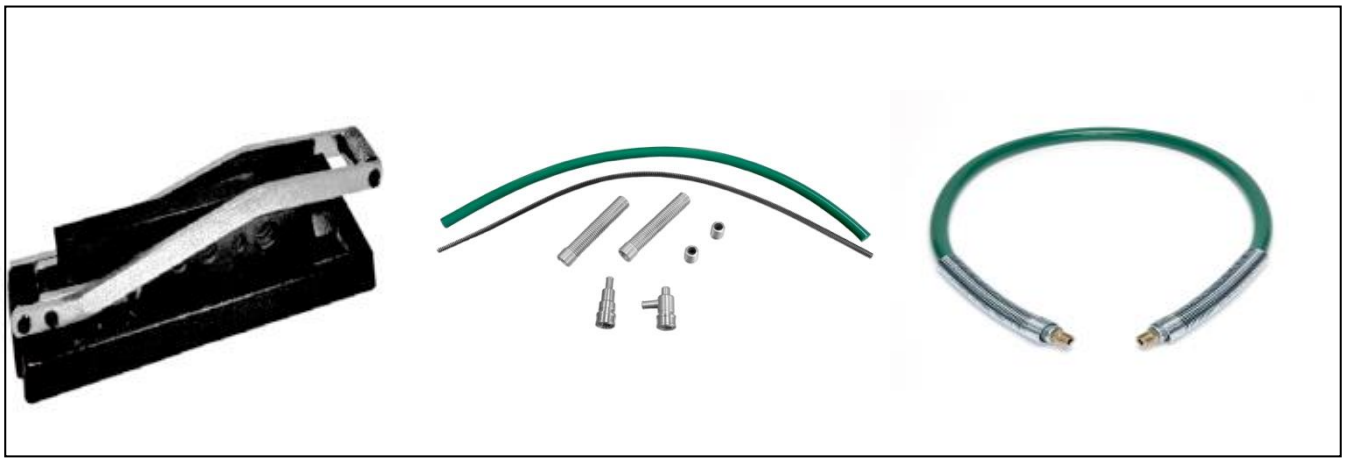
Swaging and Hose Assembly

Back to range

► DESCRIPTION

The Swaging machine allows hose crimping to be done on hose assemblies with either 3/8” or 1/2” hose. The unit is suitable for new assemblies and for hose repairs.
The swaging machine is compact, lightweight and easy to use.

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



► HOSE ASSEMBLY

Before operating the hose crimping machine, close the crimper and adjust the screw opposite the end where the handle attaches until the screw just touches the end stop. Never turn the screw tighter than this. The screw should be looser if the hose barb fits very tightly and the ferrule is close-fitting.

- Cut the hose to the final hose length desired
- Cut the stainless steel spiral 5 cm longer than the hose
- Place ferrule on the hose
- Screw the barbed fitting on the stainless steel spiral and insert the barb inside the hose
- Open the hose crimping machine by raising handle
- Place hose into the crimping machine, centering the ferrule on the appropriate die
- Press down on handle until it hits the end stop. Lift up and rotate hose 90 °
- Once crimped the coupling will be difficult to rotate by hand

For making new standard hose you will need 4 items:

Reference	Description	Unit	Quantity for one hose
SK2VV232-11	Brass hosetail, thread NPTM 1/4", hose i.d. 3/8"	pcs	2 pcs
SK2VV232-12	A light weight ferrule to secure a house coupling	pcs	2 pcs
SK2VV232-14	External spring, provides support to the swaged area and prevents kinking, silver	pcs	2 pcs
SK2VV232-18	Silicon hose with integrated reinforcing internal spring inside, T=232°C	linear meter	(consumption depending on desired hose length)

For making new full assemblies hose you will need 4 items:

Reference	Description	Unit	Quantity for one hose
SK2VV232-8	SK2VV232-8STR - QRC straight socket connector, coupling size: 1/4 inch, core size: 3/8 inch or SK2VV232-8C90 - QRC elbow (90°) socket connector, coupling size: 1/4 inch, core size: 3/8 inch	pcs	2 pcs
SK2VV232-12	A light weight ferrule to secure a house coupling	pcs	2 pcs
SK2VV232-14	External spring, provides support to the swaged area and prevents kinking, silver	pcs	2 pcs
SK2VV232-18	Silicon hose with integrated reinforcing internal spring inside, T=232°C	linear meter	(consumption depending on desired hose length)

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

► **NOTE**

Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV232-18

Standard vacuum hose in the roll

Back to range

► DESCRIPTION

This vacuum hose is a platinum cured silicone hose manufactured to the highest standard which has been developed specially for high temperature applications in autoclaves and ovens, rated to a temperature of 232°C. The internal steel spring prevents collapse under vacuum and pressure.

The hose is extremely durable and long lasting, very flexible and user friendly.
The hose has NO silicone loss meaning no contamination worries.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Hose color:	Green
Length of the roll:	25m
Internal hose diameter:	3/8 inch
Outer hose diameter:	3/4 inch
Maximum use temperature:	232°C
Maximum autoclave pressure:	10 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV260-1R

Reinforced vacuum hose for high temperature and high pressure process

Back to range

► DESCRIPTION

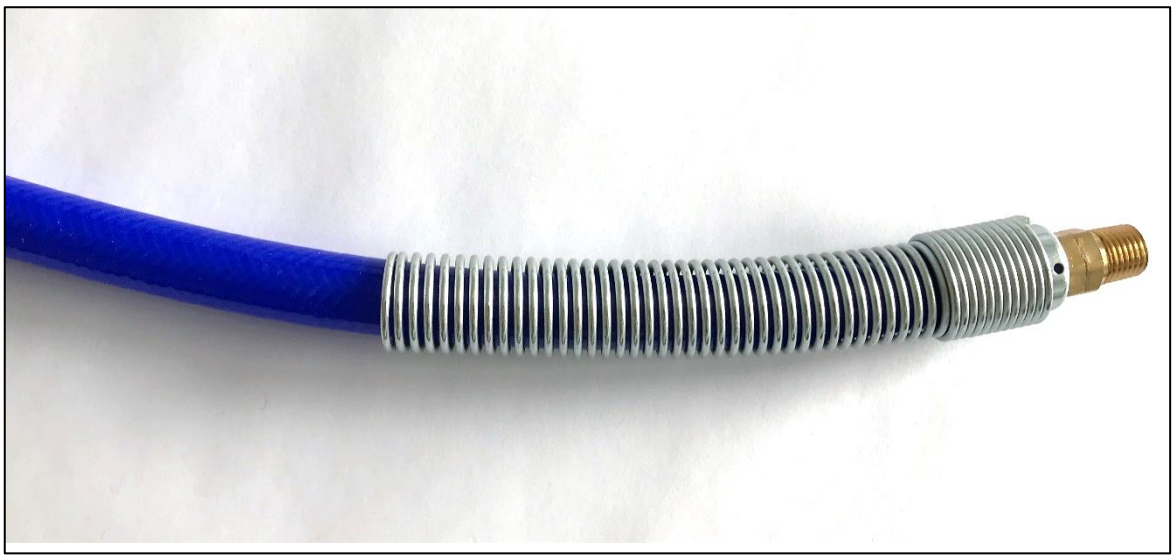
The SK2VV260-1R is long lifecycle glass fiber reinforced silicone vacuum hose, tested to the highest standards and specially developed for high pressure and high temperature applications up to 260 C in autoclaves. The internal steel spring prevents collapse under vacuum and pressure and prevents hose separation from the couplings. The external support spring prevents hose lacerations at the fitting ends, extending the hose life.

The hose is extremely durable and long lasting, very flexible and user friendly.
The hose has NO silicone loss meaning no contamination worries.

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

► TECHNICAL DATA

Material type of hose:	Silicone reinforced with glass fibre
Material type of inner conduits:	Steel spring
Hose color:	Blue
Internal hose diameter:	9,5 mm
Outer hose diameter:	18 mm
End fittings:	1/4 inch male BSP or NPT (on request)
Maximum use temperature:	260°C
Max. recommend work pressure:	22 Bar



Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

The length of the hose has to be chosen by 0,5m step.
The maximum manufactured length is 25 meters.
Maximum use pressure and temperature should be determined under your actual process conditions.
Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV260-18R

Reinforced vacuum hose in roll for high temperature and high pressure process

Back to range

► DESCRIPTION

The SK2VV260-18R is long lifecycle glass fiber reinforced silicone vacuum hose in roll, tested to the highest standards and specially developed for high pressure and high temperature applications up to 260°C in autoclaves. The internal steel spring prevents collapse under vacuum and pressure and prevents hose separation from the couplings. The external support spring prevents hose lacerations at the fitting ends, extending the hose life.

The hose is extremely durable and long lasting, very flexible and user friendly.
The hose has NO silicone loss meaning no contamination worries.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Reinforcement:	Glass fiber
Hose color:	Blue
Internal hose diameter:	9,5 mm
Outer hose diameter:	18 mm
Length of the roll:	25 m
Maximum use temperature:	260°C
Max. recommend work pressure:	22 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Maximum use pressure and temperature should be determined under your actual process conditions.

Recommended maintenance interval: 1000 hours based on operating temperatures up to 260°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-1

Vacuum hose for high temperature process 270°C

Back to range

► DESCRIPTION

This vacuum hose is a platinum cured silicone hose manufactured to the highest standard which has been developed specially for high temperature applications in autoclaves and ovens, rated to a temperature of 270°C. The internal steel spring prevents collapse under vacuum and pressure and prevents hose separation from the couplings. The external support spring prevents hose lacerations at the fitting ends, extending the hose life.

The hose is extremely durable and long lasting, very flexible and user friendly.
The hose has NO silicone loss meaning no contamination worries.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Hose color:	Red
Internal hose diameter:	3/8 inch
Outer hose diameter:	18mm
End fittings:	1/4 inch male BSP
Maximum use temperature:	270°C
Recommended autoclave pressure:	10 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

For pressure over 10Bar we recommend hoses Version HP.
The length of the hose has to be chosen by 0,5m step. The maximum manufactured length is 25 meters.
Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-1HP

Vacuum hose for high temperature and high pressure process

Back to range

► DESCRIPTION

This vacuum hose is a platinum cured silicone hose manufactured to the highest standard which has been developed specially for high pressure till 20 Bar and high temperature applications in autoclaves, rated to a temperature of 270°C. The internal steel spring prevents collapse under vacuum and pressure and prevents hose separation from the couplings. The external support spring prevents hose lacerations at the fitting ends, extending the hose life.

The hose is extremely durable and long lasting, very flexible and user friendly.
The hose has NO silicone loss meaning no contamination worries.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Hose color:	Red
Internal hose diameter:	3/8 inch
Outer hose diameter:	19mm
End fittings:	1/4 inch male BSP or NPT (on request)
Maximum use temperature:	270°C
Maximum autoclave pressure:	20 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

The length of the hose has to be chosen by 0,5m step. The maximum manufactured length is 25 meters.
Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-1R

Reinforced vacuum hose for high temperature and high pressure process

Back to range

► DESCRIPTION

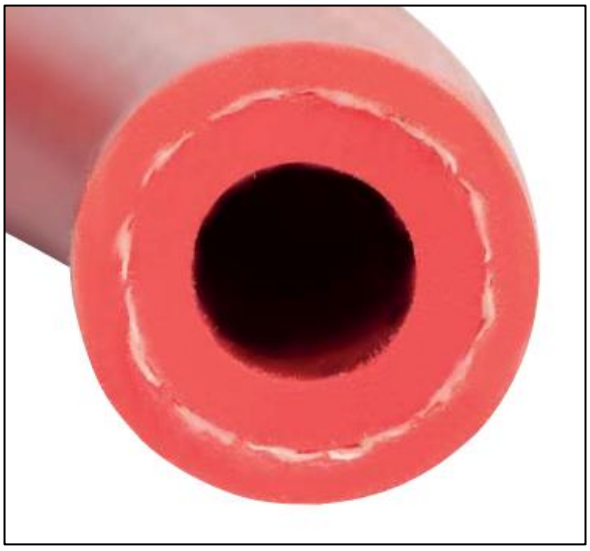
This vacuum hose is a platinum cured reinforced silicone hose manufactured to the highest standard which has been developed specially for high temperature applications in autoclaves and ovens, rated to a temperature of 270°C. The internal steel spring prevents collapse under vacuum and pressure and prevents hose separation from the couplings. The external support spring prevents hose lacerations at the fitting ends, extending the hose life.

The hose is extremely durable and long lasting, very flexible and user friendly.
The hose has NO silicone loss meaning no contamination worries.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Reinforcement type:	Glass fiber or aramid reinforcement
Hose color:	Red
Internal hose diameter:	3/8 inch
Outer hose diameter:	18mm
End fittings:	1/4 inch male BSP or NPT (on request)
Maximum use temperature:	270°C



SK2VV270-1R

Reinforced vacuum hose for high temperature and high pressure process

Hose type	Reinforcement type	Working temperature	Burst pressure	Max. recommend work pressure
SK2VV270-1RA	Aramid	270°C	> 80 bar	> 25 bar
SK2VV270-1RG	Glass fiber	270°C	35 bar	> 25 bar

The glass fiber reinforced hose SK2VV270-1RG is a tough, durable hose ideal for industrial high temperature environments.

The aramid fiber reinforced hose SK2VV270-1RA provides maximum durability, robustness and high tear resistance. Designed for demanding high temperature aerospace environments.

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

The length of the hose has to be chosen by 0,5m step.
The maximum manufactured length is 25 meters.
Maximum use pressure and temperature should be determined under your actual process conditions.
Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-2

High temperature vacuum hose assemblies

Back to range

► DESCRIPTION

This vacuum hose assembly is made from platinum cured silicone hose manufactured to the highest standard (gives off no free silicone particles) and is fitted with stainless steel one-piece couplings. This thread-less system provides the highest vacuum performance, reliability and maximum flexibility when used in autoclaves and oven processes up to 270°C. Assemblies are fitted with internal and external support springs. Couplings are fully resealable, without removal from the hose. All couplings are manufactured to ISO B.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Material type of socket:	Stainless steel
Hose color:	Red
Maximum use temperature:	270°C
Recommended autoclave pressure:	10 Bar

► SIZE

Hose type	Socket type	QRC Connection	Hose i.d.	Hose o.d.	Length
SK2VV270-2STR/STR	Straight socket	1/4	3/8	18 mm	1,0m till 25,0m
SK2VV270-2STR/C90	Elbow socket	1/4	3/8	18 mm	1,0m till 25,0m

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

For pressure over 10Bar we recommend hoses Version HP.
All end fittings are 100% vacuum tested after assembly. The length of the hose has to be chosen by 0,5m step. Recommended maintenance interval: 1000hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV270-18

High temperature vacuum hose in the roll

Back to range

► DESCRIPTION

This vacuum hose is a platinum cured silicone hose manufactured to the highest standard which has been developed specially for high temperature applications in autoclaves and ovens, rated to a temperature of 270°C. The internal steel spring prevents collapse under vacuum and pressure.

The hose is extremely durable and long lasting, very flexible and user friendly.
The hose has NO silicone loss meaning no contamination worries.

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

► TECHNICAL DATA

Material type of hose:	Silicone
Material type of inner conduits:	Steel spring
Hose color:	Red
Length of the roll:	25m
Internal hose diameter:	3/8 inch
Outer hose diameter:	3/4 inch
Maximum use temperature:	270°C
Maximum autoclave pressure:	10 Bar

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Recommended maintenance interval: 1000 hours based on operating temperatures up to 180°C when using with our connections.

TECHNICAL DATA SHEET

SK2VV400-1

Vacuum hose for high temperature process 400°C

Back to range

► DESCRIPTION

This super high temperature vacuum hose is a stainless steel hose with a specially designed welded end fittings for maximum durability. It is manufactured to the highest standard which has been developed specially for high temperature applications in autoclaves and ovens, rated to a temperature of 400°C. Super high temperature hoses are manufactured to the highest grade and finish to provide a seal-less connection of the highest integrity. The fitting is welded into hose and assemblies are 100% vacuum tested.

The hose is extremely durable and long lasting and user friendly.

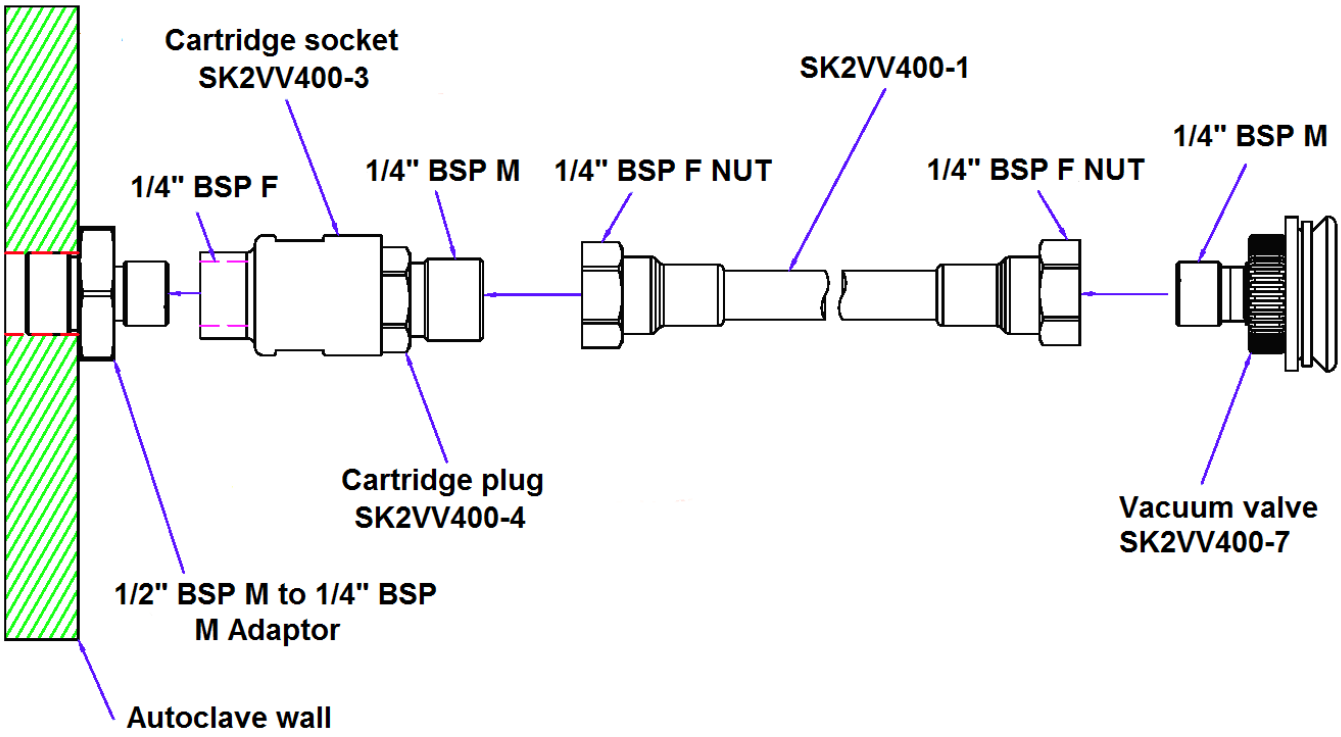
This product is used in various manufacturing processes of parts made of composite.

► TECHNICAL DATA

Material type of hose:	316 stainless steel
Hose color:	iron grey
Internal hose diameter:	3/8 inch
Outer hose diameter:	1/4 – 3/4 inch
End fittings:	welded 1/4 inch female BSP F (female) nuts
Maximum use temperature:	400°C

Pic.: Assembled hose SK2VV400-1H14BSPSTR90

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.



Assembling schema for using of super high temperature products for processes till 400°C

► **NOTE**

The length of the hose has to be chosen by 0,5m step. The maximum manufactured length is 12 meters.
Possible size of end fittings: 1/4 or 3/8 inch female BSP F (female)
Hoses can be delivered with straight or elbow 90° fittings.

BOARDS AND ADHESIVES FOR MASTER MODEL MANUFACTURING			
Name	**Description**	**Max. use T°C**	**Color**
MMTM70-RIM	Set of technological tool – master-model for composite skin tool manufacturing in resin infusion technology according to the Specification of the customer	70°C	Grey

MATERIALS FOR TOOLING MANUFACTURING			
Name	**Description**	**Max. use T°C**	**Color**
SK2TM164-1	Two-component epoxy gel coat	175°C	Grey
SK2TM175-1	High-temperature two-component resin system for vacuum infusion	175°C	Brown transparent
SK2TM180-1	Two-components carbon filled epoxy gel coat	180°C	Black
SK2TM180-2	Prepreg with epoxy matrix and carbon reinforcement for composite tooling construction in 3 different surface weights	180°C	-
SK2TM181-1	High-temperature two-component laminating resin system	181°C	Brown transparent
SK2TM400-1	Thermoplactic tape made of uni-directional carbon fiber and PEEK-matrix	400°C	-
SK4CV-1	Carbon veil with PVA binder	-	Black
SK4CV-2	Carbon veil with styrene soluble polyester binder	-	Black
SK4CV-3	Carbon veil with cross-linked polyester binder	-	Black
SK4CV-4	Carbon veil with cross-linked styrene acrylic binder	-	Black
SK4GV-1	Glass veil	-	White

MATERIALS FOR WASH-AWAY MANDRELS			
Name	**Description**	**Max. use T°C**	**Color**
SK2TM200-1	Powdered mandrel material for mixing with water before use.	200°C	White
SK2TM200-2	Water soluble fugitive core material ready to use.	193°C	White
SK2TM200-4	Spray-/brushable seal for mandrel	193°C	Blue
SK2TM200-7	Block for manufacturing of mandrel	200°C	Light grey
SK2TM200-9	Paste for filling, bonding or patching	200°C	White

TECHNICAL DATA SHEET

MM-TM70-RIM

Master-model for composite tool manufacturing in resin infusion technology

Back to range

► DESCRIPTION

Master-model is an initial carrier of shape and surface quality of the final product. We offer high quality Master-models produced by the company «KOLLER». They are designed to produce composite tool using resin infusion technology to create high quality shape-generating surface. Master-model is a light, vacuum tight and solid structure fabricated using sandwich-structure technology with application of special modeling compound, applied on the previously created structure. Comparing to modeling board Master-models this technology allows to avoid starved spots, porosity and interstices and also to avoid joints that reduce surface quality of composite tool.

Manufacturing of Master Model includes following steps:

- Analyses of technical files received from the customer like Technical Statement of Work (SOW) and 3D models. Before going to the next step Customer will get mathematical model of final Master-model for check and validation.
- Design and manufacturing of Master-model supporting structure includes:
  - ✓ Creation of wooden structure;
  - ✓ Creation of polystyrene core with following milling with negative offset from the theoretical contour;
  - ✓ Application of expanded foam (density 100kg/m3) with negative offset from the theoretical contour to create primary volume;
  - ✓ Laminating: application, impregnation and polymerization of reinforcing layers.

- Modeling of shape-generating structure of Master-model includes applying of epoxy compound SK2TM70.
  To achieve the best strength characteristics of the applied compound model-master have to be thermo stabilized.

TECHNICAL DATA SHEET

MM-TM70-RIM

Master-model for composite tool manufacturing in resin infusion technology

- Mechanical treatment of Master-models is carried out on one of three available machines HSM milling UGV 5 axis «FOREST LINE» with working area 6800 mm x 3500 mm x 2000 mm and with surface finish Ra 1,6. Application of the contour lines and labels can be done on request on finished models. Final finishing is achieved by polishing grain 320.

