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DATA SHEET

AIRTECH 4140

Reusable Elastomeric for Vacuum Bagging, Uncured

Thermavac® Elastomeric Vacuum Bagging Materials

Description:

The Thermavac® grade silicone rubber is a proprietary formulation that offers high reversion resistance and strength. It is designed to provide superior performance in composite lamination systems for vacuum/autoclave and vacuum/hydraulic curing. Any silicone rubber has the potential to transfer. Silicone transfer investigation should be done by the user.

<u>Available Forms:</u>	Thickness:	.040" (1.02mm) - .060" (1.52mm)
	Width:	36" (91.4cm)
	Finish:	N/A
	State:	Uncured
	Form:	25 LYD Roll (22.9m)
	Color:	Red

Physical Properties:

The physical properties of the material are comparable to Airtech 1050 when fully cured and post cured according to the following instructions.

Cure Procedure: Typical Seam

- + Clean area of cured Thermavac® to be bonded with isopropyl alcohol on a lint free rag.
- + Cut uncured Thermavac® to size and remove white cloth liner.
- + Lay rubber in place, taking care not to trap air, and remove clear liner.
- + Rub edges smooth with a spatula or plastic liner and fingers.
- + Cover area with A4000 release film and Airweave N-7 breather cloth.
- + Apply a vacuum bag and debulk 20 minutes at 25" Hg minimum.
- + Cure in an oven at 350°F (177°C) for 30 minutes + Heat up time required to bring supporting member to temperature maintaining minimum 25" Hg vacuum.
- + Allow to cool to 120°F (49°C) before removal from mold.
- + For lower temperature cures, simply increase the cure time 30 minutes per 50°F (10°C) drop in temperature (from 350°F 177°C).
- + Recommended minimum cure temperature is 250°F (121°C).

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 1/2 hour.
- + Post cure at 400°F (204°C) for 4 hours.
- + Allow to cool to 120°F (49°C) before handling.

Shelf Life: 6 months from date of manufacture when stored below 40°F (4°C).
30 days from date of manufacture when stored at 72°F (22°C).

CATALOG POSITION: **RUBBER**



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