

Data Sheet

AIRTECH 1069

Uncured rubber

DESCRIPTION

Airtech 1069 is a high temperature FKM rubber material that is formulated to be co-cured with Airtech 1024 or Airtech 4124. The material is typically used to create a band of material around the perimeter of a silicone bag that allows the use of standard vacuum bag sealant tapes.

BENEFITS

- Sealant tapes adhere more reliably to FKM rubber than silicone for better vacuum security.
- High temperature stability gives long service life of reusable rubber tooling.
- Easier to use than bondable release films for complex sealing strips.

TECHNICAL DATA

Properties listed are typical for fully cured material

| Material type | FKM rubber | Test method |
|--|--|---------------------|
| Color | Black | |
| Hardness | 75+/-5 Shore A | ASTM D2240 |
| Density | 0.065 lb/cm ³ (1.81 g/cm ³) | ASTM D 792 |
| Maximum use temperature | 500°F (260°C) | |
| Elongation at break | 268 % | ASTM D412 |
| Tensile strength | 2685 psi (18.5 MPa) | ASTM D412 die A |
| Compression set at 22 hrs. 350°F (177°C) | 5 % | ASTM D395, Method B |
| Shelf life | 6 months when stored below 40°F (4°C) 30 days when stored at 72°F (22°C) from date of shipment when stored in original packaging | |

SIZES

| Thickness | Width | Length | Packaging Type |
|----------------------|--------------------|-------------------|----------------|
| 0.020 inch (0.51 mm) | 42 inch (106.7 cm) | 25 yards (22.9 m) | roll |

APPLICATION

Cure Procedure:

- Airtech 1069 is a no-tack material, contact Airtech technical support for advice.
- Apply a vacuum bag and debulk 20 minutes at 25 inches Hg (0.85 bar) minimum.
- Cure in an autoclave at 350°F (177°C) with a minimum pressure of 45 psi (3 bar) for 30 minutes plus heat up time required to bring supporting member to temperature. Maintain full vacuum throughout cure cycle 25 inches Hg (0.85 bar).
- Allow for cooling to 120°F (49°C) before removal from mold.

Post Cure Instructions:

- Place fully cured material in cool oven with material exposed to air (no vacuum bag).
- Ramp temperature to 400°F (204°C) in approximately half an hour.
- Post cure at 400°F (204°C) for 4 hours.
- Allow for cooling at 120°F (49°C) before handling.

NOTES

- Shorter rolls available on special order
- The maximum use temperature is dependent upon the duration at maximum temperature and is process specific, Airtech recommends testing prior to use.

Last updated : 2019-10-14

Catalog position : [Rubber](#)