- Final check of Master-model includes the vacuum test and geometry test measuring the deviation from the theoretical contour. The vacuum test is carried out in the vacuum bag to prove that the maximum vacuum loss is no more than 0.1 bar for 10 minutes. Geometry test measuring the deviation from specified values is carried out with the help of the POWER INSPECT DELCAM software and special measuring arm for quality control of the tool. Measuring arm and digitalization have useful area of 6000 mm x 3000 mm x 2000 mm.

► TECHNICAL DATA

THERMAL AND MECHANICAL PROPERTIES OF SK2TM70-4 [1]			
Hardness 7 days at 23°C 16 hours at 70°C	ISO 868 : 2003	Shore D1	65 67
Glass transition temperature (Tg) 7 days at 23°C 16 hours at 70°C	ISO 11359 : 1999	°C	50 83
Coefficient of thermal expansion (CTE) 16 hours at 70 °C	ISO 11359 : 1999	$10^{-6}.K^{-1}$	60
Tensile modulus	ISO 527 : 1993	MPa	1,100
Tensile strength	ISO 527 : 1993	MPa	14
Elongation at break	ISO 527 : 1993	%	2.8

Flexural modulus	ISO 178 : 2001	MPa	1,100
Flexural strength	ISO 178 : 2001	MPa	24

(1) Average values obtained on standard specimens / Hardening 24 hr at 23°C + 16 hr at 70°C

► ADVANTAGES OF OUR MASTER- MODELS

- Manufacturing of oversized Master-model within a very short time;
- High surface quality of Master-models;
- High working temperature of Master-model;
- Low coefficient of thermal expansion (CTE): geometrical stability of model;
- Installation of rigidity ribs for redistribution of loads;
- Creating of supporting structure with bearing and rigging elements.

Storage conditions : it is recommended to store at temperature from -20°C until +30°C in the original package.

► NOTE

Before applying the release liquids SK2TR399-1 or SK2TR399-2, it is recommended to treat the surface of the Master-model by sealing material SK2TR399-4. Apart from reducing of the surface porosity, it has the ability to enhance the performance of semi-permanent release reagents.

TECHNICAL DATA SHEET

SK2TM164-1

Two-component epoxy gel coat

Back to range

► DESCRIPTION

SK2TM164-1 is a two-component epoxy gel coat for production of prepreg tools. This dimensionally accurate carbonfibre filled mould surface resin provides better surface slip and has a very low thermal expansion and a very high heat resistance.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type: Epoxy

PHYSICAL PROPERTIES			
Composition	**Mixing**	**Resin Part A**	**Hardener Part B**
Colour	grey	grey	brown transparent
Mixing ratio	-	100 p. b. w.	31 p. b. w.
Viscosity at 25°C (mPa.s)	thixotrop	thixotrop	375 mPas
Density at 20°C	1,22 g/cm^3	1,35 g/cm^3	0,97 g/cm^3
Pot life 200g / 20°C	220-260 min	-	-
Curing time at RT	24-48 hrs	-	-
Post curing	16 / 60 h/°C 8 / 130 h/°C 4 / 160 h/°C	-	-
TECHNICAL SPECIFICATIONS			
Flexural strength	EN ISO 178	MPa	90
Flexural modulus	EN ISO 178	MPa	4630
Impact resistance (Charpy)	EN ISO 179	kJ/m^2	7,3
Compressive strength	EN ISO 604	MPa	105
Heat resistance (HDT)	DIN 53458	°C	164
Shore hardness	DIN ISO 7619-1	Shore D	87
Coefficient of linear expansion	DIN 53752	10-6 K-1	ca. 50

► SIZE

Packing	Pack
Kit	4,5 kg

► PROCESSING INSTRUCTIONS

The temperature of material and processing should be between 18 and 25° C.

After each use the containers have to be closed again. Porous mould surfaces should be sealed before by SK2TR450-1. For an optimum mould release we recommend a suitable release agent (e.g. SK2TR450-4) which can be easily applied with a brush. The mould should be treated 2 or 3 times with release agent and allowed to evaporate for approx. 20 min after every application.

Mixing ratio resin/hardener according to instructions!
Stirring rods etc. with residual resin can be easily cleaned with SK2TR000-1 cleaning agent.

► STORAGE

Storage at room temperature 18-25 °C.
Opened containers should be closed immediately after use and should be used up as soon as possible.
Shelf life is indicated on the labels.

► SAFETY MEASURE

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices.

► WASTE DISPOSAL

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste. Non-cured products are waste which is subject to inspection and has to be disposed accordingly.
In case of further questions please do not hesitate to contact our Product Safety Data Sheet.

► GUARANTEE

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of the products, under their own conditions before commencing with the proposed application. We refuse any guarantee about the compatibility of a product with any particular application. We disclaim all responsibility for damage from any incident, which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

TECHNICAL DATA SHEET

SK2TM175-1

High temperature two-component resin system for vacuum infusion

Back to range

► DESCRIPTION

SK2TM175-1 is a high temperature resistant two components epoxy laminating resin designed for multipurpose applications: vacuum forming, prepreg tools, hot gluing tools, blow moulds, polyester injection moulds, polyester press tools, vacuum infusion.

SK2TM175-1 has a very high heat resistance, precuring at room temperature and depending on post curing can be used till 175 °C.

Since SK2TM175-1 laminating resin system contains no fillers, it has got good wetting properties and makes a high glass fabric content possible. This leads to a low coefficient of thermal expansion and high strength.

Together with aluminium granules, SK2TM175-1 is suitable for back filling of heat resistant moulds and moulding tools. At room temperature the curing takes 7 days and the material can only be used for applications till 60°C.

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

► TECHNICAL DATA

PROCESSING DATA			
Composition	**Mixing**	**Resin Part A**	**Hardener Part B**
Colour	brown transparent	brown transparent	brown transparent
Mixing ratio	-	100 p. b. w.	40 p. b. w.
Viscosity at 25°C (mPa.s)	750 mPas	800 mPas	375 mPas
Density at 20°C	1,10 g/cm^3	1,15 g/cm^3	0,97 g/cm^3
Pot life 200g / 20°C	240-360 min	-	-
Curing time at RT	24-48 hrs	-	-
Post curing	4 / 40 h/°C 4 / 60 h/°C 4 / 100 h/°C 4 / 135 h/°C 4 / 160 h/°C	-	-

SK2TM175-1

High temperature two-component resin system for vacuum infusion

PHYSICAL PROPERTIES			
Flexural strength	EN ISO 178	MPa	95
Flexural elongation at break	EN ISO 178	%	4
Flexural modulus	EN ISO 178	MPa	2800
Impact resistance (Charpy)	EN ISO 179	kJ/m^2	16
Compressive strength	EN ISO 604	MPa	85
Heat resistance (HDT)	DIN 53458	°C	175
Glass transition temperature TG	method DSC	°C	182
Shore hardness	DIN ISO 7619-1	Shore D	85

► SIZE

Packing	Part A	Part B
Kit	20 kg	8 kg

► PROCESSING INSTRUCTIONS

The temperature of material and processing should be between 18 and 25° C. The mixing of resin and hardener should be made intensively and if possible without any bubbles at room temperature.

We recommend a post curing with a temperature rise of about 10°C/hour. Difficult geometries should be supported during the curing cycle. Afterwards the part should be cooled down at about 20°C/hour.

Through step-by-step curing a high heat resistance will be reached. Cool down slowly to room temperature.

Glass transition temperature (TG) 95°C: After postcuring 4 hrs. at 40°C + 4-10 hrs. at 60°C

Glass transition temperature (TG) 139°C:	After postcuring 4 hrs. at 40°C + 4-10 hrs. at 60°C + 4 hrs. at 100 °C
Glass transition temperature (TG) 156°C:	After postcuring 4 hrs. at 40°C + 4-10 hrs. at 100°C + 4 hrs. at 135°C
Glass transition temperature (TG) 175°C:	After postcuring 4 hrs. at 40°C + 4-10 hrs. at 60°C + 4 hrs. at 100°C + 4 hrs. at 135°
Heat resistance (HDT) ISO 75 B - 158 °C:	After post curing 4 h at 40 °C + 4-10 h at 60°C + 4 h at 100 °C + 4 h at 135 °C
Heat resistance (HDT) ISO 75 B - 175 °C:	After post curing 4 h at 40 °C + 4-10 h at 60°C + 4 h at 100 °C + 4 h at 135 °C + 4 h at 160°C
Glass transition temperature (TG) 182°C:	After postcuring 4 hrs. at 40°C + 4-10 hrs. at 60°C + 4 hrs. at 100°C + 4 hrs. at 135°C + 4 hrs. at 160°C

We recommend to perform the complete postcuring on the master model, at least the first one should be made this way.

► STORAGE

At appropriate storage 18-25°C.
Occuring crystallization due to unfavorable storage conditions can be eliminated by warming up the material at approx. 60° C for some hours.
Opened containers should be closed immediately after use and be protected against moisture. This material should be used up as soon as possible.
Shelf life is indicated on the labels.

► SAFETY MEASURE

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices.

► WASTE DISPOSAL

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste. Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Product Safety Data Sheet.

► GUARANTEE

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of the products, under their own conditions before commencing with the proposed application. We refuse any guarantee about the compatibility of a product with any particular application. We disclaim all responsibility for damage from any incident, which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

TECHNICAL DATA SHEET

SK2TM180-1

Epoxy gel coat

Back to range

► DESCRIPTION

SK2TM180-1 is a black two-components carbon filled epoxy gel coat designed for production of moulds for prepreg, RTM, SMC, thermoforming. SK2TM180-1 has a high thermal resistance and can be polished, the product is chemically resistant.

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

► TECHNICAL DATA

Material type: Epoxy

PHYSICAL PROPERTIES			
Composition	**Part A**	**Part B**	**Mixing**
Mix ratio by weight	100	31	-
Aspect	thick liquid	liquid	thick liquid
Colour	black	brown transparer	black
Viscosity at 25°C (mPa.s)	thixotropic	375±75	thixotropic
Density at 20°C	1,35±0,03	0,97±0,02	1,22±0,02
Potlife, 200 g at 20°C (min)	-	-	220 - 260
Curing time at RT (in hours)	-	-	24 - 48
Post curing time (in hours / temperature in °C)	-	-	16 / 60 8 / 130 4 / 160
MECHANICAL & THERMAL PROPERTIES (1)			
Hardness	DIN ISO 7619-1	Shore D	87±3
Flexural strength	EN ISO 178	MPa	90±4
Flexural modulus	EN ISO 178	MPa	4630±300

Impact resistance (Charpy)	EN ISO 179	kJ/m^2	7,3±1,5
Compressive strength	EN ISO 604	MPa	105±7
Heat resistance (HDT)	DIN EN ISO 75 B	°C	175±5
Glass transition temperature TG	TMA	°C	175
Coefficient of thermal expansion	internal test / Dilatometer	$10^{-6}K^{-1}$	около 50

(1) : Average values obtained on standardized specimens, on neat resin.
Hardening: according to the curing cycle indicated on the next page.

► SIZE

Packing	Part A	Part B
Kit 4,5 kg	12 containers x 0.285 kg each	12 containers x 0.090 kg each

► PROCESSING

The material and processing temperature should be between 18 and 25 °C.

As soon as the surface resin has gelled but is still slightly tacky, you can proceed with your buildup. Porous mould surfaces should be sealed first. The mould should be coated 2-3 times and allowed to evaporate for approx. 20 min. after each application.

The mixing ratio of resin and hardener must be kept according to the instructions.

► STORAGE

Both parts should be protected from moist and be stored in the original unopened packing at the temperature 18 - 25°C. Opened containers should be closed immediately after use and should be used up as soon as possible.

► HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products: ensure good ventilation, wear gloves, safety glasses and clothes.

► GUARANTEE

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SK2TM180-2

Prepreg with epoxy matrix and carbon reinforcement for composite tooling

Back to range

► DESCRIPTION

SK2TM180-2 is an advanced epoxy matrix system designed for composite tooling construction.

SK2TM180-2 supplied in the form of carbon* prepreg to offer the following advantages:

- low temperature cure: 14 hours at 45°C
- excellent surface finish
- work life of 2-3 days at room temperature (23°C) and 6 months when stored at -18°C
- low shrinkage during the curing and post-curing process
- service temperature over 180°C after post-cure
- solvent free formulation

** SK2TM180-2 can also be supplied in the form of glass prepreg on special order*

The 3 different types of prepreg SK2TM180-2 are available:

Reference	Areal weight	Resin content
SK2TM180-2PRE50	204 g/m^2	50%
SK2TM180-2PRE35	630 g/m^2	35%
SK2TM180-2PRE34	995 g/m^2	34%

► TECHNICAL CHARACTERISTICS

SK2TM180-2PRE50		
Dry fabric	**Typical values**	**Unit**
Weaving Style	TWILL 2/2 BATAVIA 2/2	-
Fiber type	T300 3K or equivalent	-
Fiber density	1.76	g/cm^3
Warp	5.1	threads/cm
Weft	5.1	threads/cm
Areal weight	204 (± 4%)	g/m^2

Uncured prepreg	Typical values	Unit
Tack	Medium-High	-
Flow	21 (± 5%)	%
Out life at 23°C	3	days
Storage life at -18°C	6	months
Nominal Area weight	408	g/m^2
Nominal Resin content	50 (± 3)	Wt %
Volatile content	< 1	Wt %
Nominal width	1000	mm
Cured Ply Thickness*	0.282	mm

* The tests were carried out at 23°C and 60% R.H. on specimens cured in std conditions (dwell at 45°C for 14 hours in autoclave. External pressure applied: 6 bar).

SK2TM180-2PRE35		
Dry fabric	**Typical values**	**Unit**
Weaving Style	TWILL 2/2 BATAVIA 2/2	-
Fiber type	T700 12K or equivalent	-
Fiber density	1.8	g/cm^3
Warp	3.9	threads/cm
Weft	3.9	threads/cm
Areal weight	630 (± 4%)	g/m^2
Uncured prepreg	**Typical values**	**Unit**
Tack	High	-
Flow	13 (± 5%)	%

Out life at 23°C	3	Days
Storage life at -18°C	6	Months
Nominal Area weight	969	g/m^2
Nominal Resin content	35 (± 3)	Wt %
Volatile content	< 1	Wt %
Nominal width	1270	mm
Cured Ply Thickness*	0.626	mm

* The tests were carried out at 23°C and 60% R.H. on specimens cured in std conditions (dwell at 45°C for 14 hours in autoclave. External pressure applied: 6 bar).

SK2TM180-2PRE34		
Dry fabric	**Typical values**	**Unit**
Weaving Style	TWILL 2/2 BATAVIA 2/2	-
Fiber type	AKSA 24K	-
Fiber density	1.78	g/cm^3
Warp	3.0	threads/cm
Weft	3.0	threads/cm
Areal weight	995 (± 4%)	g/m^2
Uncured prepreg	**Typical values**	**Unit**
Tack	High	-
Out life at 23°C	3	days
Storage life at -18°C	6	months
Nominal Area weight	1508	g/m^2
Nominal Resin content	34 (± 3)	Wt %
Volatile content	< 1	Wt %

Nominal width	1270	Mm
Cured Ply Thickness*	0.976	Mm

* The tests were carried out at 23°C and 60% R.H. on specimens cured in std conditions (dwell at 45°C for 14 hours in autoclave. External pressure applied: 6 bar).

► PROCESSING INFORMATION

MASTER MODEL SELECTION

Master model material should be selected with reference to the temperature and pressure to be applied during the autoclave cure process. In all cases the master model must be proved at the temperature and pressure above that of the desired cure cycle before beginning lay-up of the tool. This will enable any potential problems such as lack of vacuum integrity or poor stability under pressure to be checked before any actual laminate construction. The master model must be constructed from materials that will not cause adverse reactions with the tooling prepreg resin system. Equally, it should not be coated with a sealer that will allow migration of chemicals which cause problems.

MASTER MODEL PREPARATION PROCEDURE

- Thoroughly degrease the master model surface using an organic solvent
- Seal the surface of master model with a suitable epoxy surfacing resin using wipe on buff off technique
- Thoroughly degrease the master model surface ensuring all solvent is removed
- Apply a semi-permanent, solvent-based release agent from our SK2TR range such as SK2TR450-12 to the surface following the instructions
- Allow the final coat to cure for 15 to 20 minutes at 22°C

THAWING PREPREG BEFORE USE

SK2TM180-2 prepregs must be stored at -18°C, sealed in original packages. Shop life at 23°C refers to rolls sealed in original packages. Before using the prepreg, remove the roll from the freezer and let it warm up to room temperature for 6 hours sealed in its original package. Prepreg rolls are considered sufficiently warm when condensation no longer forms on the outside of the bag. Ensure there is adequate material available to complete laminating and cure, prior to unsealing the roll and starting work.

OPERATIONAL INSTRUCTIONS

- Always wear nitrile gloves when handling prepreg;
- Cut the prepreg into convenient sized squares or rectangles for laminating;

- Cut 45° trim strips for the external corners and tight radii;
- Cleanliness is very important during the lay-up procedure. Avoid introducing any contaminates into the lay-up, i.e. paper, polythene or release film, as these will adversely affect the tool laminate and may lead to premature tool failure;
- Table 1 shows a copy of a typical work sheet with easy reference for ply type and fibre orientation.
- Lay up the first ply, carefully cutting and keep in mind the following points:

    1. All pieces should be overlapped of 3,0 mm (1/8 inch)
    2. Lay up a series of 45º trim strips in to all external corners and tight radii, ensure pattern runs in a consistent direction for aesthetics;
    3. Cut material to fit into all external radii and corners taking care not to disturb the trim strips.
    4. To avoid bridging, no single piece of prepreg should ever be laid up around more than one corner;
    5. Ensure that Prepreg is spliced in corners and any female tight radii in order to avoid wrinkling.

- Lay up the bulk plies following these instructions:

    1. Butt jointing is preferable on subsequent plies but care must be taken so that the joints on each ply are staggered with a minimum of 18 mm (3/4 inch) spacing for adjacent plies;
    2. If overlapping is unavoidable on subsequent plies ensure the overlap is a maximum of 3.0 mm (1/8 inch) wide and that overlaps are staggered;
    3. Under no circumstances should any gaps be left as this is likely to cause voids in the completed tool.

DEBULKING

It is essential to debulk the prepreg at least at the stages stated in table 1. This will ensure even consolidation and remove air from the laminate prior to final curing. More complex shapes can sometimes be easier to laminate if more frequent debulks are used, but in these cases, the time factor must be taken into consideration.

Debulk the lay-up per the following steps:

1. Cover the lay-up with a suitable (PC type) perforated release film (e.g. SK2RF230-1 or SK2230-2 with perforation PC) ensuring no bridging and extending beyond the lay-up by approximately 25mm (1 inch);
2. Apply peel ply from the rang of SK2PP over the release film.
3. Apply a breather fabric SK2BB205-4 over the peel ply. Tailor to fit avoid bridging.

Do not use a non-woven polyester breather without a peel ply is first applied over the release film. Filaments from the polyester breather left in the laminate may cause premature tool failure.

4. Cover the laminate/assembly with a vacuum bag and apply full vacuum of 948 mbar (28 inches Hg) for a minimum of 30 minutes.
5. Care must be taken when materials are removed from the surface afterwards, be careful not to lift up the previously laminated plies.

TYPICAL LAY-UP SEQUENCE AND OPERATION FOR A CARBON FIBER REINFORCED LAMINATE OF TOTAL THICKNESS 5.60 mm

Operation N	Ply orientation	Material / Operation
1	0°	SK2TM180-2PRE50
2		DEBULK
3	0°	SK2TM180-2PRE35
4	+45°	SK2TM180-2PRE35
5		DEBULK
6	-45°	SK2TM180-2PRE35
7	90°	SK2TM180-2PRE35
8	90°	SK2TM180-2PRE35
9		DEBULK
10	-45°	SK2TM180-2PRE35
11	+45°	SK2TM180-2PRE35
12	0°	SK2TM180-2PRE35
13		DEBULK
14	0°	SK2TM180-2PRE50

The initial choice of the direction which will be 0° is arbitrary, but, once chosen, subsequent angles must be measured relative to this direction.

SK2TM180-2PRE50 is a 204 g/m², 2x2 twill, 3K carbon fabric with 50% resin content
SK2TM180-2PRE35 is a 630 g/m², 2x2 twill, 12K carbon fabric with 35% resin content

REDUCED LAY-UP SEQUENCE AND OPERATION FOR A CARBON FIBER REINFORCED LAMINATE OF TOTAL THICKNESS 6.40 mm

Operation N	Ply orientation	Material / Operation
1	0°	SK2TM180-2PRE50
2		DEBULK
3	0°	SK2TM180-2PRE34
4	45°	SK2TM180-2PRE34
5		DEBULK
6	90°	SK2TM180-2PRE34
7	90°	SK2TM180-2PRE34
8		DEBULK
9	45°	SK2TM180-2PRE34
10	0°	SK2TM180-2PRE34
11		DEBULK
12	0°	SK2TM180-2PRE50

The initial choice of the direction which will be 0° is arbitrary, but, once chosen, subsequent angles must be measured relative to this direction.

SK2TM180-2PRE50 is a 204 g/m², 2x2 twill, 3k carbon fabric with 50% resin content
SK2TM180-2PRE34 is a 995 g/m², 2x2 twill, 24k carbon fabric with 34% resin content

► OPERATIONAL INSTRUCTIONS

This epoxy matrix system can be processed at low temperature, starting from 23°C.

Temperature °C	Time	Tg °C DSC
45 °C	14 h	69 °C
55 °C	7 h	75 °C

► CURE PROCESS RECOMMENDATIONS

The curing cycles recommended are:

1. **14h at 45°C, ramp 0,5°C/min:**
   - Dwell at RT for 60 minutes under full vacuum
   - Apply a pressure of 6 bar
   - Heat the laminate at a rate of 0.5°C/min to 45°C
   - Hold the laminate at 45°C for 14 hours
   - Cool the laminate to RT under pressure at 2°C/min

The Tg of the laminate made using this cure cycle is 63°C (by DMA onset).

2. **7h at 55°C, ramp 0,5°C/min:**
   - Dwell at RT for 60 minutes under full vacuum
   - Apply a pressure of 6 bar
   - Heat the laminate at a rate of 0.5°C/min to 55°C
   - Hold the laminate at 55°C for 7 hours
   - Cool the laminate to RT under pressure at 2°C/min

The Tg of the laminate made using this cure cycle is 72°C (by DMA onset).

► POST-CURE

An unsupported post cure can be applied to reach the necessary service temperature of the carbon tool. All the cycle below are performed with a 0,2°C/min heating ramp:

Cure	Postcure	Tg °C E' DMA	Tg °C tan & DMA	% cure by DSC
14h at 45°C	**5h at 180°C**	189°C	222°C	100%
7h at 55°C	**5h at 180°C**	191°C	228°C	100%

BAGGING & LAY-UP RECOMMENDATIONS

1. The tool master should be sealed and coated with release agent.
2. When the prepreg is laid up on the mold, splices should be staggered.
3. Small strips of prepreg can be placed in tight corners and radii to insure that there is no bridging of the Prepreg.
4. A thermocouple should be placed under the second ply, in an area that is not critical to the aesthetics of the part.
5. A Non Perforated release film is placed on the top of the last layer of prepreg.
6. Pin prick the solid release film every 100-150mm across the surface of the tool. This is to form vacuum connections to the breather.
7. Breather cloth, minimum 300 gsm weight, is applied of the entire part, with a double layer where the vacuum ports are attached.
8. The vacuum bag is placed over the part with sufficient slack to avoid bridging in corners.
9. Perform a vacuum check to insure there are no leaks and that > 914 mbar vacuum (27 in Hg) is achieved.

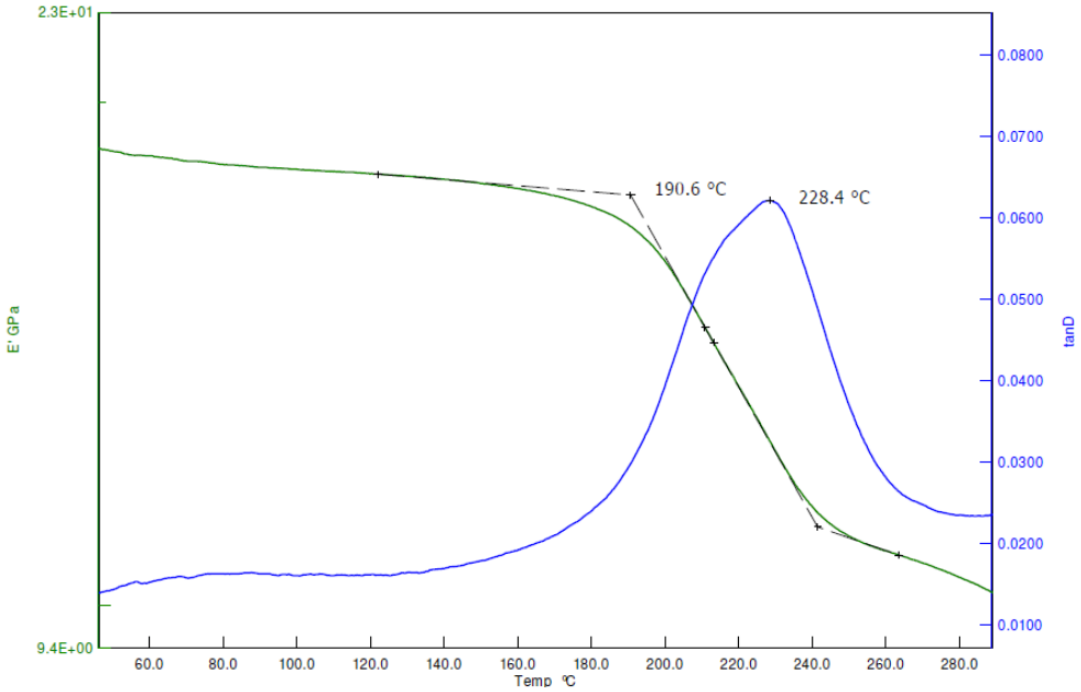
► GENERAL PROPERTIES OF THE RESIN MATRIX

Property	Value	Unit	Standard
Storage life at -18°C	6	months	
Work life at 23°C	2-3	days	
Cured resin density	1.23	g/cm^3	ASTM D792-00
Tg E' (DMA)*	191	°C	ASTM E1640-09
Tg Peak Tan δ (DMA)*	228	°C	ASTM E1640-09
CTE*	4-6 x 10^{-6}	°C-1	ISO 11359-2
Tack	High		

** Laminate fully cured 7h at 55°C plus post cure 5h at 180°C*

► THERMO-MECHANICAL DMA ANALYSIS

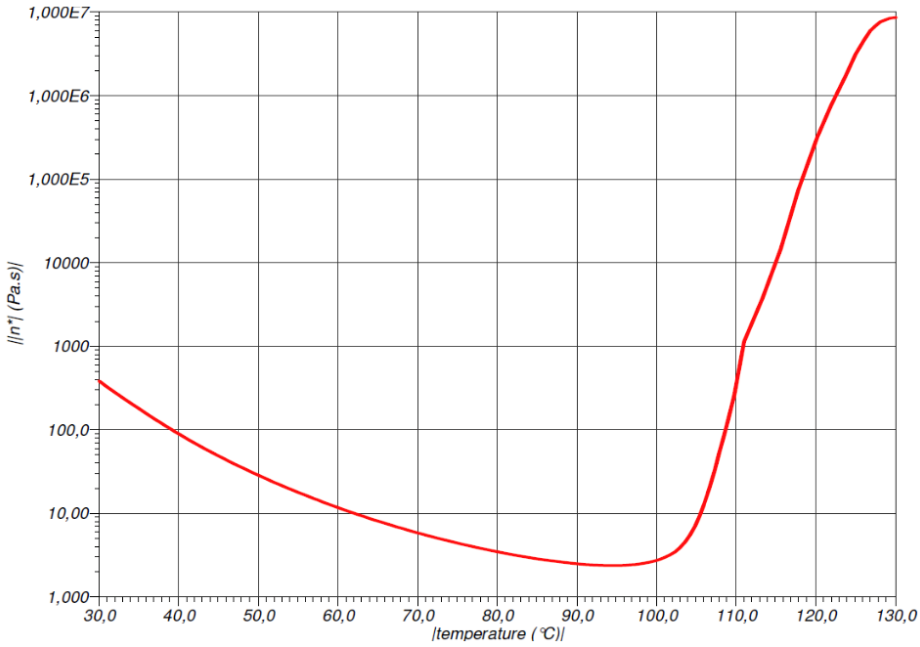
DMA trace of the prepreg SK2TM180-2 laminate cured for 7h at 55°C + post cure 5h at 180°C.



DMA Analysis: modulus E‘ vs temperature

Modulus E’ evaluated under 2°C/min heating rate, 1Hz oscillating frequency.

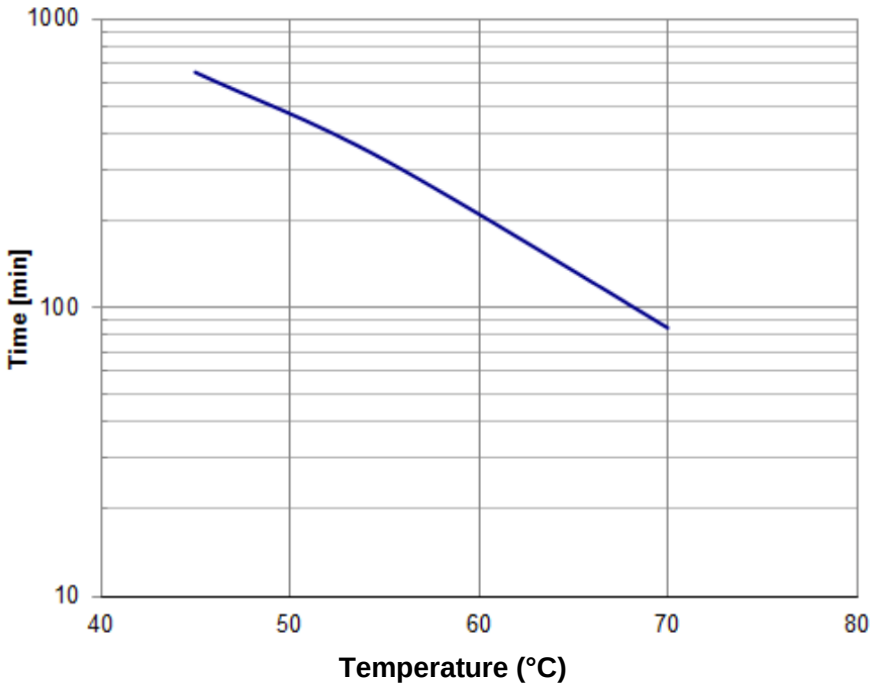
► VISCOSITY PROFILE



Viscosity profile: temperature vs complex viscosity

Resin complex viscosity’ evaluated under 3°C/min heating rate, 1Hz oscillating frequency.

▶ GEL TIME



Temperature °C	Gel time (min)
45°C	653 min
55°C	325 min
70°C	85 min

▶ SAFETY CONSIDERATION

- Please consult the Material Safety Data Sheet.
- This product contains epoxy resin, and may cause allergic reaction.
- The use of latex gloves for handling is recommended.
- Waste material should be discarded following national law.

▶ DELIVERY FORM AND PACKAGING

Custom widths, roll size, and packaging are available on request.

Prepreg fabrics: Supplied on 75 mm (3”) diameter cardboard cores with release paper on one side and polyethylene film separator on the other side. Rolls are sealed plastic bags and packed in cardboard boxes.
Standard width: 100 cm (39.4“) or 127 cm (50“).
Standard length: 50 m (54.7 in yds).

Unidirectional Prepreg: Supplied on 300 mm (12”) diameter cardboard cores with release paper on one side and smooth polyethylene film separator on the other side. Rolls are sealed in plastic bags and packed in cardboard boxes.
Standard width: 60cm (23.6”), range from 30cm (11.8”) up to 105cm (41.3”)
Standard length: 100 m (109 in yds).

Shipment: Product should be shipped at < -18 °C

► HANDLING AND CONDITIONING

- Store rolls at -18 °C, sealed in original packages.
- Shop life at 23°C refers to rolls sealed in original packages.
- Before using the prepreg, remove the roll from the freezer and let it warm up to room temperature for 6 hours sealed in its original package.

► GUARANTEE

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SK2TM181-1

High temperature two-component laminating resin system

Back to range

► DESCRIPTION

SK2TM181-1 is a high temperature resistant two-component epoxy laminating resin designed for wet lay up production of composite moulds for following using of tools in prepreg, resin infusion and RIM application.

It has a very high heat resistance, precuring at room temperature and depending on post curing can be used till 181°C.

Since SK2TM181-1 laminating resin system contains no fillers, it has got good wetting properties and makes a high fabric content possible. This leads to a low coefficient of thermal expansion and high strength of the tooling.

Together with aluminium granules, SK2TM181-1 is suitable for back filling of heat resistant moulds and moulding tools.

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

► TECHNICAL DATA

PROCESSING DATA			
Composition	**Mixing**	**Resin Part A**	**Hardener Part B**
Colour	brown transparent	yellow transparent	brown transparent
Mixing ratio	-	100 p. b. w.	42 p. b. w.
Viscosity at 25°C (mPa.s)	2200 mPas	2000 mPas	2400 mPas
Density at 20°C	1,08 g/cm^3	1,12 g/cm^3	0,98 g/cm^3
Pot life 200g / 20°C	160-200 min	-	-
Curing time at RT	>48 hrs	-	-
Post curing	4-6 / 40 h/°C 4-6 / 60 h/°C 4-6 / 100 h/°C 4-6 / 150 h/°C	-	-

PHYSICAL PROPERTIES			
Flexural strength	EN ISO 178	MPa	68
Flexural elongation at break	EN ISO 178	%	2,4
Flexural modulus	EN ISO 178	MPa	3100
Impact resistance (Charpy)	EN ISO 179	kJ/m^2	4,5
Compressive strength	EN ISO 604	MPa	100
Heat resistance (HDT)	DIN 53458	°C	181
TG in TMA Tg	method TMA	°C	200
Shore hardness	DIN ISO 7619-1	Shore D	88

► SIZE

Packing	Part A	Part B
Kit	20 kg	8,4 kg

► PROCESSING INSTRUCTIONS

The temperature of material and processing should be between 18 and 25° C. The mixing of resin and hardener should be made intensively and, if possible, without any bubbles at room temperature.

We recommend a post curing with a temperature rise of about 10°C/hour. Difficult geometries should be supported during the curing cycle. Afterwards the part should be cooled down at about 20°C/hour.

Through step-by-step curing a high heat resistance will be reached. Cool down slowly to room temperature.

Postcuring in following steps:

4 - 6 h at 40°C
4 - 6 h at 60°C
4 - 6 h at 100°C
4 - 6 h at 150°C

By additional postcuring of 4 hrs. at 160-180°C Tg of about 200 °C will be reached. We recommend to perform the complete postcuring on the master model, at least the first one should be made this way.

► STORAGE

At appropriate storage 18-25°C.
Occuring crystallization due to unfavorable storage conditions can be eliminated by warming up the material at approx. 60°C for some hours. Opened containers should be closed immediately after use and be protected against moisture. This material should be used up as soon as possible.

Shelf life is indicated on the labels.

► SAFETY MEASURE

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices.

► WASTE DISPOSAL

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste. Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Product Safety Data Sheet.

► GUARANTEE

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SK2TM400-1

Thermoplactic tape made of uni-directional carbon fiber and PEEK-matrix

Back to range

► DESCRIPTION

SK2TM400-1 – is a high-end thermoplastic composite material, utilizing the semi-crystalline thermoplastic polymer PEEK for excellent mechanical performance.

The long-standing use of PEEK in demanding applications such as aerospace and cutting edge medical applications proves its benefits and versatility. As a composite material it offers outstanding mechanical performance, also at elevated temperatures. The semi-crystalline nature of the resin ensures an excellent resistance to chemicals and solvents, and an equally superior performance in flammability properties.

The product type: PEEK (PolyEtherEtherKetone) Thermoplastic Resin System

► PROPERTIES

- Excellent toughness and impact resistance
- Excellent mechanical performance, also at elevated temperatures
- Low moisture uptake for good hot/wet strength retention
- Fully impregnated low void content unidirectional tapes for robust processing
- Inherently flame retardant
- Outstanding chemical and solvent resistance
- Indefinite shelf life at ambient temperature storage

► TYPICAL NEAT RESIN PROPERTIES

Density (specific gravity):	1.30 g/cm^3
T_g (glass transition):	143°C
T_m (melt):	343°C
T_c (crystallinity):	290°C
T_p (processing):	370-400°C

► APPLICATIONS

- Primary and secondary aircraft structure
- Structural aircraft interiors applications
- Access panels, rib stiffeners, brackets, conduit, flooring
- Medical
- Oil and gas

TECHNICAL DATA SHEET

SK2TM400-1

Thermoplactic tape made of uni-directional carbon fiber and PEEK-matrix

PHYSICAL PROPERTIES	
Fiber areal weight (FAW)	145 g/m^2
Weight per ply (PAW)	221 g/m^2
Resin content by weight (RC)	34%
Consolidated ply thickness (CPT)	0.14 mm
Density	1.59 g/cm^3
Width	305 mm*

** Narrower widths are available through secondary slitting.*

For the availability of other reinforcements, please contact our sales team.

TECHNICAL SPECIFICATIONS				
Property	**Condition**	**Test Method**	**Results**	
Tensile strength 0°	RTD	ASTM D 3039	2410 MPa	350 ksi
Tensile Modulus 0°	RTD	ASTM D 3039	135 GPa	19.5 Msi
Tensile Strength 90°	RTD	ASTM D 3039	86 MPa	12.5 ksi
Tensile Modulus 90°	RTD	ASTM D 3039	10 GPa	1.4 Msi
Compressive Strength 0°	RTD	ASTM D 6641	1300 MPa	189 ksi
Compressive Modulus 0°	RTD	ASTM D 6641	124 GPa	18 Msi
Compressive Strength 0°	ETW(1)	ASTM D 6641	1210 MPa	176 ksi
Compressive Modulus 0°	ETW	ASTM D 6641	121 GPa	17.6 Msi
In-Plane Shear Strength ±45°	RTD	ASTM D 3518	152 MPa	22 ksi
In-Plane Shear Modulus ±45°	RTD	ASTM D 3518	5.2 GPa	0.75 Msi
Flexural Strength 90°	RTD	ASTM D 7264	152 MPa	22.0 ksi
Interlaminar Shear Strength (SBS) 0°/90°	RTD	ASTM D 2344	96.5 MPa	14 ksi

Open-Hole Tensile Strength	RTD	ASTM D 5766	386 MPa	56 ksi
Open-Hole Compressive Strength	RTD	ASTM D 6484	320 MPa	46 ksi
Compression After Impact Strength 30.5 J (270 in/lb) Impact Energy	RTD	ASTM D 7137	303 MPa	44 ksi
Mode I Interlaminar Fracture Toughness (GIC Strain Energy Release Rate)	RTD	ASTM D 5528	1.6 kJ/m^2	9.0 lb/in
Mode II Interlaminar Fracture Toughness (GIIC Strain Energy Release Rate)	RTD	ASTM D 7905	2.3 kJ/m^2	13.0lb/in

Fiber type AS4D
59% fiber by volume (Vf)
(1)ETW is tested at 82°C (180°F) after 14 days soaked in 71°C (160°F) water

► HANDLING PRECAUTIONS

Health and safety information on handling and processing of SK2TM400-1 is described in the Material Safety Data Sheet.

► STORAGE

Out life: indefinite at ambient temperature storage.
Frozen storage life: not applicable - product does not require freezing.

► GUARANTEE

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of the products, under their own conditions before commencing with the proposed application. We refuse any guarantee about the compatibility of a product with any particular application. We disclaim all responsibility for damage from any incident, which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

TECHNICAL DATA SHEET

SK4CV-1
Carbon veil

Back to range

► DESCRIPTION

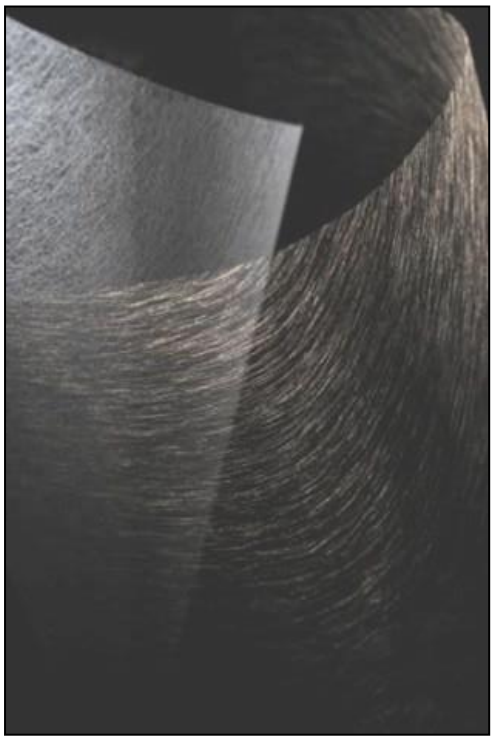
SK4CV-1 is a nonwoven carbon fibre veil with PVA binder that is made using a unique wet-forming process based on the principles of papermaking. It results in a very even distribution of fibres in the plane of the sheet.

Fibres are bonded with tailored levels of organic binders to optimise and use strength and flexibility. Binders can be selected for compatibility with the resin and may be soluble or insoluble in the resin to aid processing.

Veil applying surface engineering solutions to the problems encountered when using composites in highly demanding technical applications. This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	PAN Carbon
Fibre Length:	6mm and 12mm
Fibre diameter:	7µm
Binder:	PVA (Poly vinyl alcohol)
Max. roll width:	1650 mm
Min. roll width:	10 mm



SK4CV-1

Carbon veil

► SIZE

Areal weight	Thickness	Tensile strength MD [N/15 mm]	Tensile strength CD [N/15 mm]	MD Surface Resistivity [ohm/sq]	CD Surface Resistivity [ohm/sq]
8 g/m²	0,12mm	14	7	10	22
10g/m²	0,14mm	18	9	8	12
17g/m²	0,21mm	31	15	5	14
20g/m²	0,24mm	36	18	4	9
30g/m²	0,37mm	54	27	3	7
34g/m²	0,41mm	61	31	3	7

Reference to order	Areal weight	Width	Length
SK4CV-1BK8G100150	8 g/m²	1000mm	150
SK4CV-1BK10G100150	10g/m²	1000mm	150
SK4CV-1BK17G100150	17g/m²	1000mm	150
SK4CV-1BK20G100150	20g/m²	1000mm	150
SK4CV-1BK30G100150	30g/m²	1000mm	150
SK4CV-1BK34G100150	34g/m²	1000mm	150

Shelf life: unlimited. Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing, protected from direct sun and heat source.

► **NOTE**

Other values of areal weight till 400g are possible when the order exceeds 1000m². Please contact us for get information about MOQ for each product.

Surface resistivity is measured using a Vermason 75mm square contact block. The test sample size fits the contact blocks. There is no pressure applied to the sample during testing. Applied pressure would reduce the surface resistivity values.

TECHNICAL DATA SHEET

SK4CV-2
Carbon veil

Back to range

► DESCRIPTION

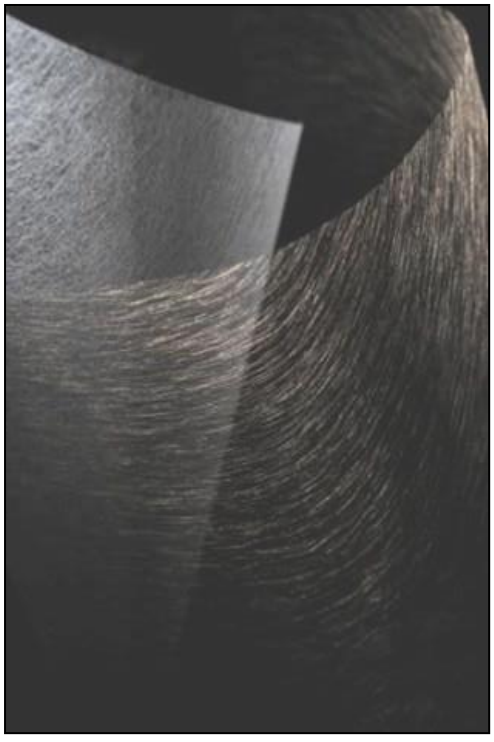
SK2CV-2 is nonwoven carbon fibre veil with styrene soluble polyester binder that is made using a unique wet-forming process based on the principles of papermaking. It results in a very even distribution of fibres in the plane of the sheet.

Fibres are bonded with tailored levels of organic binders to optimise and use strength and flexibility. Binders can be selected for compatibility with the resin and may be soluble or insoluble in the resin to aid processing.

Veil applying surface engineering solutions to the problems encountered when using composites in highly demanding technical applications. This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	Carbon
Fibre Length:	6 mm and 12mm
Fibre diameter:	7µm
Binder:	Styrene soluble polyester
Max. roll width:	1650 mm
Min. roll width:	10 mm



SK4CV-2

Carbon veil

► SIZE

Areal weight	Thickness	Tensile strength MD [N/15 mm]	Tensile strength CD [N/15 mm]	MD Surface Resistivity [ohm/sq]	MD Surface Resistivity [ohm/sq]
4g/m²	0,05mm	8	5	43	52
10g/m²	0,13mm	19	17	16	24
17g/m²	0,20mm	29	18	7	12
20g/m²	0,23mm	33	22	7	11
30g/m²	0,35mm	43	25	4	8
34g/m²	0,40mm	50	44	5	6

Reference to order	Areal weight	Width	Length
SK4CV-2BK4G100150	4g/m²	1000mm	150
SK4CV-2BK10G100150	10g/m²	1000mm	150
SK4CV-2BK17G100150	17g/m²	1000mm	150
SK4CV-2BK20G100150	20g/m²	1000mm	150
SK4CV-2BK30G100150	30g/m²	1000mm	150
SK4CV-2BK34G100150	34g/m²	1000mm	150

Shelf life: unlimited. Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing, protected from direct sun and heat source.

► **NOTE**

Other values of areal weight till 400g are possible when the order exceeds 1000m².

Please contact us for get information about MOQ for each product.

Surface resistivity is measured using a Vermason 75mm square contact block. The test sample size fits the contact blocks. There is no pressure applied to the sample during testing. Applied pressure would reduce the surface resistivity values.

TECHNICAL DATA SHEET

SK4CV-3

Carbon veil

Back to range

► DESCRIPTION

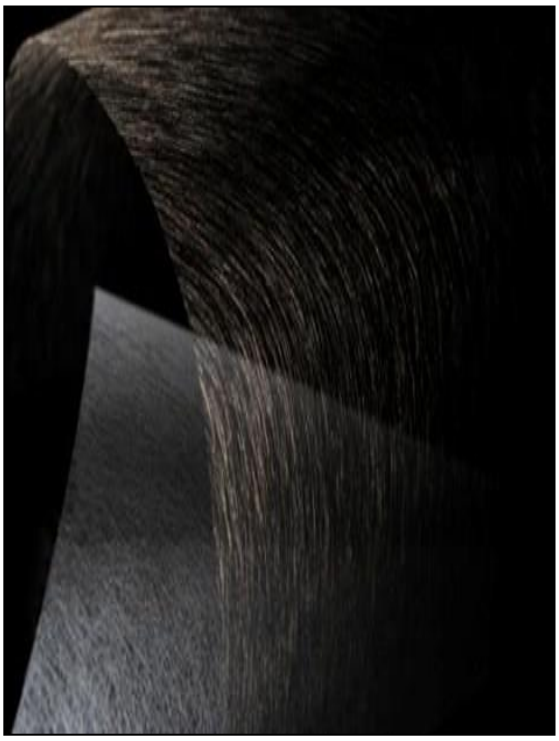
SK4CV-3 is a nonwoven carbon fibre veil with cross-linked polyester binder that is made using a unique wet-forming process based on the principles of papermaking. It results in a very even distribution of fibres in the plane of the sheet.

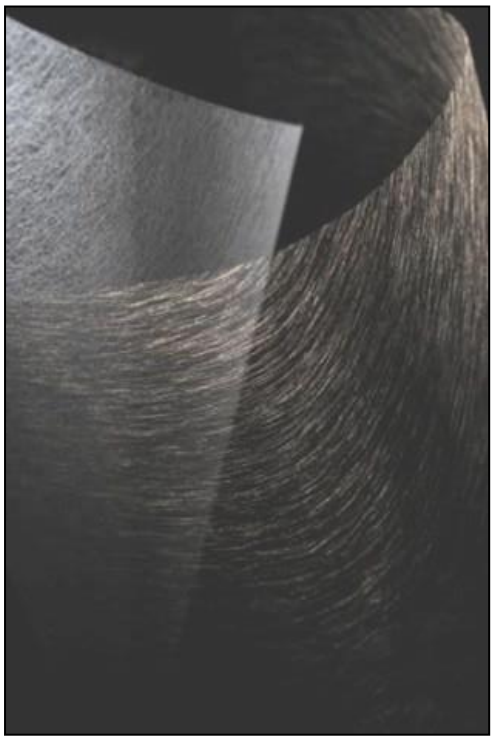
Fibres are bonded with tailored levels of organic binders to optimise and use strength and flexibility. Binders can be selected for compatibility with the resin and may be soluble or insoluble in the resin to aid processing.

Veil applying surface engineering solutions to the problems encountered when using composites in highly demanding technical applications. This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	Carbon
Fibre Length:	6mm and 12mm
Binder:	Cross-linked polyester
Max.roll width:	1650 mm
Min. roll width:	10 mm





► SIZE

Areal weight	Thickness	Tensile strength MD [N/15 mm]
10g/m²	0,14mm	15
12g/m²	0,16mm	18
20g/m²	0,25mm	33
24g/m²	0,42mm	52

Reference to order	Areal weight	Width	Length
SK4CV-3BK10G100150	10g/m²	1000mm	150
SK4CV-3BK12G100150	12g/m²	1000mm	150
SK4CV-3BK20G100150	20g/m²	1000mm	150
SK4CV-3BK24G100150	24g/m²	1000mm	150

Shelf life: unlimited. Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing, protected from direct sun and heat source.

► NOTE

Other values of areal weight till 400g are possible when the order exceeds 1000m².

Please contact us for get information about MOQ for each product.

Surface resistivity is measured using a Vermason 75mm square contact block. The test sample size fits the contact blocks. There is no pressure applied to the sample during testing. Applied pressure would reduce the surface resistivity values.

TECHNICAL DATA SHEET

SK4CV-4
Carbon veil

Back to range

► DESCRIPTION

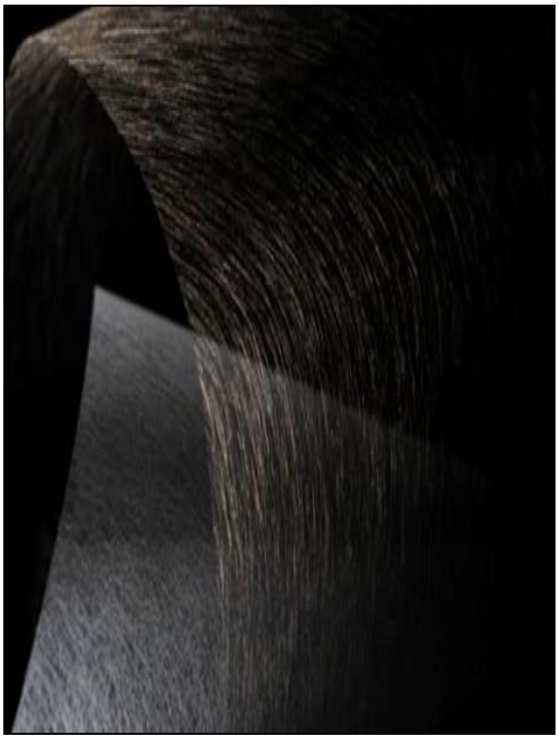
SK4CV-4 is a nonwoven carbon fibre veil with cross-linked styrene acrylic binder that is made using a unique wet-forming process based on the principles of papermaking. It results in a very even distribution of fibres in the plane of the sheet.

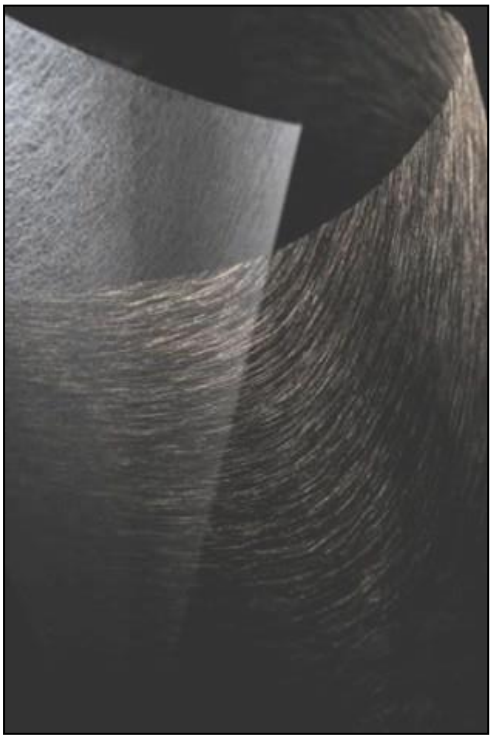
Fibres are bonded with tailored levels of organic binders to optimise and use strength and flexibility. Binders can be selected for compatibility with the resin and may be soluble or insoluble in the resin to aid processing.

Veil applying surface engineering solutions to the problems encountered when using composites in highly demanding technical applications. This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	PAN Carbon
Fibre Length:	12mm
Fibre diameter:	7µm
Binder:	Cross-linked styrene acrylic
Max. roll width:	1650 mm
Min. roll width:	10 mm





SK4CV-4

Carbon veil

► SIZE

Areal weight	Thickness	Tensile strength MD [N/15 mm]	Tensile strength CD [N/15 mm]	Surface Resistivity MD [ohm/sq]	Surface Resistivity CD [ohm/sq]
4g/m²	0,05mm	8	4	13	38
10g/m²	0,12mm	30	8	8	21
14g/m²	0,17 mm	40	14	7	11
17g/m²	0,20mm	46	24	5	9
34g/m²	0,40mm	70	38	3	4,4

Reference to order	Areal weight	Width	Length
SK4CV-4BK4G100150	4g/m²	1000mm	150
SK4CV-4BK10G100150	10g/m²	1000mm	150
SK4CV-4BK14G100150	14g/m²	1000mm	150
SK4CV-4BK17G100150	17g/m²	1000mm	150
SK4CV-4BK34G100150	34g/m²	1000mm	150

Shelf life: unlimited. Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing, protected from direct sun and heat source.

► NOTE

Other values of areal weight till 400g are possible when the order exceeds 1000m².
Please contact us for get information about MOQ for each product.
Surface resistivity is measured using a Vermason 75mm square contact block. The test sample size fits the contact blocks. There is no pressure applied to the sample during testing. Applied pressure would reduce the surface resistivity values.

TECHNICAL DATA SHEET

SK4GV-1

Carbon veil

Back to range

► DESCRIPTION

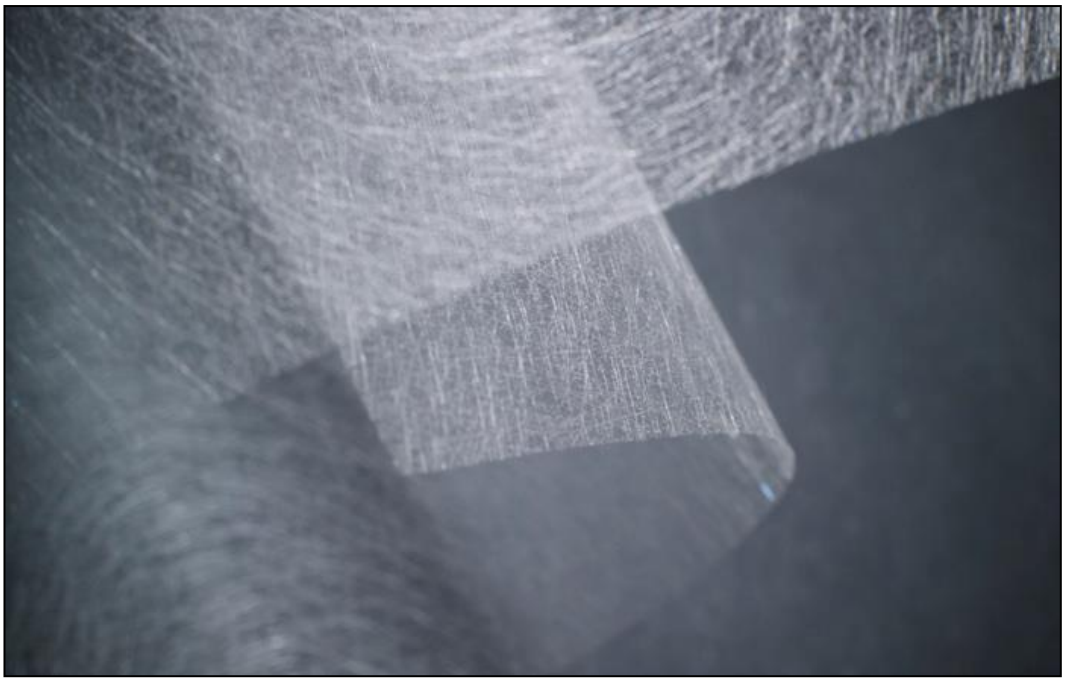
SK4GV-1 is a nonwoven E glass fibre veil, made using a unique wet-forming process based on the principles of papermaking, this results in a very even distribution of fibres in the plane of the sheet.

Fibres are bonded with tailored levels of organic binders to optimise end use strength and flexibility. Binders can be selected for compatibility with the resin and may be soluble or insoluble in the resin to aid processing.

The veils offer means of applying surface engineering solutions to the problems encountered when using composites in highly demanding technical applications. This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	E glass
Fibre length:	12 mm
Fibre diameter:	6µm and 11µm
Binder type:	PVA (Poly vinil alcohol)
Max. roll width:	1625 mm
Min. roll width:	10 mm
Roll length:	150 m



TECHNICAL DATA SHEET

SK4GV-1

Carbon veil

► SIZE

Areal weight	Fiber thickness [µm]	Thickness	Tensile strength MD [N/15 mm]
10g/m²	6	0,08mm	13
10g/m²	11	0,10mm	12
17g/m²	11	0,15mm	20
22g/m²	11	0,19mm	26
30g/m²	11	0,27mm	36
34g/m²	11	0,29mm	41
42g/m²	11	0,35mm	50
46g/m²	11	0,38mm	55
50g/m²	11	0,42mm	60
200g/m²	11	1,50mm	140

Reference to order	Areal weight	Width	Length
SK4GV-1WH10G100150T	10g/m²(6µm)	1000mm	150
SK4GV-1WH10G100150	10g/m²(11µm)	1000mm	150
SK4GV-1WH17G100150	17g/m²	1000mm	150
SK4GV-1WH22G100150	22g/m²	1000mm	150
SK4GV-1WH30G100150	30g/m²	1000mm	150
SK4GV-1WH34G100150	34g/m²	1000mm	150
SK4GV-1WH42G100150	42g/m²	1000mm	150

SK4GV-1WH46G100150	46g/m²	1000mm	150
SK4GV-1WH50G100150	50g/m²	1000mm	150
SK4GV-1WH200G100150	200g/m²	1000mm	150

Shelf life: unlimited. Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing, protected from direct sun and heat source.

► **NOTE**

Other values of areal weight are possible when the order exceeds 1000m².

Please contact us for get information about MOQ for each product.

Surface resistivity is measured using a Vermason 75mm square contact block. The test sample size fits the contact blocks. There is no pressure applied to the sample during testing. Applied pressure would reduce the surface resistivity values.

TECHNICAL DATA SHEET

SK2TM200-1

Powdered mandrel material

Back to range

► DESCRIPTION

SK2TM200-1 is a powdered mandrel material, which is easily mixed with water. It may be poured or injected into molds to form complex mandrels for composite lay-ups. Material is readily soluble in cold tap water and formulated to minimize air bubbles and voids. It can easily be washed away from the finished part.

SK2TM200-1 saves time, labor and the wash-away feature minimizes the possibility of damaging fine details.

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

Benefits

- Easily mixed with water
- Makes complex part manufacturing simple
- Pourable and injectable
- Easily dried in a convection oven
- Environmentally friendly, no special
- Easily repaired and re-formed disposal procedures required
- Reduces labor
- Washes away in cold tap water
- Saves money
- Compatible with all commercial resins
- Saves time prepreg compounds

Aquaseal is recommended to seal the tool and prevent resin migration.

► TECHNICAL DATA

Material type:	Powder
Color:	White
Compressive strength:	596 ± 46 pci (pound per cubic inch) at 21°C
Density Dry:	573,46 kg/m³
Coefficient of Thermal Expansion:	3.6 x 10^{-6} mm/mm°C

Drying at 120 to 135°C for 1.5 hour per inch of thickness in a hot air convection oven. Drying time can vary depending on geometry and size, you can control this by measuring weight loss in certain time steps.

► SIZE

Volume	Weight
5 Gal (18,9 L)	Pail, Ø 330 x 380mm, 7 kg
55 Gal (208 L)	Drum, Ø 600 x 930mm, 77 kg

► WATERSOLUBLE MANDREL PROCESS

Shelf life: 24 months

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► **NOTE**

Please contact us for getting special manufacturing guide with involved techniques and properties of the product.

TECHNICAL DATA SHEET

SK2TM200-2

Core material ready to use

Back to range

► DESCRIPTION

SK2TM200-2 is a new high-temperature, water soluble fugitive core material. It is supplied as a moist powder which is machined, molded or hand shaped to the desired geometry and dried at 93°C. With a specific gravity of 0.45 wet, it is lightweight, easily machined, and thermally stable. SK2TM200-2 is compatible with most commercial epoxy and cyanate resin ester systems with cure temperatures below 193°C. It can be dissolved away from the cured composite quickly using tap water, and the effluent is nontoxic.
Unlike conventional mandrel materials, which must be tediously removed from composite lay-ups, SK2TM200-2 mandrel is readily soluble in cold tap water and can easily be washed away from the finished part. It saves time, labor and the wash-away feature minimizes the possibility of damaging fine details.

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

Benefits

- Washes out in cold tap water in minutes
- Environmentally friendly
- Nontoxic and odorless
- Remove mandrel from previously
- Reduces labor and saves money
- Compatible with all commercial resins and disposal procedures required prepreg compounds
- Makes complex part manufacturing simple
- Strong and lightweight
- Easily repaired and re-formed
- Saves time inaccessible hidden areas
- Easily dried in a convection oven

It is recommended to seal the tool with SK2TM200-4 to prevent resin migration.

► TECHNICAL DATA

Material type:	Powder
Color:	White
Density Dry:	1500 -2000 psi
Coefficient of Thermal Expansion:	5 x 10^{-6} mm/mm°C

Drying at 120 to 135°C for 1.5 hour per inch of thickness in a hot air convection oven. Drying time can vary depending on geometry and size, you can control this by measuring weight loss in certain time steps.

► SIZE

Volume	Weight
5 Gal (18,9 L)	Pail, Ø 330 x 380mm, 8,51 kg
55 Gal (208 L)	Drum, Ø 600 x 930mm, 93,61 kg

Shelf life: 24 months
Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

► NOTE

Please contact us for getting special manufacturing guide with involved techniques and properties of the product.
SK2TM200-2 is also available in machinable, pre-formed, dried blocks in virtually any size.

Please contact for more details about ordering mandrels in your shape and size.

TECHNICAL DATA SHEET

SK2TM200-4

Spray-/brushable seal for mandrel

Back to range

► DESCRIPTION

SK2TM200-4 has been specially formulated to seal the water-soluble mandrel materials Aquacore and Aquapour. It provides a smooth, nonporous finish on the surface of a mold or tool and inhibits the migration of resins into the porous tool during the lay up or RTM process. SK2TM200-4 is compatible with the core temperatures of commercial resins and pre-preg compounds up to 193°C and washes away in minutes with tap water. SK2TM200-4 may be applied with a spray gun or brush. Several coats should be applied. It should be applied evenly over the entire part so as to prevent cracking of the mandrel. We have added an environmentally safe blue dye to aid in detecting how well the sealer is applied. After achieving the desired finish, SK2TM200-4 is thermally stable up to 193°C. To remove, simply wash away mandrel material and sealer with plain tap water. SK2TM200-4 is environmentally friendly; no special disposal procedures are required.

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

► TECHNICAL DATA

Material type:	Liquid
Color:	Blue

► SIZE

Volume	Weight
1Quart (0,95 L)	Pail, Ø 90 x 260mm, 1kg
1Gal (3,8 L)	Pail, Ø 160 x 310mm, 4kg

Shelf life: 12 months

Storage conditions: it is recommended to store at temperature from +15°C until +25°C in the original packing.

► NOTE

Please contact us for getting special manufacturing guide with involved techniques and properties of the product.

TECHNICAL DATA SHEET

SK2TM200-7

Block for manufacturing of mandrel

Back to range

► DESCRIPTION

SK2TM200-7 – water soluble block, prefabricated, pressed and dried, vacuum sealed to avoid moisture uptake for manufacturing of mandrel. The block is made from the powder SK2TM200-1 (Aquapour). Bondable to thicker constructions.

► TECHNICAL PROPERTIES

- Water soluble material
- Prefabricated, pressed and dried
- Vacuum sealed to avoid moisture uptake
- Bondable to thicker constructions
- Colour: light grey
- Ready to use
- Machineable
- Various thickness available
- Other dimensions on request

STANDARD SIZES	
Article	Dimensions
88050	620 x 620 x 50 mm (19.22 Litre)
88055	620 x 620 x 80 mm (30.75 Litre)
88060	620 x 620 x 100 mm (38.44 Litre)
88065	620 x 620 x 120 mm (46.13 Litre)
88070	620 x 620 x 150 mm (57.66 Litre)
88075	620 x 620 x 200 mm (76.88 Litre)

► BASIC DATA FOR MACHINING AQUA BLOCKS

	Speed	Feed	Cutting depth
Roughing	5'000 U/min	1524mm	5.0mm
Finishing	8'000 U/min	635mm	0.13mm

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.

Notes: This data is given as a guide only. If a complex shape operator should adjust accordingly. Contact us for your specific manufacturing requirements.

► GARANTY

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of the products, under their own conditions before commencing with the proposed application. We disclaim all responsibility for damage from any incident, which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

TECHNICAL DATA SHEET

SK2TM200-9

Paste for filling, bonding or patching

Back to range

► DESCRIPTION

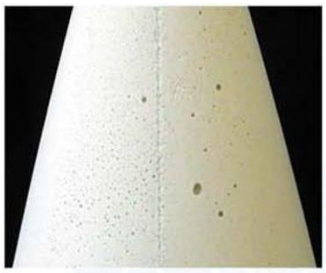
SK2TM200-9 has been specially formulated to fill, bond or patch the watersoluble mandrel materials SK2TM200-1, SK2TM200-2 and SK2TM200-7.

Once applied, SK2TM200-9 will give the surface of the mandrel a smooth porcelain-like feel.

SK2TM200-9 will be delivered in three parts and is easy to mix.

Once the mandrel has been formed and dried in a convention oven, SK2TM200-9 can be applied easily with a rubber squeegee, such as those used in autobody applications.
SK2TM200-9 takes slightly longer to washout than SK2TM200-1 and SK2TM200-2 but it is completely environmentally friendly and requires no special procedures for disposal.

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



► SIZE

Volume
1Quart (0,95 L)
1Gal (3,8 L)

► STORAGE CONDITIONS

It is recommended to store at temperature from +15°C until +25°C in the original packing.
Shelf life of unmixed separate components is 12 months.
Pot-life of mixed components is 3 months.

MATERIALS FOR VACUUM LINES			
Name	**Description**	**Max. use T°C**	**Color**
AIRVIK-1	Spray adhesive with high epoxy compatibility for tissue positioning	-	Transparent
AIRVIK-5	Adhesive spay for temporary bonding in resin infusion process	-	Blue
AIRVIK-9	Strong tack aerosol adhesive for multipurpose temporary positioning of layers	-	Variable (straw, green, blue)
SK2RIM000-1	Resin line clamp	-	-
Squeezee	Tube clip for control and stop of each resin line separately. Max. Diameter of pinched tube: 15mm	120°C	Steel, Blue
Squeezer	Tube clip for control and stop of each resin line separately. Max. Diameter of pinched tube: 25mm	120°C	Steel, Blue
SK2RIM000-8	Resin infusion adapter	180°C	Aluminium, Grey
SK2RIM000-9	Resin infusion adapter with conical tube connection	180°C	Aluminium, Grey
SK2RIM000-10	Threaded fitting with core for resin inlet tubes in injection process	-	-
SK2RIM000-11	Clamping ring for resin inlet tubes in injection process	-	-
LOW TEMPERATURE MATERIALS FOR VACUUM / RESIN LINES			
Name	**Description**	**Max. use T°C**	**Color**
MTI hose	Vacuum manifold in permeable casing	80°C	Translucent/ White
SK2RIM000-4	Low temperature resin infusion connector	90°C	White
SK2RIM000-7	Resin infusion valve	70°C	Black/ Red
SK2RIM90-1	Low temperature polyethylene spiral wrap	120°C	Translucent
SK2RIM90-2	Polyethylene tube for low temperature resin infusion	120°C	White
SK2RIM90-3	L-Fittings for low temperature resin infusion	120°C	White

SK2RIM90-4	T-Fittings for low temperature resin infusion	120°C	White
SK2RIM90-10	I-fittings for low temperature resin infusion	120°C	White
SK2RIM120-3	Low print belt	120°C	White
SK2RIM120-5	Omega Line for resin inlet	120°C	White
SK2RIM120-6	Resin and vacuum tube	150°C	White
SK2RIM120-9	Omega line for resin inlet with perforated panel	120°C	White
SK2STK-90	Starter kit for low temperature vacuum resin infusion process	90°C	-
SK1MOV-KITMINI	Portable starter kit for educating organizations	-	-

HIGH TEMPERATURE MATERIALS FOR VACUUM / RESIN LINES			
Name	**Description**	**Max. use T°C**	**Color**
SK2RIM000-2	High temperature resin infusion connector	260°C	White
SK2RIM000-3	High temperature PA resin infusion connector	180°C	White
SK2RIM175-1	Polyamide spiral wrap for high temperature resin infusion process	190°C	White translucent
SK2RIM175-2	Polyamide tube	190°C	White
SK2RIM180-3	L-Fittings for high temperature resin infusion	190°C	White
SK2RIM180-4	T-Fittings for high temperature resin infusion	190°C	White
SK2RIM180-5	I-Fittings for high temperature resin infusion	190°C	White
SK2RIM180-8	X-Fitting for high temperature resin infusion	190°C	White
SK2RIM180-9	Y-Fitting for high temperature resin infusion	190°C	White
SK2RIM180-10	Adapter fittings for high-temperature vacuum infusion	190°C	White
SK2RIM250-2	Silicone pressure tubing reinforced with glass fibers	250°C	Transparent

SK2RIM260-1	Heat resistant tube	260°C	Translucent
SK2RIM260-2	High temperature silicone tube reinforced with polyester fibers for high temperature resin infusion and RTM-process	260°C	Transparent
SK2RIM260-4	High temperature silicone cord for mold sealing in RTM process	260°C	Translucent
SK2RIM260-5	Heat resistant hard silicone tube	260°C	Translucent
SK2RIM260-10	Silicone omega flow line	260°C	White
SK2STK180	Starter kit for high temperature vacuum resin infusion process	180°C	-

RESIN DISTRIBUTION MESH			
Name	**Description**	**Max. use T°C**	**Color**
SK2COM115-1	Two layers combined product	121°C	Yellow / Blue
SK2RIM115-1	Soft high drapable woven resin distribution mesh for low temperature resin infusion process	125°C	Yellow
SK2RIM120-1	Extruded mesh for resin distribution	150°C	Green
SK2RIM120-2	Low profile mesh for accelerated distribution in low temperature resin infusion process	150°C	Green
SK2RIM120-4	Heavy resin distribution mesh, 250g/m²	120°C	Green/ Black
SK2RIM125-1	Sewed tubular mesh	125°C	Yellow
SK2RIM125-4	Woven heavy resin distribution mesh	125°C	Green
SK2RIM180-1	Soft resin distribution mesh, available with black tracer treads	190°C	White available with black tracer treads
SK2RIM180-2	Resin distribution tape for high temperature resin infusion process	180°C	White
SK2RIM180-6	Rigid woven distribution mesh for high temperature resin infusion process	180°C	White
SK2SPIRMESH 90-1	Sewed tubular mesh with spiral wrap	90°C	Green

TECHNICAL DATA SHEET

AIRVIK-1

Spray adhesive with high epoxy compatibility for tissue positioning

Back to range

► DESCRIPTION

AIRVIK-1 is a solvent-based spray adhesive for high temperature processes with high epoxy compatibility, formulated with special synthetic resins that do not compromise the aesthetic and functional resistance of the product.
It is suitable for tissue positioning (carbon, glass, kevlar), in infusion, R.T.M., PREPREG, R.F.I. processes. The application of the appropriate quantity of AIRVIK-1 does not affect the thermosetting of the resin and structural integrity.
Due to the resins chemicals variants, we suggest to test the materials and bonding techniques before definitive use.

AIRVIK-1 is suitable for:

- all cases where epoxy resins are used
- the positioning of multiple layers of fiberglass, carbon, kevlar and other fabrics
- the positioning of prepreg fabrics and epoxy resin's film
- bonding of fabrics with plastic films
- block fabric textures to facilitate cutting operations

► CHEMICAL COMPOSITION

Special resins in solvent solution.

► INSTRUCTIONS FOR USE

- Shake well before use and during the craftwork time.
- The materials to bond must be cleaned and dry, without dusty residues.
- Apply a layer of product on the support(s) from a distance of 10/20 cm.
- For the positioning of fabrics on layers, wait for evaporation of solvents (from few seconds to 1 minute) depending on temperature and humidity.
- Apply pressure to join the parts.
- Wait for the total evaporation of the solvents before sealing the bag, close the mould and inject the resin.

AIRVIK-1

Spray adhesive with high epoxy compatibility for tissue positioning

► HARDENING TIME

The complete bonding process needs 24/48 h.

► MAINTENANCE

Any fresh or hardened adhesive residues can be removed with special solvents.

► ADVANTAGES

- High epoxy resins compatibility
- No yellowing and reaction, even during cooking at high temperatures up to 200°C
- It forms a highly transparent adhesive film without defects showing
- Developed to avoid gasification defects during the cross-linking and cooking process
- Spray aerosol with modular 3-position valve (L-M-H)
- Strong bonding with a low product quantity

► PACKAGING

AIRVIK-1 is available in 500 ml spray cans. Minimum order quantity: box of 12 cans.

► STORAGE AND LIFE

Storage temperature of AIRVIK-1 is between +15°C and +30°C.
The cans of AIRVIK-1 can be stored in its box for a maximum of 12 months.

► SAFETY

Please, refer to the material Safety data sheet (MSDS).

► GUARANTEE

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of our products, under their own conditions before commencing with the proposed application. We refuse any guarantee about the compatibility of a product with any particular application. We disclaim all responsibility for damage from any incident which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

TECHNICAL DATA SHEET

AIRVIK-5

Positioning adhesive for core fabrics and materials for compounds

Back to range

► DESCRIPTION

AIRVIK-5 is a temporary adhesive for positioning fiberglass and carbon fabrics in the manufacture of compound materials (polyester resin, vinyl-ester and epoxy) using the vacuum infusion method. AIRVIK-5 is formulated with raw materials that are perfectly compatible with infusion process resins, and it quickly dissolves in them without affecting the polymerization kinetics, or altering the final mechanical properties of the product. Even an excessive amount of adhesive does not interfere with the interlaminar adhesion of the fabrics.
The amount of AIRVIK-5 to apply depends on the type of surface and weight of the fabric. Non- absorbent surfaces, like Gel Coat or glass resin moulds, only require a small amount of AIRVIK-5. Porous and very absorbent surfaces, like fiberglass fabrics (biaxial, coupled) require around 1 kg for 60-100 m2. In this type of use, a spray can cover a surface of 15-25 m2.
AIRVIK-5 contains a blue colorant, to make it easier to modulate the applied quantity, which then disappears during polymerization.

► INSTRUCTIONS FOR USE

From a distance of approx. 20 or 30 cm, apply an even layer of AIRVIK-5 on one or both of the surfaces being coupled. The time AIRVIK-5 needs to develop all its adhesive properties depends on the environmental conditions and the applied thickness: generally, between 30 seconds and a few minutes. After this time, the fabric should be positioned so that it adheres perfectly to the layer beneath, and then repeat the operation for all the subsequent layers that are needed.
The fabric can still be positioned for a few minutes after the first application. The amount of AIRVIK-5 to apply depends on the type of surface and weight of the fabric in question. Use AIRVIK-5 in well ventilated surroundings, using suitable protective equipment.

► PACKAGING

AIRVIK-5 is available in 500 ml spray cans. Minimum order quantity: case of 12 cans.

► STORAGE AND LIFE

If AIRVIK-5 is stored in the original packaging at a temperature between +15°C and +25°C, it has a life of 24 months from the date of production. DO NOT heat the can up to temperatures above 50°C.

TECHNICAL DATA SHEET

AIRVIK-9

Strong tack aerosol adhesive for multipurpose temporary positioning of layers

Back to range

► DESCRIPTION

AIRVIK-9 is a solvent-based temporary aerosol adhesive with elastomers and synthetic resins. It is suitable for tissue positioning (PU - PVC - PET and others), in infusion, R.T.M., R.F.I., PREPREG processes. The application of the appropriate quantity of AIRVIK-9 does not affect the thermosetting of the resin and structural integrity.
Due to the resins chemicals variants, we suggest to test the materials and bonding techniques before definitive use.

AIRVIK-9 is suitable for:

- the positioning of fiberglass, carbon, kevlar and other fabrics
- the positioning of foams as PU, PVC, PET and more
- the positioning of multiple layers of fabrics and foams horizontally, vertically and upside-down
- the positioning of multiple layers even of different foams
- the positioning of multiple layers of plywood to foams.
  the positioning of fabrics with different plastic films
- block fabric textures to facilitate cutting operations.

► CHEMICAL COMPOSITION

Elastomers and synthetic resins in solvent solution.

► INSTRUCTIONS FOR USE

- Shake well before use.
- The materials to bond must be cleaned and dried, without dusty residues.
- Apply a layer of product on the support(s) from a distance of 10/20 cm.
- To join the fabrics on surfaces, wait the solvent evaporation. The timing can be from 10 second to 2 minutes, depending on temperature.
- For the positioning of foams, woods and fabrics on layers, wait for the solvents evaporation (from 30 seconds to 10 minutes) depending on temperature and the gluing needs.
- Applying pressure to join the parts.

TECHNICAL DATA SHEET

AIRVIK-9

Strong tack aerosol adhesive for multipurpose temporary positioning of layers

► HARDENING TIME

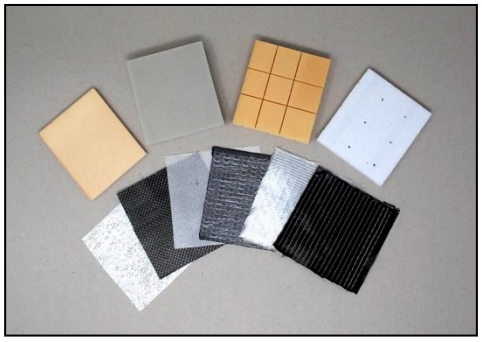
The complete bonding process needs 24/48 h.

► MAINTENANCE

Any fresh or hardened adhesive residues can be removed with solvents.

► ADVANTAGES

- Practical aerosol spray dispenser
- High dry residue
- High coverage
- Fast production process



Some compatible materials

► PACKAGING

AIRVIK-9 is available in 500 ml spray cans. Minimum order quantity: box of 12 cans

► STORAGE AND LIFE

AIRVIK-9 is stored in the original packaging at a temperature between +15°C and +30°C.
The cans of AIRVIK-9 should be stored in its box for a maximum of 12 months.

► SAFETY

Please, read carefully the Safety data sheet. The can is under pressure.
It should be stored in a cool and dry place at a temperature not exceeding 50°C.
Do not smoke during use.

► GUARANTEE

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of our products, under their own conditions before commencing with the proposed application. We refuse any guarantee about the compatibility of a product with any particular application. We disclaim all responsibility for damage from any incident which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

TECHNICAL DATA SHEET

SK2RIM000-1

Resin line clamp

Back to range

► DESCRIPTION

The clamp can be used in resin infusion process for clamp each hoses separate to stop the flow of resin. The surface is special treated to make the clamp not slippery. The pliers can be adjusted depend of the size of the tube you are using.

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

► TECHNICAL DATA

Material type:	Nickel plated steel
Plier length:	20 cm
Flange width:	8 cm
Weight:	495g

Shelf life: not limited.
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

TECHNICAL DATA SHEET

Squeezee®

Tube clip for control or stop of feeding line

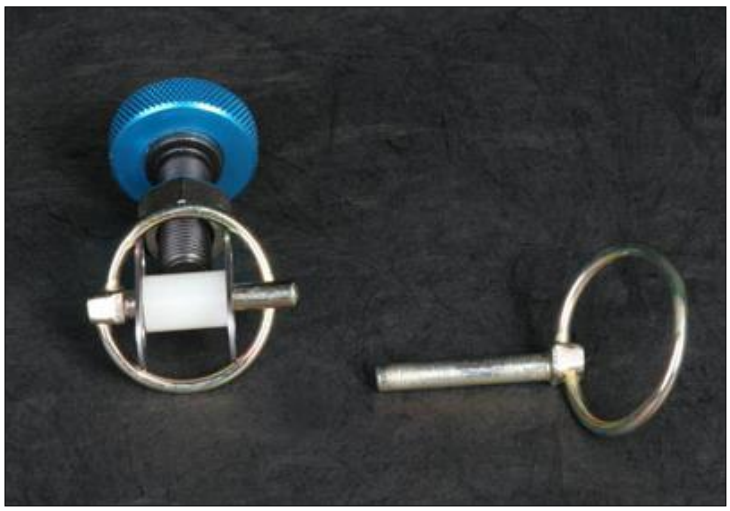
Back to range

► DESCRIPTION

The tube clip of DD-Compound is the solution for adjusting the resin flow and disconnecting resin- and vacuum lines. The tube clip will convince by the easy use and exact dosing of the resin flow. Squeezee® allows disconnecting the resin feed line without much force. The tube clip is suitable for different kind of tubes with an outer diameter up to 15mm. Because of the solid construction, Squeezee® is suitable fort the everyday, industrial use.

► TECHNICAL DATA

Material:	Steel, aluminum, polyoxymethylen
Resin type:	Epoxy, polyester
Outer diameter of resin feed line:	up to 15 mm
Color:	Steel, blue
Use temperature:	120°C



Shelf life: not limited
Storage conditions: it is recommended to store at temperatures between -20°C and +30°C in original packing.

► NOTE

MOQ 10 pce.

TECHNICAL DATA SHEET

Squeezer®

Tube clip for control or stop of feeding line

Back to range

► DESCRIPTION

The tube clip Squeezer® of DD-Compound is the solution for adjusting the resin flow and disconnecting resin- and vacuum lines. The tube clip will convince by the easy use and exact dosing of the resin flow. Squeezer® allows disconnecting the resin feed line without much force. The tube clip is suitable for different kind of tubes with an outer diameter up to 25mm. Because of the solid construction, Squeezer® is suitable fort the everyday, industrial use.

► TECHNICAL DATA

Material:	Steel, aluminum, polyoxymethylen
Resin type:	Epoxy, polyester
Outer diameter of resin feed line:	up to 25 mm
Color:	Steel, blue
Use temperature:	120°C

Shelf life: not limited
Storage conditions: it is recommended to store at temperatures between -20°C and +30°C in original packing.

► NOTE

MOQ 5 pce.

TECHNICAL DATA SHEET

SK2RIM000-8

Infusion adapter

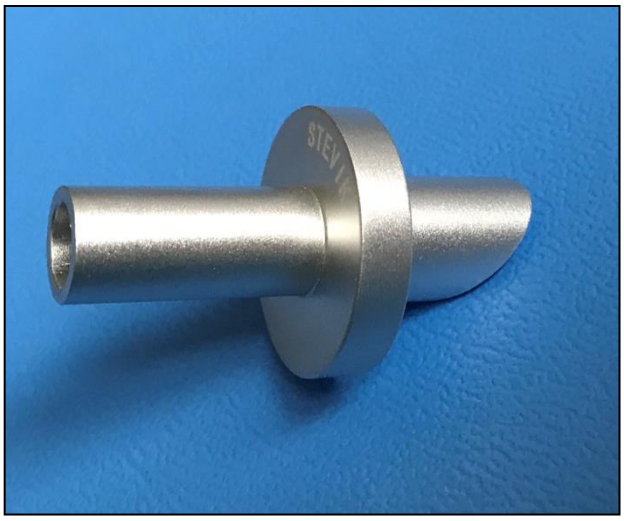
Back to range

► DESCRIPTION

SK2RIM000-8 – cosy adapter for resin infusion for connect resin inlet tube and resin infusion connector. Its sharp edge punches easily vacuum bag and matches with infusion connector (SK2RIM000-2, SK2RIM000-3 и SK2RIM000-4), other tube end can be used for connection of vacuum tube or resin inlet tube. The product provides simplified connection and sealing of silicone tube.
It is recommended to apply release agent on adapter surface before using.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	Aluminum
Max. working T:	180°C



► SIZE

Reference	Outside diameter	For tube with inside diameter
SK2RIM000-8RIA	10 mm	10mm PE 7-10mm silicone

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures between +10°C and +30°C in original packing.

► NOTES

MOQ – 1pce.

TECHNICAL DATA SHEET

SK2RIM000-9

Infusion adapter with conical connection

Back to range

► DESCRIPTION

SK2RIM000-9 – cosy adapter with conical connection for resin infusion for connect resin inlet tube and resin infusion connector. Its sharp edge punches easily vacuum bag and matches with infusion connector (SK2RIM000-2, SK2RIM000-3 и SK2RIM000-4), other tube end can be used for connection of vacuum tube or resin inlet tube. The product provides simplified connection and sealing of silicone tube.
It is recommended to apply release agent on adapter surface before using.

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

► TECHNICAL DATA

Material type:	Aluminum
Max. working T:	180°C

► SIZE

Reference	Outside diameter	For tube with inside diameter
SK2RIM000-9	Conical from 9 to 11mm	7-11mm silicone

Shelf life: unlimited
Storage conditions: it is recommended to store at temperatures T=20°C (+/-10°C).

► NOTES

MOQ – 1pce.

Maximum use temperature should be determined in actual process conditions.

TECHNICAL DATA SHEET

SK2RIM000-10

Threaded fitting with core for resin inlet tubes in injection processes

Back to range

► DESCRIPTION

Steel fitting with threaded connection once side and barbed connection other side connect inlet reinforced tube SK2RIM260-2 in injection processes by resin transfer under pressure into the mold. The clamping ring SK2RIM000-11 should be use to secure connection of fitting and tube.
This product is used in various manufacturing processes of parts made of composite materials.

► SIZE

Reference for order	Treaded size	Barbed side
SK2RIM000-10NPT1/4C	NPT 1/4 inch conical	I.D. Ø7 mm tube
SK2RIM000-10BSP1/4	BSP 1/4 inch	I.D. Ø7 mm tube

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from +10°C until +30°C in original packing.

► NOTE

MOQ is 50 pce
Other sizes and treaded size are available on special order.

TECHNICAL DATA SHEET

SK2RIM000-11

Clamping ring for resin inlet tubes in injection process

Back to range

► DESCRIPTION

The clamping ring is developed specially for securing of connection between core barbed part of the fitting SK2RIM000-11 with feeding silicone reinforced tube SK2RIM260-2 in injection processes by resin transfer under pressure into the mold.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	Galvanised steel
Clamping area:	Ø11 - 17mm
Thread length:	25mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from +10°C until +30°C in original packing.

► NOTE

MOQ is 50 pce
Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2RIM000-7

Resin infusion valve

Back to range

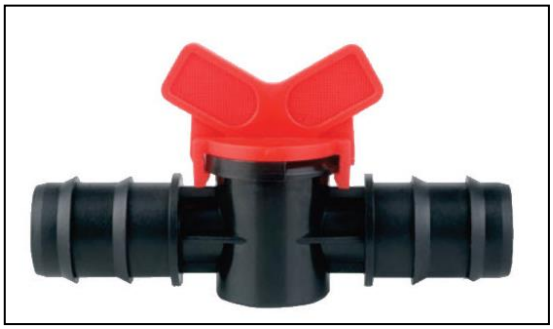
► DESCRIPTION

Resin infusion valve with two fittings which can connected with tubes with internal diameter of approx. 10 mm (3/8 inches) for stop of resin during the resin inlet.

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

► TECHNICAL DATA

Material type:	POM
Color:	Red and black
Maximum use temperature:	70°C



► SIZE

Reference for order	Outside diameter	For tube with internal diameter
SK2RIM000-7RIV	3/8 inch	10mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from +10°C until +30°C in original packing.

► NOTE

MOQ is 20 ea.

TECHNICAL DATA SHEET

MTI® hose

Vacuum manifold in permeable casting

Back to range

► DESCRIPTION

MTI® hose produced by DD|Compound consists of evacuation spiral wrap, non-woven and an air permeable membrane. The sandwich construction leads to optimize the evacuation process and quality. Thus, this tube will minimize costs using the vacuum infusion process. By using of MTI® hose guarantees the complete impregnation of the fabric. The resin allocation can be arranged independently from the tube, so it is possible to manufacture complex fiber parts by vacuum infusion. MTI® hose can be located directly on the fiber part, e.g. at critical points of fields with material accumulation (thicker layers).

Advantages:

- Less effort for preparing the infusion process
- No resin trap necessary
- Few investment cost
- Visible infusion process
- Minimize of resin consumption
- Resin allocation independent from evacuation hose
- Small molding flanges
- Complete impregnation of the fabric
- More process stability for single piece production and small series
- Minimize material consumption
- High fiber to volume ratio, adjustable through injected resin volume

► TECHNICAL DATA

Material type:	Polyethylene spiral tube in membrane casing
Color:	Translucent/ white
Use temperature:	80°C

► SIZE

Inside diameter	Packaging
8mm	100m/roll

MTI® hose

Vacuum manifold in permeable casting

Shelf life: not limited
Storage conditions: it is recommended to store at temperatures between -20°C and +30°C in original packing.

► **NOTE**

MOQ is 12 rolls.

TECHNICAL DATA SHEET

SK2RIM000-4

Low temperature resin infusion connector

Back to range

► DESCRIPTION

Low temperature polyethylene infusion connector can be used in resin infusion process for resin inlet or for connection of vacuum manifold.

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

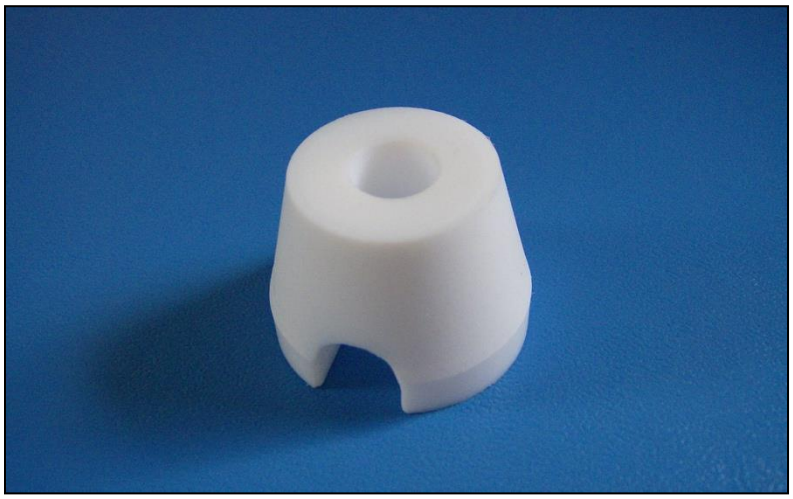
► TECHNICAL DATA

Material type:	PE
Color:	White
Maximum use temperature:	90°C

► SIZE

Tube connection	Spiral tube connection
Ø=12-13mm	Ø=12-13mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.



► NOTE

Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2RIM90-1

Spiral wrap

Back to range

► DESCRIPTION

Spiral wrap is produced from PE with additional modification for increasing of protective, isolation and anticorrosive properties. The main application areas are:

- Vacuum manifold function by Resin Infusion Process;
- Association of cables in lines;
- Protection of cables against a friction, mechanical damages;
- Protection of cables against influence of ultra-violet irradiation.

► TECHNICAL DATA

Material type:	PE
Color:	Translucent
Recommended use temperature:	90°C
Maximum use temperature:	120°C

► SIZE

Inside diameter	Outside diameter	Packaging
8mm	10mm	30m/roll
10mm	12mm	30m/roll

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 1 roll. Other diameters, lengths and colors are available on special order.

TECHNICAL DATA SHEET

SK2RIM90-2
Polyethylene tube

Back to range

► DESCRIPTION

Tube is produced from PE for using in resin infusion process for creation of vacuum channels and resin inlet channels.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	PE
Color:	Translucent
Recommended use temperature:	90°C
Maximum use temperature:	120°C

► SIZE

Inside diameter	Outside diameter	Packaging
8mm	10mm	30m/roll
10mm	12mm	30m/roll
17mm	19mm	30m/roll

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 1 roll. Other diameters, lengths and colors are available on special order.

* Maximum use temperature should be determined in actual process conditions and is dependent upon the operational mode and the exposure time and is process specific, we recommend testing prior to use.

TECHNICAL DATA SHEET

SK2RIM90-3

L-Fitting

Back to range

► DESCRIPTION

Barb coupling L-fitting developed for using in low resin infusion process.

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

► TECHNICAL DATA

Material type:	PP
Color:	White
Recommended use temperature:	90°C
Maximum use temperature:	120°C

► SIZE

Reference for order	Outside diameter	For tube with internal diameter
SK2RIM90-3WH88L	8mm x 8mm	8mm
SK2RIM90-3WH1010L	10mm x 10mm	10mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 20 ea.
Other sizes: 1/2” x 1/2” and 5/8” x 5/8” are available on special order.

SK2RIM90-4

T-Fitting

Back to range

► DESCRIPTION

Barb coupling T-fitting developed for using in low resin infusion process.

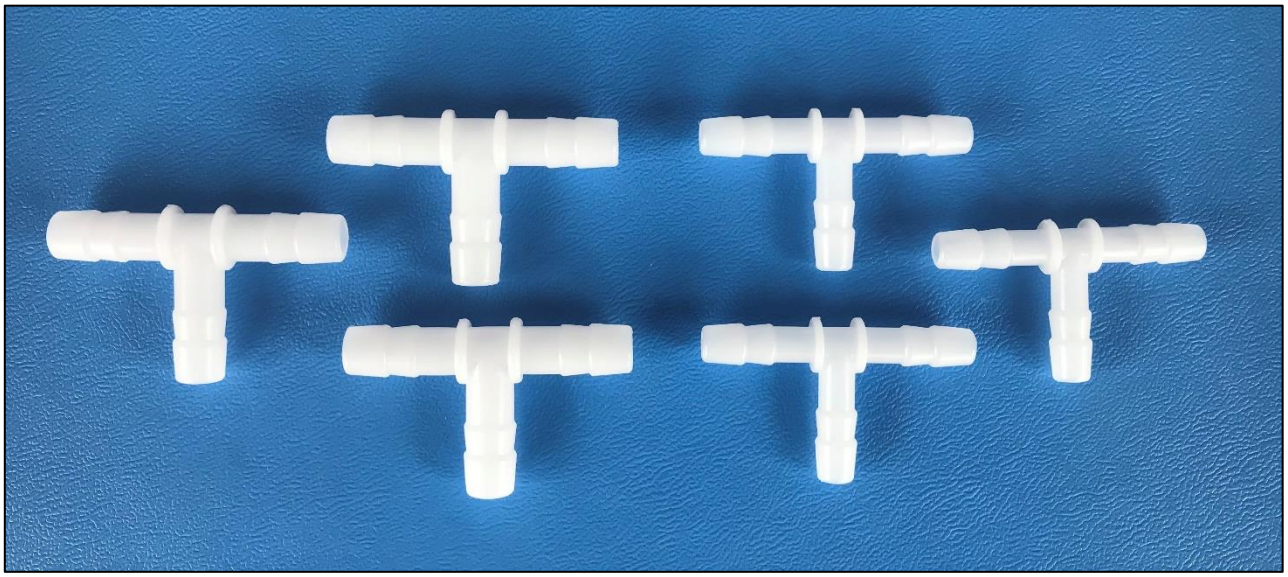
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	PP
Color:	White
Recommended use temperature:	90°C
Maximum use temperature:	120°C

► SIZE

Reference for order	Outside diameter	For tube with internal diameter
SK2RIM90-4WH888T	8mm x 8mm x 8mm	8mm
SK2RIM90-4WH101010T	10mm x 10mm x 10mm	10mm



Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► **NOTE**

MOQ is 100 ea.
Other sizes: 1/2” x 1/2” x 1/2” and 5/8” x 5/8” x 5/8” are available on special order.

TECHNICAL DATA SHEET

SK2RIM90-10

I-Fitting

Back to range

► DESCRIPTION

Barb coupling I-fitting developed for using in low temperature resin infusion process.

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

► TECHNICAL DATA

Material type:	PP
Color:	White
Recommended use temperature:	90°C
Maximum use temperature*:	120°C

► SIZE

Reference for order	Outside diameter	For tube with internal diameter
SK2RIM90-10WH1010I	10mm x 10mm	9-10mm
SK2RIM90-10WH1616I	16mm x 16mm	15-16mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 50 ea.
Other sizes are available on special order.
* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

TECHNICAL DATA SHEET

SK2RIM120-3

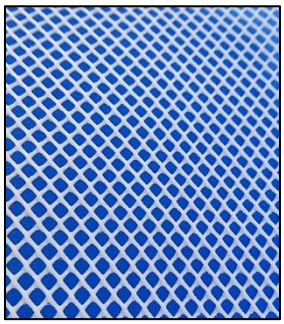
Low print belt

Back to range

► DESCRIPTION

SK2RIM120-3 is a low print belt that can be used under omega tube on top of infusion mesh, for reducing the print of omega tube on the laminate.

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



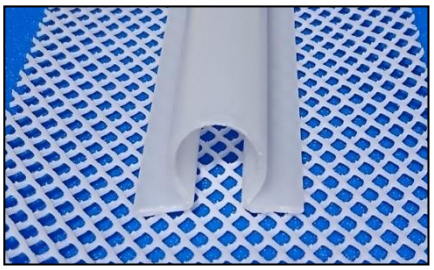
► TECHNICAL DATA

Material type:	PE
Color:	White
Weight:	400g/m²
Maximum use temperature:	120°C

► SIZE

Thickness	Width
1,8 mm ± 0,2 mm	100mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.



Omega flow line SK2RIM120-5 with low print belt SK2RIM120-3

► NOTE

Other widths are available upon request.

TECHNICAL DATA SHEET

SK2RIM120-5

Omega flow line

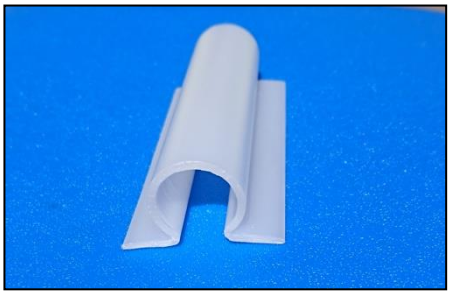
Back to range

► DESCRIPTION

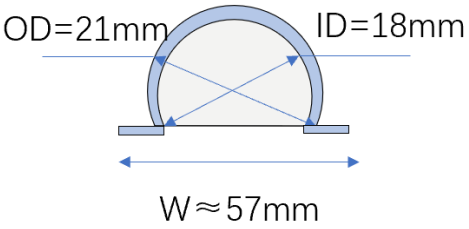
Omega flow line SK2RIM120-5 is used for resin feeding under vacuum bag during resin infusion applications, replacing spiral wraps lines by more stable profile mostly in wind energy as cost effective line. The product incorporates a cavity in omega shape internally to transport resin along the surface and into the part. It is suitable for use with our tubes SK2RIM90-2 and SK2RIM120-6 to distribute resin into the line. It leaves minimal or no mark off on the part when used with low print belt SK2RIM120-3 or flow media with peel ply under it.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

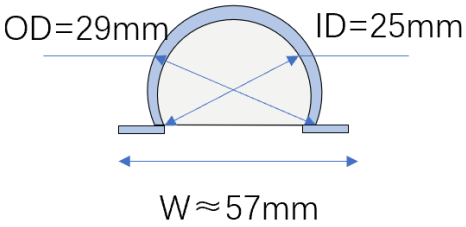
Material type:	PP
Color:	White
Maximum use temperature*:	120°C



SK2RIM120-5WH18O21L2



SK2RIM120-5WH25O29L2



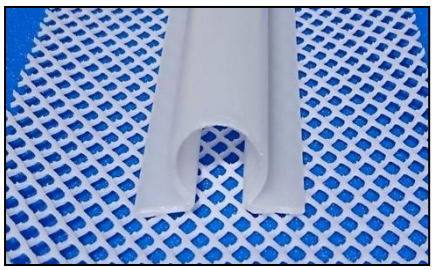
► SIZE

Reference	Inside/outside diameter	Length
SK2RIM120-5WH18O21L2	18mm x 21mm	2m
SK2RIM120-5WH25O29L2	25mm x 29mm	2m
SK2RIM120-5WH18O21L4	18mm x 21mm	4m
SK2RIM120-5WH25O29L4	25mm x 29mm	4m

Shelf life: not limited
Storage conditions: it is recommended to use at temperature from -20°C until +30°C.

SK2RIM120-5

Omega flow line



Omega flow line SK2RIM120-5 with low print belt SK2RIM120-3

► NOTE

We recommend to apply release agent on surface of line to increase lifespan.
Other sizes (inside diameters and length) are available on special order.

* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

TECHNICAL DATA SHEET

SK2RIM120-6

Resin and vacuum tube

Back to range

► DESCRIPTION

This tube is made for using in resin infusion process for creation of vacuum channels and resin inlet channels where working temperature of 120° is requested.

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

► TECHNICAL DATA

Color:	White
Recommended use temperature:	121°C
Maximum use temperature*:	150°C

► SIZE

Inside diameter	Outside diameter	Packaging
6mm	8mm	30m/roll
10mm	12mm	30m/roll
10mm	16mm	30m/roll

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 1 roll. Other diameters, lengths and colors are available on special order.
* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

TECHNICAL DATA SHEET

SK2RIM120-9

Omega Line for resin inlet with perforated panel

Back to range

► DESCRIPTION

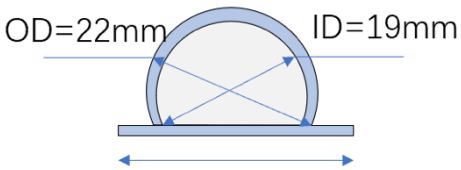
Omega line for resin inlet with perforated panel SK2RIM120-9 is used for resin feeding under vacuum bag during resin infusion applications, replacing spiral wraps lines by more stable profile mostly in wind energy as cost effective line.
The product with perforated panel incorporates a cavity in omega shape internally to transport resin along the surface and into the part. It is suitable for use with our tubes SK2RIM90-2 and SK2RIM120-6 to distribute resin into the line. It leaves minimal or no mark off on the part when used with low print belt SK2RIM120-3 or flow media with peel ply under it.

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

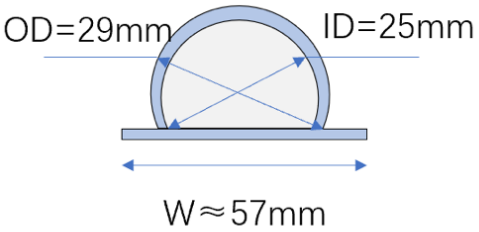
► TECHNICAL DATA

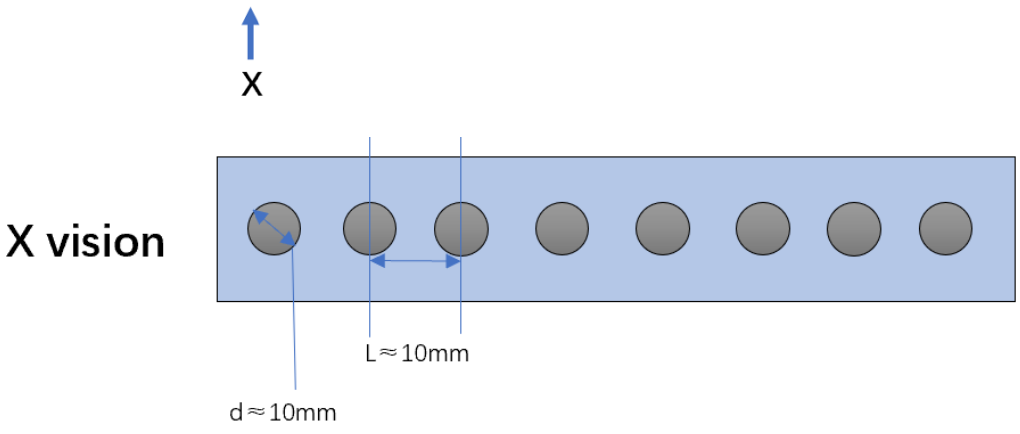
Material type:	PP
Color:	White
Maximum use temperature*:	120°C

SK2RIM120-9WH19O22L2



SK2RIM120-9WH25O29L2





► SIZE

Reference	Inside/outside diameter	Length
SK2RIM120-9WH19O22L2	19mm x 22mm	2m
SK2RIM120-9WH25O29L2	25mm x 29mm	2m

Shelf life: not limited
Storage conditions: it is recommended to use at temperature from -20°C until +30°C.

► NOTE

We recommend to apply release agent on surface of line to increase lifespan.
Other sizes (inside diameters and length) are available on special order.

* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

TECHNICAL DATA SHEET

SK2STK-90

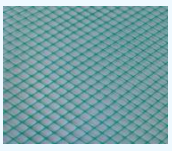
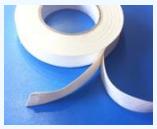
Starter kit for vacuum infusion

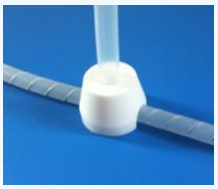
Back to range

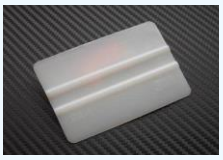
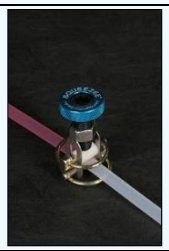
► DESCRIPTION

This starter kit was specifically developed for beginners in resin infusion technology. It includes all necessary materials, instruments and equipment for resin infusion process (except for vacuum pump) while working with room temperature polymerized resins. The provided material will allow you to make a part superior to 3 m². Operating manual contains a step-by-step guide for processing.

► COMPLETE SET

	Product	Description	Image	Quantity
1	Vacuum film SK2VF170-1	Nylon vacuum film, pink, T=170°C, elongation 465%, 50µm x 1,50m x 6m, sheeting		1,50m x 6m
2	Sealant tape SK2ST200-1	Sealant tape, yellow, T=200°C, 3mm x 12mm x 9m		3 rolls
3	Peel ply SK2PP230-1	Polyamide peel ply, white with red stripers, T=230°C, 88g/m², plain, 172 µm x 1,63m x 6m		1,63m x 6m
4	Resin distribution mesh SK2RIM120-1	Low profile mesh for accelerated distribution of resin, green, T=150°C, 1,21m x 6m		1,2m x 6m
5	Double coated adhesive tape SK2AT60-1	Double coated adhesive tape, white, T=60°C, 271 µm x 25mm x 33m		1 roll
6	Spiral wrap SK2RIM90-1	Spiral wrap, white, PE, T=90°C, Ø 10 x 12 mm		30 m

7	Tube PE SK2RIM90-2	Tube, PE, white, T=90°C Ø 10 x 12 mm		30 m
8	L-fitting SK2RIM90-3	L-fitting, white, T=90°C, 10mm x 10mm		10 pce
9	T-fitting SK2RIM90-4	T-fitting , white, T=90°C, 10mm x 10mm x 10mm		10 pce
10	Adhesive Tape SK2AT205-1	Adhesive tape, blue, T=205°C, adhesive type : silicone, carrier type : polyester, 63 µm x 25mm x 66m		1 roll
11	Resin infusion connector SK2RIM000-4	PE, T=90°C for spiral Ø= 12mm and inlet tube Ø=12-13mm		2 pce
12	Resin distribution tape SK2RIM180-2	Tape, polyester, white, T=180°C, 20mm x 25m		25 m
13	AIRVIK-5	Spray adhesive AIRVIK-5, 500 ml		1 can

14	Hand roller SK3ROL-1	Roller material: inert plastic Colour: Gray		1 pce
15	Scissors for composite materials SK3CUT-5	Blade length: 125mm, Scissors length: 250mm Weight: 276g		1 pce
16	Paddle SK3SPA-1WH	Material type: high-density polyethylene Colour: white		2 pce
17	Vacuum trap for resin SK3VAC-5L	Tank volume: 5,6 l, Size: Ø20 cm x 38 cm, Tank material: aluminum, Fitting material: stainless steel, clamping fitting for tube 12mm, quick disconnect plug 1/4"		1 pce
18	Clamp for resin feed line SK2RIM000-1	Material type: steel Plier length: 20cm Flange width: 8cm Weight: 495g		1 pce
19	Resin line clamping device SQUEZEE®	Tube clip for control or stop of feeding line		1 pce
20	Operating manual INST_SK2STK-90_RU	Operating manual in Russian and English with a step-by-step guide and images for each operation	-	1 pce

Storage conditions: it is recommended to store at temperature from +10°C till + 30°C in the original packing.

► NOTE

On customer's request the starter kit can be equipped with a resin trap with volume 5 litres: SK3VAC-5L or 15 litres: SK3VAC-15L. For room temperature resin infusion use the starter kit SK2STK-90. For high temperature resin infusion use the starter kit SK2STK-180.

Kit reference	Vacuum trap included	Max temperature of kit materials
SK2STK-90C5L	SK3VAC-5L	90°C
SK2STK-90C15L	SK3VAC-15L	90°C
SK2STK-180C5L	SK3VAC-5L	180°C
SK2STK-180C15L	SK3VAC-15L	180°C

TECHNICAL DATA SHEET

SK1MOV-KITMINI

Portable starter kit for educating organizations

Back to range

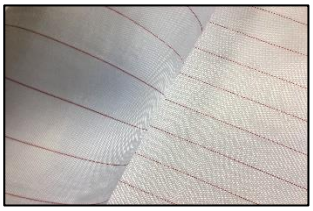
► DESCRIPTION

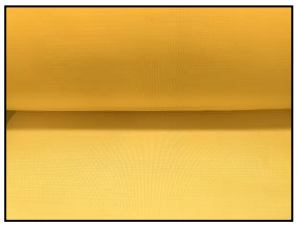
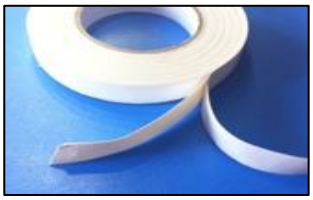
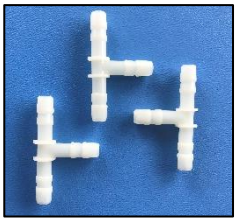
Portable starter kit was specially developed for beginners in studying processes of manufacturing products from polymer composite materials. It includes all necessary materials (consumable products), resin, carbon and fiberglass, mobile vacuum system, as well as personal protective equipment.

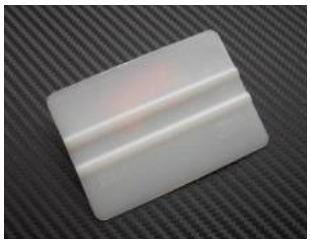
This kit provides excellent mobility in schools, technical study groups or the presentations.

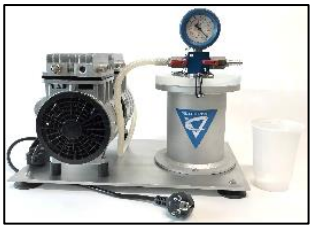
Vacuum system is placed on mobile lightweight aluminum platform as single phase powered. Light-weight and simple unit can be used in training sessions by schoolchildren and students who do not have specific technical skills, when studying different composite manufacturing processes, like vacuum resin infusion, double bag infusion, RTM light and as well for vacuum debulking operations.

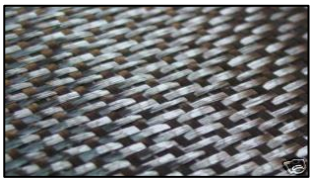
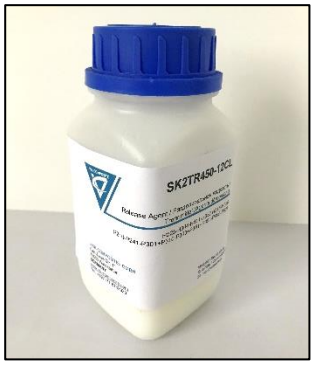
► COMPLETE SET:

Product	Image	Description	Unit measure	Quantity
SK2VF170-1		Nylon vacuum film, pink, T=120-180°C, elongation 380%, 50µm x 1,50m x 5m, sheeting	m²	7,5
SK2ST120-3		Sealant tape, gray, T=120°C, 3mm*12mm*15m	m	90
SK2PP170-1		Polyamide peel ply, white with red stripers, T=190°C, 85g/m², 1,52m*3,3m	m²	5

SK2RIM115-1		Resin distribution mesh, yellow, Max. T=125°C, 165g/m², 1,7mm*1250mm*2m	m²	2,5
SK2AT60-1		Double coated adhesive tape, white, T=60°C, adhesive type: rubber, Carrier type: cloth, 271 µm *25mm*33m	rolls	1
SK2RIM90-1		Spiral wrap, translucent, PE, max.T=120°C, inner Ø=10mm, outer Ø=12mm	m	20
SK2RIM90-2		Tube, white, PE, T=120°C, inner. Ø=10mm, outer Ø=12mm	m	20
SK2RIM90-3		L-fitting, PP, white, T=120°C, 10mm*10mm	pcs.	10
SK2RIM90-4		T-Fitting, PP, white, T=120°C, 10mm*10mm*10mm	pcs.	10

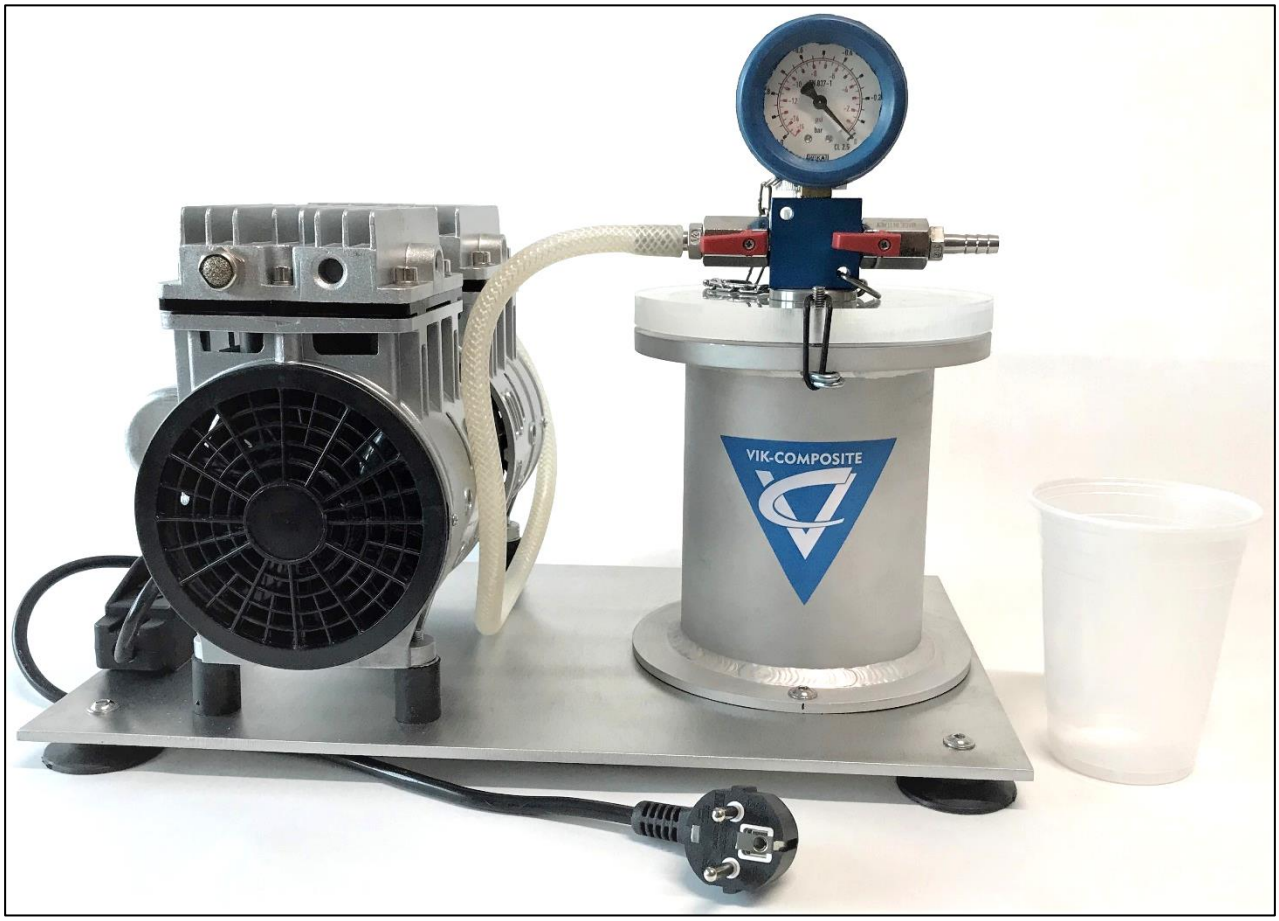
AIRVIK-9		Spray adhesive - temporary adhesive for positioning fiberglass and carbon fabrics - manufacture of polyester resin, vinyl-ester and epoxy, 500ml	pcs.	1
SK3ROL-1		Hand roller for prepreg and sealant tape	pcs.	2
SK3CUT-5S25		Sturdy scissors for cutting technical materials, 25cm	pcs.	1
SK3SPA-1WH		Paddle is used to facilitate the laying up of prepreg, layers of reinforcing and auxiliary materials, white	pcs.	5

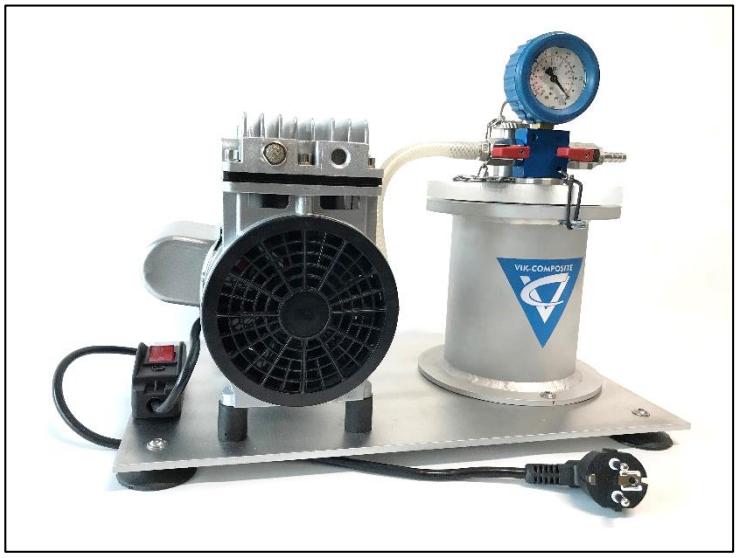
SK2RIM000-1RC		Clamp for resin feed line, steel (W*L) 8cm*20cm	pcs.	2
SK1MOVAC-MINI		Portable mobile vacuum system, pump 40 l/min, trap 1,7л, 1 clamping fitting for tube with inner. Ø12mm	pcs.	1
Gloves		Cotton-coated latex gloves (size L), 1 pair per pack	pcs.	10
Респиратор		Spray mask FFP1 up to ambient air standard 4	pcs.	10
Protective overalls		Single-use, with a hood, white Klever (size XL)	pcs.	5
Safety glass		Open, multipurpose, Rome P1 Lucerne, transparent	pcs.	5

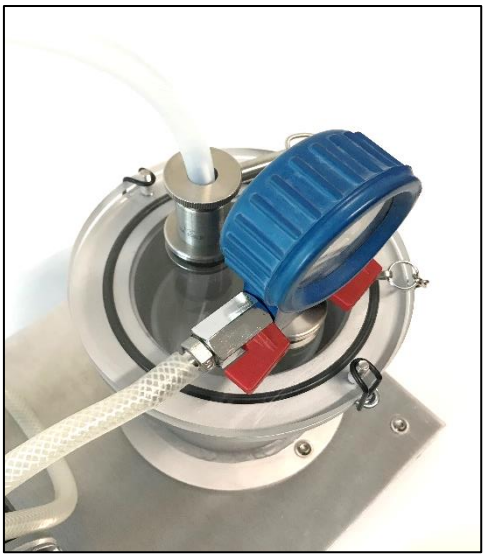
Fibreglass		0,28 mm, 290+-25 g/м², plain structure	m²	4
Carbon fiber		Carbon fiber 240g/м³, 3K, Width1,25m	m²	2
Epoxy resin		Two-component epoxy resin for infusion at room temperature + Q	kg	5
SK2TR450-12		Semi-permanent solution based release agent, can of 0,5 l	pcs.	1
SK2TR150-1		Wax based release agent, can 0,5 l	pcs.	1

The vacuum system is designed and developed subject to safety requirements and manufactured taking into account the its use by a group of students under the supervision of a supervisor. It is possible to connect several vacuum traps in series.

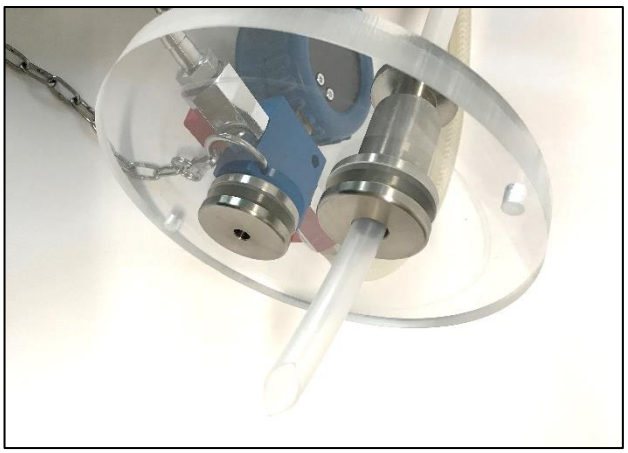
A disposable plastic or paper cup is placed inside the trap, which, if the resin splashes into the trap, collects excess, keeping the trap clean and can easily be replaced with a new one at the end of the process.







To the left of the vacuum pump there is a switch that has a button that identifies the connection to a current source.



The trap is connected to the vacuum bag using the clamping fitting located on the transparent cover on the trap. This fitting is specially designed by VIK-COMPOSITE to prevent contamination by contact with the resin.

This solution makes the use of the system safe and ergonomic. At the end of the process, the pressure fitting is untwisted and the disposable tube is removed.

► TECHNICAL SPECIFICATIONS AND ADVANTAGES:

Components	Description
Portable system	Light aluminum plate 260mm x 420mm x 5mm (W x L x H). Equipped with 1 vacuum pump и 1 vacuum trap. Rubber suction cups stably attach the vacuum system to the table surface.
Vacuum pumps	E400 A2 single phase 50 Hz: productivity 40 l / min and 18mbar

Vacuum level	Adjustable with ball valve, approximately 0% vacuum to the pump's maximum vacuum, as follows E400 A2 - 18 mbar (730 mmHg), vacuum
Vacuum gauges	Range: 0 - (-1) bar Graduations: -0,05 bar Accuracy: +/-2,5%
Vacuum trap	System equipped with resin trap series: SK3VAC-MINI with volume 1,7 l. Each tank is equipped with: - Paper/ plastic cup with volume 300 ml for resin trapping, aimed at preventing the tank from contamination; - Vacuum gauge; - Valve for manual flow control; - 1 clamping fitting for the tube with external diameter 12mm to connect resin channels. (Fittings for tubes 6, 8, 10 mm are available on special order).

► **NOTE**

Please contact us for more detailed information as well as for system development according to your technical specification.

Standard warranty period: 12 months.

SK2RIM000-2

High temperature resin infusion connector

Back to range

► DESCRIPTION

High temperature resin infusion connector can be used in resin infusion process for resin inlet or for connection of vacuum manifold. Made of PTFE connector has excellent release properties and can be reused in the process.

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

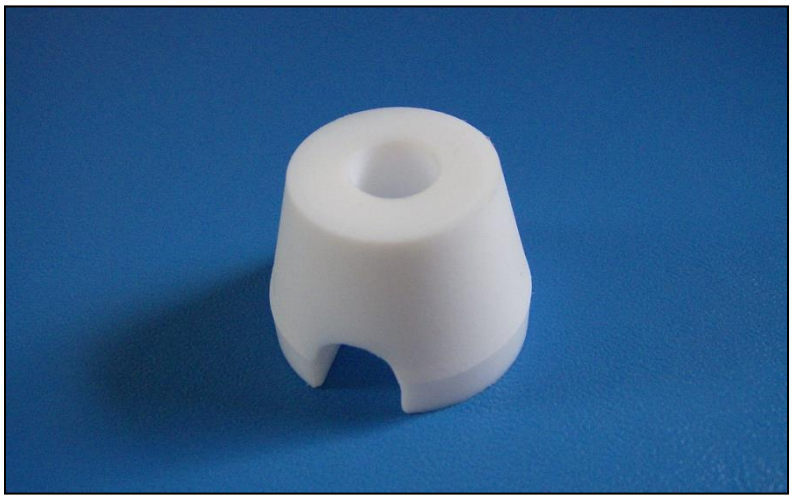
► TECHNICAL DATA

Material type:	PTFE
Color:	White
Maximum use temperature:	260°C

► SIZE

Tube connection	Spiral tube connection
Ø=12-13mm	Ø=12-13mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.



► NOTE

Other sizes are available on special order.

SK2RIM000-3

High temperature PA resin infusion connector

Back to range

► DESCRIPTION

High temperature polyamide infusion connector can be used in resin infusion process for resin inlet or for connection of vacuum manifold.

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

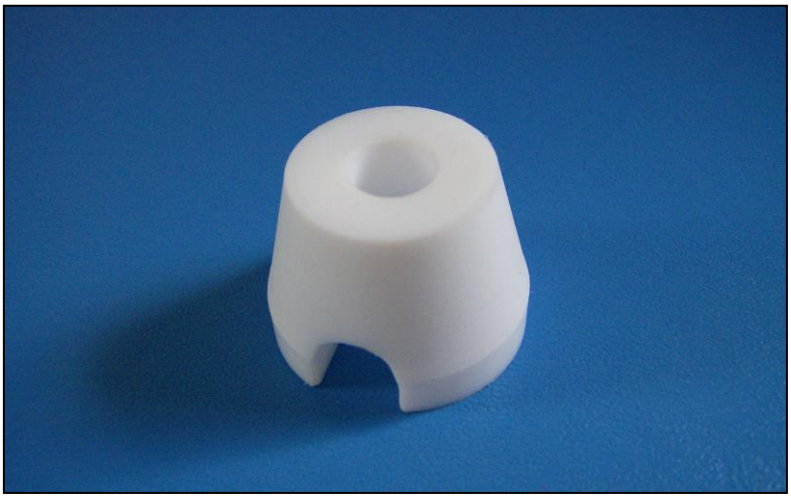
► TECHNICAL DATA

Material type:	Polyamide
Color:	White
Maximum use temperature:	180°C

► SIZE

Tube connection	Spiral tube connection
Ø=12-13mm	Ø=12-13mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.



► NOTE

Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2RIM175-1

Spiral wrap

Back to range

► DESCRIPTION

Spiral wrap is produced from Nylon 6. The main application areas are:

- Vacuum manifold function by Resin Infusion Process;
- Association of cables in lines;
- Protection of cables against a friction, mechanical damages;
- Protection of cables against influence of ultra-violet irradiation.

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

► TECHNICAL DATA

Material type:	Nylon 6
Color:	Translucent
Recommended use temperature:	175°C
Maximum use temperature:	190°C

► SIZE

Inside diameter	Outside diameter	Packaging
4mm	5,2mm	30m/roll
9mm	11mm	30m/roll

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 1 roll. Other sizes and colors are available on special order.
Maximum use temperature should be determined under your actual process conditions.

TECHNICAL DATA SHEET

SK2RIM175-2
Polyamide tube

Back to range

► DESCRIPTION

SK2RIM175-2 is a polyamide tube used to create vacuum channels and resin inlet channels.

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

► TECHNICAL DATA

Material type:	Polyamide
Colour:	White
Recommended use temperature:	175°C
Maximum use temperature:	190°C

► SIZE

Inside diameter	Outside diameter	Packaging
10mm	12mm	50m/roll

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 1 roll.
Other sizes (diameter and length of the roll) are available on special order.
Maximum use temperature should be determined under your actual process conditions.

TECHNICAL DATA SHEET

SK2RIM250-2

Silicone Pressure Tubing

Back to range

► DESCRIPTION

The tube is produced from silicone rubber with coating and glass fiber. It can be used high temperature RTM processes for creation of vacuum channels and resin inlet channels.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Elastomer:	Silicone rubber SIL 701
Colour:	Inner tubing: transparent Coating: transparent (other colours available on request)
Fabric:	Glass fibre
Roll length:	25 metres, loosely bound

Elastomer properties

Hardness (DIN 53505)	70 [°Shore A]
Density (DIN 53749)	1.18
Tensile strength (DIN 53504 S2)	10.0 [N/mm²]
Elongation at break (DIN 53504 S2)	500 [%]
Compression set (DIN 53517)	53.0
Tear resistance (ASTM D 624 Die B)	24.0 [N/mm²]
Elect. volume resistivity at RT	1015 [Ohm x cm]
Breakdown voltage	20 [KV/mm]
Temperature resistance (continuous)	+200 [°C]
Temperature resistance (short-term)	+ 250 [°C]
Low temperature flexibility	-60 [°C]
UV resistance	very good

Burst pressure

Product	Dimensions [ID x WT]	Burst pressure (at 20°C)
SK2RIM250-2WH308025	3.00 x 2.50	> 50 [bar]
SK2RIM250-2WH409025	4.00 x 2.50	> 50 [bar]
SK2RIM250-2WH5011025	5.00 x 3.00	> 35 [bar]
SK2RIM250-2WH6012025	6.00 x 3.00	> 30 [bar]
SK2RIM250-2WH7013425	7.00 x 3.20	30 [bar]
SK2RIM250-2WH8014425	8.00 x 3.20	25 [bar]
SK2RIM250-2WH901625	9.00 x 3.50	25 [bar]
SK2RIM250-2WH10018025	10.00 x 4.00	25 [bar]
SK2RIM250-2WH12020025	12.00 x 4.00	24 [bar]
SK2RIM250-2WH13021025	13.00 x 4.00	23 [bar]

SK2RIM250-2WH14023025 SK2RIM250-2WH16026025 SK2RIM250-2WH19030025 SK2RIM250-2WH20031025 SK2RIM250-2WH22034025 SK2RIM250-2WH25037025	14.00 x 4.50 16.00 x 5.00 19.00 x 5.50 20.00 x 5.50 22.00 x 6.00 25.00 x 6.00	23 [bar] 22 [bar] 20 [bar] 15 [bar] 15 [bar] 15 [bar]

(Burst pressure is a statistical, non-binding value which was determined at 20°C using water as a pressure medium.
Higher temperatures and the use of other media can reduce pressure resistance.)

► USE

Operating mode (guideline only)	Ratio of test pressure to operating pressure	Ratio of burst pressure to operating pressure
Water tubing, maximum operating pressure < 10 bar	1.5	3.0
Tubing for other fluids, solids dissolved in liquids or air and water tubing with an operating pressure > 10 bar	2.0	4.0
Tubing for compressed air and other gases	2.0	4.0
Tubing for liquid media which converts to a gaseous state when pressure reduces (i.e. during venting into the atmosphere).	2.5	5.0
Steam tubing	5.0	10.0

Table: Ratios of test and burst pressure to operating pressure
Source: DIN EN ISO 7751: 1997

Tolerances

All tubes are manufactured in compliance with DIN 7715.

Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

TECHNICAL DATA SHEET

SK2RIM260-1

Heat resistant tube

Back to range

► DESCRIPTION

Tube is produced from silicone, heat and chemicals resistant. Tube can be used high temperature resin infusion and RTM processes for creation of vacuum channels and resin inlet channels.

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

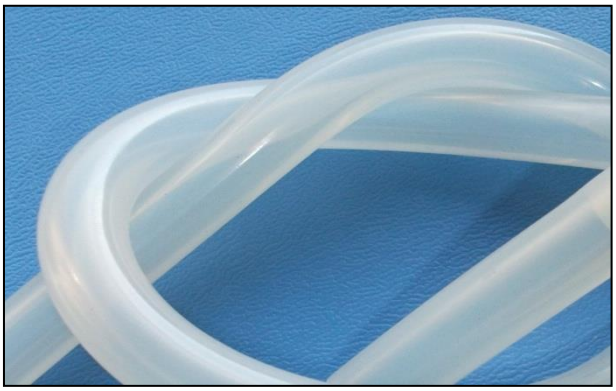
► TECHNICAL DATA

Material type:	Silicone
Color:	Translucent
Maximum use temperature:	260°C

► SIZE

Inside diameter	Outside diameter	Packaging
7mm	13mm	25m/roll

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.



► NOTE

Please contact us for MOQ information for sizes you need.

TECHNICAL DATA SHEET

SK2RIM260-2

Heat resistant reinforced tube

Back to range

► DESCRIPTION

Tube is produced from silicone and reinforced with PES fiber, heat and chemicals resistant. Tube can be used high temperature RTM processes for creation of vacuum channels and resin inlet channels.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	Silicone
Color:	Translucent
Maximum use temperature:	260°C

Burst pressure

Product	Dimensions [ID x WT]	Burst pressure (at 20°C)
SK2RIM260-2WH308025	3.00 x 2.50	> 36 [bar]
SK2RIM260-2WH409025	4.00 x 2.50	> 34 [bar]
SK2RIM260-2WH5011025	5.00 x 3.00	> 33 [bar]
SK2RIM260-2WH6012025	6.00 x 3.00	> 31[bar]
SK2RIM260-2WH7013425	7.00 x 3.20	30 [bar]
SK2RIM260-2WH8014425	8.00 x 3.20	25 [bar]
SK2RIM260-2WH901625	9.00 x 3.50	25 [bar]
SK2RIM260-2WH10018025	10.00 x 4.00	25 [bar]
SK2RIM260-2WH12020025	12.00 x 4.00	22 [bar]
SK2RIM260-2WH13021025	13.00 x 4.00	21[bar]
SK2RIM260-2WH14023025	14.00 x 4.50	19 [bar]
SK2RIM260-2WH16026025	16.00 x 5.00	16 [bar]
SK2RIM260-2WH19030025	19.00 x 5.50	12 [bar]

(Burst pressure is a statistical, non-binding value which was determined at 20°C using water as a pressure medium. Higher temperatures and the use of other media can reduce pressure resistance.)

► SIZE

Inside diameter	Outside diameter	Packaging
7mm	13,4mm	25m/roll

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

SK2RIM260-2

Heat resistant reinforced tube

► **NOTE**

Please contact us for MOQ information for sizes you need.

SK2RIM260-4

High temperature silicone cord

Back to range

► DESCRIPTION

Cord is produced from silicone with the hardness 60 Shore A, heat and chemicals resistant. Cord can be used as sealant for the molding tool in the RTM process till 260°C.

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

► TECHNICAL DATA

Material type:	Silicone
Hardness:	60 Shore A
Color:	Translucent
Maximum use temperature:	260°C

► SIZE

Diameter	Packaging
4mm	50m/roll

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 1 roll.
Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2RIM260-5

Heat resistant hard silicone tube

Back to range

► DESCRIPTION

The strong version of silicone tube SK2RIM260-5 is produced from hard silicone, heat and chemicals resistant. Tube can be used at high temperature resin infusion for creation of vacuum channels and resin inlet channels outside. It can be used under vacuum bag without collapsing.

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

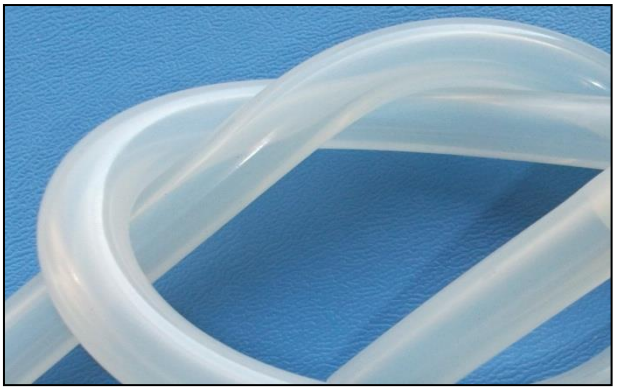
► TECHNICAL DATA

Material type:	Silicone
Color:	Translucent
Maximum use temperature:	260°C

► SIZE

Inside diameter	Outside diameter	Packaging
7mm	15mm	25m/roll

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.



► NOTE

MOQ is 1 roll. Other sizes (wall thicknesses and inside diameters) are available on special order.

SK2RIM260-10

Silicone omega flow line

Back to range

► DESCRIPTION

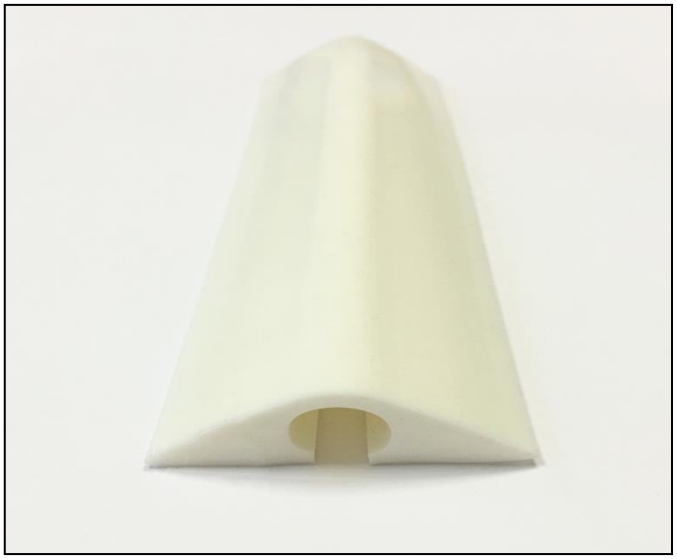
Silicone omega flow line SK2RIM260-10 is used for resin feeding under vacuum bag during resin infusion applications, replacing spiral wraps lines by more stable reusable profile. The product incorporates a cavity in omega shape internally to transport resin along the surface and into the part. It is suitable for use with our polyethylene tubes SK2RIM90-2 and silicone tubes SK2RIM260-1 to distribute resin into the line. It leaves minimal or no mark off on the part when used with flow media or peel ply under it.
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	Silicone
Color:	White
Maximum use temperature:	260°C

► SIZE

Inside diameter	Length
12mm	15m



Shelf life: not limited
Storage conditions: it is recommended to use at temperature from -20°C until +30°C.

► **NOTE**

We recommend to apply release agent on surface of line to increase lifespan.
Other sizes (inside diameters) are available on special order.

TECHNICAL DATA SHEET

SK2RIM180-3

L-Fitting

Back to range

► DESCRIPTION

Barb coupling L-fitting developed for using in High temperature resin infusion process.

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

► TECHNICAL DATA

Material type:	PA
Color:	White
Maximum use temperature:	190°C

► SIZE

Reference for order	Outside diameter	For tube with internal diameter
SK2RIM180-3WH88L	8mm x 8mm	8mm
SK2RIM180-3WH1010L	10mm x 10mm	10mm
SK2RIM180-3WH1212L	12mm x 12mm	12mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 20 ea.
Other sizes: 1/2” x 1/2” and 5/8” x 5/8” are available on special order.

TECHNICAL DATA SHEET

SK2RIM180-4

T-Fitting

Back to range

► DESCRIPTION

Barb coupling T-fitting developed for using in High temperature resin infusion process.

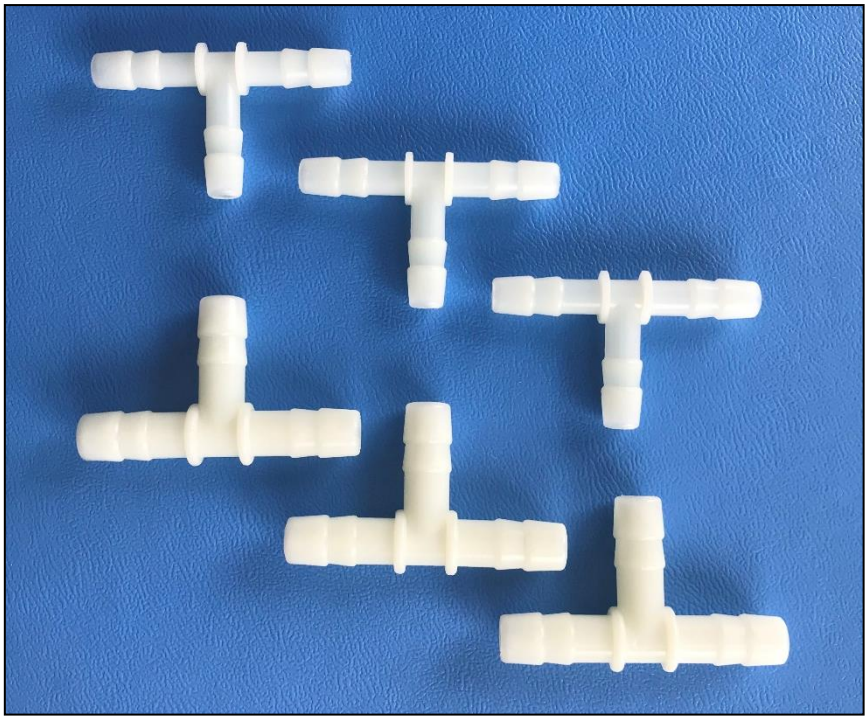
This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type:	PA
Color:	White
Maximum use temperature:	190°C

► SIZE

Reference for order	Outside diameter	For tube with internal diameter
SK2RIM180-4WH888T	8mm x 8mm x 8mm	8mm
SK2RIM180-4WH101010T	10mm x 10mm x 10mm	10mm
SK2RIM180-4WH121212T	12mm x 12mm x 12mm	12mm



Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 100 ea.
Other sizes: 1/2” x 1/2” x 1/2” and 5/8” x 5/8” x 5/8” are available on special order.

TECHNICAL DATA SHEET

SK2RIM180-5

I-Fitting

Back to range

► DESCRIPTION

Barb coupling I-fitting developed for using in High temperature resin infusion process.

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

► TECHNICAL DATA

Material type:	PA
Color:	White
Maximum use temperature:	190°C

► SIZE

Reference for order	Outside diameter	For tube with internal diameter
SK2RIM180-5WH88I	8mm x 8mm	8mm
SK2RIM180-5WH1010I	10mm x 10mm	10mm
SK2RIM180-5WH1212I	12mm x 12mm	12mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 20 ea.
Other sizes: 1/2” x 1/2” and 5/8” x 5/8” are available on special order.

SK2RIM180-8

X-Fitting

Back to range

► DESCRIPTION

Barb coupling X-fitting developed for using in High temperature resin infusion process.

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

► TECHNICAL DATA

Material type:	PA
Color:	White
Maximum use temperature:	180°C

► SIZE

Reference for order	Outside diameter	For tube with internal diameter
SK2RIM180-8WH1010X	10mm x 10mm	10 mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 20 ea.
Other sizes are available on special order.

SK2RIM180-9

Y-Fitting

Back to range

► DESCRIPTION

Barb coupling Y-fitting developed for using in High temperature resin infusion process.

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

► TECHNICAL DATA

Material type:	PA
Color:	White
Maximum use temperature:	180°C

► SIZE

Reference for order	Outside diameter	For tube with internal diameter
SK2RIM180-9WH121212Y	12mm x 12mm x 12mm	12mm

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 20 ea.

SK2RIM180-10

Adapter Fittings

Back to range

► DESCRIPTION

Barb coupling adapter fittings developed for commutating pipelines of different section in High temperature resin infusion process.

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

► TECHNICAL DATA

Material type:	PA
Color:	White
Maximum use temperature:	180°C

► SIZE

Reference	Size	Shape
SK2RIM180-10WH12RA8I	Passage from internal Ø 12mm to internal Ø 8mm	I-fitting

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 20 ea.
Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2STK-180

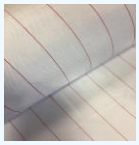
Starter kit for vacuum infusion

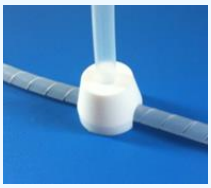
Back to range

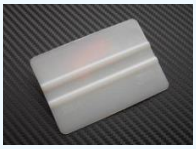
► DESCRIPTION

This starter kit was specifically developed for beginners in high temperature resin infusion technology. It includes all necessary materials, instruments and equipment for resin infusion process (except for vacuum pump) while working with room temperature polymerized resins. The provided material will allow you to make a part superior to 3 m². Operating manual contains a step-by-step guide for processing.

► COMPLETE SET

	Product	Description	Image	Quantity
1	Vacuum film SK2VF200-1	Nylon vacuum film, green, T=204°C, elongation 400%, 50µm x 1,52m x 6m, sheeting		1,52m x 6m
2	Sealant tape SK2ST200-1	Sealant tape, yellow, T=204°C, 3mm x 12mm x 9m		5 rolls
3	Peel ply SK2PP180-5	Polyester peel ply, white with red stripes T=200°C, 105g/m², 140µm x 1,52m x 6m		1,52m x 6m
4	Resin distribution mesh SK2RIM180-1	Resin distribution mesh, T=180°C, 100g/m², 650 µm x 1,2m x 6m		1,2m x 6m
5	Double coated adhesive tape SK2AT200-1	Double coated adhesive tape, white, polyester, 210 µm, T 200°C, 25mm x 50m		1 roll
6	Spiral wrap SK2RIM175-1	Spiral wrap, white, nylon T=175°C, Ø = 9 x 11mm		30 m

7	Silicone tube SK2RIM260-1	Tube, PET, white, T=260°C Ø 7 x 12 mm		25 m
8	L-fitting SK2RIM180-3	L-fitting , white, T=180°C, 10mm x 10mm		10 pce
9	T-fitting SK2RIM180-4	T-fitting , white, T=180°C, 10mm x 10mm x 10mm		10 pce
10	Adhesive Tape SK2AT205-1	Adhesive tape, blue, T=205°C, adhesive type: silicone, carrier type: polyester, 63 µm x 25mm x 66m		1 roll
11	Resin infusion connector SK2RIM000-2	PTFE, T=260°C for spiral Ø= 12mm and inlet tube Ø=12-13mm		2 pce
12	Resin distribution tape SK2RIM180-2	Tape, polyester, white, T=180°C, 20mm x 25m		25 m
13	AIRVIK-5	Spray adhesive AIRVIK-5, 500 ml		1 bottle

14	Hand roller SK3ROL-1	Roller material: inert plastic Colour: Gray		1 pce
15	Scissors for composite materials SK3CUT-5	Blade length: 125mm, Scissors length: 250mm Weight: 276g		1 pce
16	Paddle SK3SPA-1WH	Material type: high-density polyethylene Colour: white		2 pce
17	Vacuum trap for resin SK3VAC-5L	Tank volume: 5,6 l, Size: Ø20 cm x 38 cm, Tank material: aluminum, Fitting material: stainless steel, clamping fitting for tube 12mm, quick disconnect plug 1/4"		1 pce
18	Clamp for resin feed line SK2RIM000-1	Material type: steel Plier length: 20cm Flange width: 8cm Weight: 495g		1 pce
19	Operating manual INST_SK2STK-180_RU	Operating manual in Russian and English with a step-by-step guide and images for each operation	-	1 pce

Storage conditions: it is recommended to store at temperature from +10°C till + 30°C in the original packing.

► NOTE

On customer's request the starter kit can be equipped with a resin trap with volume 5 litres: SK3VAC-5L or 15 litres: SK3VAC-15L. For room temperature resin infusion use the starter kit SK2STK-90. For high temperature resin infusion use the starter kit SK2STK-180.

TECHNICAL DATA SHEET

SK2STK-180

Starter kit for vacuum infusion

Kit reference	Vacuum trap included	Max temperature of kit materials
SK2STK-90C5L	SK3VAC-5L	90°C
SK2STK-90C15L	SK3VAC-15L	90°C
SK2STK-180C5L	SK3VAC-5L	180°C
SK2STK-180C15L	SK3VAC-15L	180°C

► DESCRIPTION

SK2COM115-1 is a two layers combination composed of one infusion resin transport medium in knitted mesh laminated to a release film perforated for infusion. The two layers are joined together with a hot melt synthetic rubber having a permanent tack. The amount of adhesive from 2 gr to 5 gr/sqm does not affect the draining capacity of mesh. The product is intended to optimize the infusion process with surface medium by combining two difficult tasks: laying the release film with respect of patches overlapping and laying up of the mesh always difficult to cut precisely. It permits overlaps without limitation and strengthens the mesh for precise cut without curling edges. SK2COM115-1 provides drainage of the resin between the perforation of the two layers of release film, which ensures the continuity of the resin feeding flow to the laminate under the overlap. Great labor saving can be achieved by having combination of products applied in one operation as opposed to applying one layer at a time. The product can be applied on the top of the carbon or fiberglass fabrics or on the top of a peel ply.

- Excellent resin flow characteristics
- Adaptable for different shapes, corners and contours
- Does not leave unsightly indentations
- Can be used with all resins
- Labor savings

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

► TECHNICAL DATA

RELEASE FILM:

Material release film type:	Polyolefin
Material thickness:	25 µm
Color:	Blue
Perforation type of release film:	ø 0,5 / each 6,35mm

DISTRIBUTION MESH:

Material mesh type:	HDPE
Configuration of net:	Knitted
Mesh weight:	162 g/m^2 (+/- 5 g/m^2)
Color:	Yellow

COMBINED PRODUCT:

Area weight:	170 gr/m^2 (+/- 5 g/m^2)
Flow capacity:	275 gr/mn (+/- 10%)
Resin trapped:	587 gr/m^2
Recommended use T:	115°C
Maximum use T:	121°C

► SIZES

Thickness	Width	Length
1,5mm	1450mm	100m

Shelf life: unlimited.
Storage conditions: it is recommended to store at temperatures between -20°C and +30°C in original packing.

* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

TECHNICAL DATA SHEET

SK2RIM115-1

High drapable woven resin distribution mesh

Back to range

► DESCRIPTION

Knitted resin distribution media for assist resin flow through the part during the vacuum assisted resin infusion process by room temperature and low temperature processes till 115 °C. It works well with polyester, vinylester and epoxy resins. The product is highly drapable. SK2RIM115-1 is available with green tracer threads that indicate the roll direction of the mesh. It can also be used as a reusable flexible / high stretch breather for vacuum bagging and consolidation. Flow rate of the resin in the mesh roll direction is about 20% faster compared to the resin flow at 90° to the mesh roll direction. Therefore, take note of the mesh direction when using.

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

► TECHNICAL DATA

Material type:	HDPE
Color:	Yellow
Weight:	165g/m²
Recommended use temperature:	115°C
Maximum use temperature:	125°C

SK2RIM115-1

High drapable woven resin distribution mesh

► SIZE

Thickness	Width	Length
1,7mm	1250mm	100m
1,7mm	2500mm	100m

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 1 roll.

* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use

TECHNICAL DATA SHEET

SK2RIM120-1

Low profile mesh for accelerated distribution of resin

Back to range

► DESCRIPTION

Extruded mesh SK2RIM120-1 is designed for efficient distribution of resin with minimization of its waste due to low and tight profile of mesh. It can be used with polyester, vinylester and epoxy resins.

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

► TECHNICAL DATA

Material type:	PP
Color:	Green
Weight:	100 ± 3 g/m²
Configuration of net:	Extruded with rhombic cell
Maximum use temperature:	150°C

► SIZE

Thickness	Width	Length
0,9 mm	1,21 m	100 m

► NOTE

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

Shelf life: not limited

Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

MOQ is 1 roll.

Other weights and sizes available on request.

TECHNICAL DATA SHEET

SK2RIM120-2

Low profile mesh for accelerated distribution of resin

Back to range

► DESCRIPTION

Extruded mesh SK2RIM120-2 is designed for accelerated distribution of resin with minimization of its waste due to low and tight profile of mesh. It can be used with polyester, vinylester and epoxy resins.

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

► TECHNICAL DATA

Material type:	PP
Color:	Green
Weight:	103g/m²
Recommended use temperature:	120°C
Maximum use temperature:	150°C

► SIZE

Thickness	Width	Length
0,93mm	1040mm	107m

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 1 roll.

TECHNICAL DATA SHEET

SK2RIM120-4

Heavy woven fast resin distribution mesh

Back to range

► DESCRIPTION

Extruded mesh SK2RIM120-4 is designed for efficient distribution of resin through the part during the vacuum assisted resin infusion process. It can be used with polyester, vinylester and epoxy resins. SK2RIM120-4 is a highly drapable knitted flow medium with a high resin flow speed for most resins.

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

► TECHNICAL DATA

Material type:	HDPE
Color:	Green (black on request)
Weight:	250 g/m²
Configuration of net:	Extruded
Recommended use temperature:	100°C
Maximum use temperature*:	120°C

► SIZE

Reference	Width	Length
SK2RIM120-4GN200100	2,00 m	100 m

Shelf life: not limited

Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

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

Other weights and sizes available on request.

* Maximum use temperature should be determined in actual process conditions.
The maximum use temperature depends on the duration at maximum temperature and is process specific, we recommend testing prior to use.

TECHNICAL DATA SHEET

SK2RIM125-1

Sewed tubular mesh

Back to range

► DESCRIPTION

SK2RIM125-1 is a sewed tubular knitted mesh designed to include a spiral wrap with the outside diameter till 13 mm. Use of this sleeve allows to prevent mark-off of a spiral tube on the surface of the composite laminate. The special "stalk" stitched 2 times reduces labor costs on installation of sleeve by applying of the vacuum, allowing to place easily and precisely a spiral tube into a pleat in the vacuum bagging film.

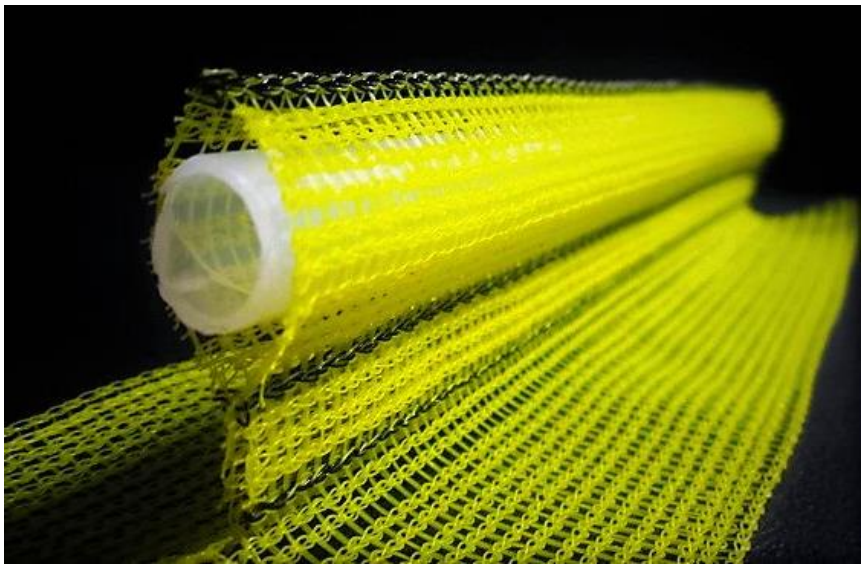
► TECHNICAL DATA

Material type:	HDPE
Color:	Yellow
Configuration of net:	Knitted
Maximum use temperature:	125°C

► SIZE

Thickness	Width	Length
0,9mm	120mm	50m

Shelf life: not limited. Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.



► NOTE

MOQ is 1 roll. The tube is sold without the spiral. Other sizes are available on special order.

TECHNICAL DATA SHEET

SK2RIM125-4

Woven heavy resin distribution mesh

Back to range

► DESCRIPTION

SK2RIM125-4 is a flow media designed to distribute efficiently the resin with little waste due to its low profile and tight construction. It is compatible with polyester, vinylester and epoxy resins.
This distribution mesh is used for vacuum infusion and it is placed on the top of peel ply.
SK2RIM125-4 is used to allow a quick flow for resin to travel across the part while under vacuum. This product is very easy to use and allows to achieve great results.

► TECHNICAL DATA

Material:	HDPE
Colour:	Green
Knitting technics:	Weave
Mesh density (line/cm):	Longitudinal 3 lines/ transverse 3 lines
Weight:	165 g/m²
Maximum use temperature:	125°C
Compatible resin system:	Epoxy, Polyester, Vinyl Ester
Tensile strength:	≥ 23 MPa
Elongation at break :	≥ 500%

► SIZE

Thickness	Width	Length
1000µm	2000mm	100m
1000µm	3600mm	100m
1000µm	140mm	100m

Shelf life: unlimited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

Please contact us for MOQ information.

TECHNICAL DATA SHEET

SK2RIM180-1

Woven resin distribution mesh

Back to range

► DESCRIPTION

The resin distribution media is composed of a warp-knitted basic structure and monofilament created loops. The 2-dimensional flowing aid supports the vacuum infusion process (VIP), because it distributes the resin equally into the component part. Therefore, it can easily be combined with the resin distribution tapes SK2RIM180-2 in order to ensure a much more optimized resin distribution in the component.
The elasticity of this knitted fabric is very advantageous for the drapacity of the resin media. Because of the low weight per unit, low wastages of resin can be realized. SK2RIM180-1 is available with black tracer threads that indicate the roll direction of the mesh. It can also be used as a reusable flexible / high stretch breather for vacuum bagging and consolidation. Flow rate of the resin in the mesh roll direction is about 18% faster compared to the resin flow at 90° to the mesh roll direction. Therefore, take note of the mesh direction when using.

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

► TECHNICAL DATA

Material type:	PES
Color:	White
Weight:	100g/m²
Maximum use temperature:	190°C
Melting point:	220°C

► SIZE

Thickness	Width	Length
650µm	1250mm	100m
650µm	2500mm	100m

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► **NOTE**

MOQ is 1 roll.

TECHNICAL DATA SHEET

SK2RIM180-2

Resin distribution tape

Back to range

► DESCRIPTION

Resin distribution tape is composed of a warp-knitted structure and monofilament-created nooses which are used as flow canal. The tape supports the vacuum infusion process. It can be used on the entry side as resin infusion aid and on the exit side as vacuum canal. The tape is easy to handle and to attach, adapts to curved component contours and leaves no appreciable marks.

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

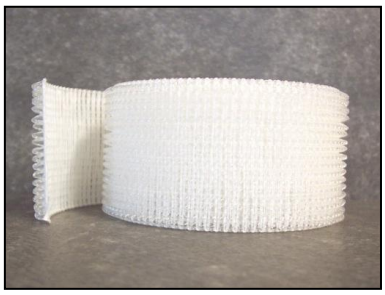
► TECHNICAL DATA

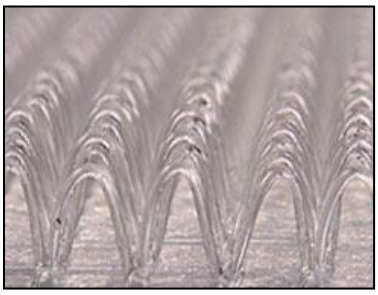
Material type:	PES
Color:	White
Maximum use temperature:	180°C
Melting point:	220°C

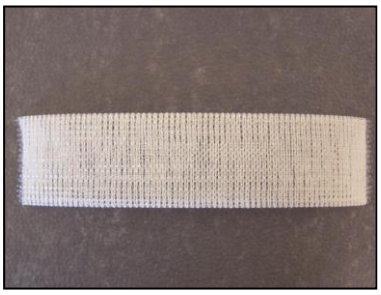
► SIZE

Thickness	Width	Length
3,5mm	20mm	25m
3,5mm	43mm	25m

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.







► NOTE

MOQ is 1 roll.

TECHNICAL DATA SHEET

SK2RIM180-6

Woven resin distribution mesh

Back to range

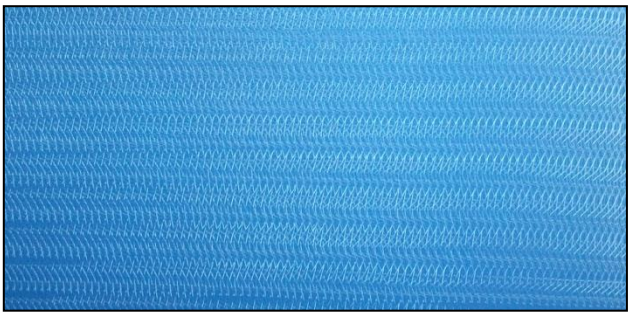
► DESCRIPTION

The resin distribution media is composed of a warp-knitted basic structure and monofilament created loops.
Because of the better resistance to vacuum depression, the mesh will be less compacted thus the channel will be more open to let the resin going through faster. The 2-dimensional flowing aid supports the vacuum infusion process (VIP), because it distributes the resin equally into the component part. Therefore, it can easily be combined with the resin distribution tapes SK2RIM180-2 in order to ensure a much more optimized resin distribution in the component. The elasticity of this knitted fabric is very advantageous for the drapacity of the resin media.

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

► TECHNICAL DATA

Material type:	PES
Color:	White
Weight:	105g/m²
Maximum use temperature:	180°C
Melting point:	220°C



► SIZE

Thickness	Width	Length
700µм	1250mm	100m
700µм	2500mm	100m

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 1 roll.

TECHNICAL DATA SHEET

SK2SPIRMESH90-1

Sewed tubular mesh with spiral wrap

Back to range

► DESCRIPTION

The combined product SK2SPIRMESH90-1 is a polyethylene tubular mesh with a spiral wrap inserted in it.

This product is used in various manufacturing processes of parts made of composite materials. It is designed to improve the resin distribution flow during vacuum infusion at room temperature or low temperature vacuum infusion. The mesh is suitable for use with polyester, vinylester and epoxy resins and has a high drapability.

► TECHNICAL DATA

Material type (mesh):	LD polyethylene
Material type (wrap):	Polyethylene
Weight (mesh):	165 g/m²
Recommended use temperature:	90°C
Maximum use temperature:	120°C

Shelf life: not limited
Storage conditions: it is recommended to store at temperature from -20°C till + 30°C in the original packing.

► NOTE

MOQ is 1 roll.