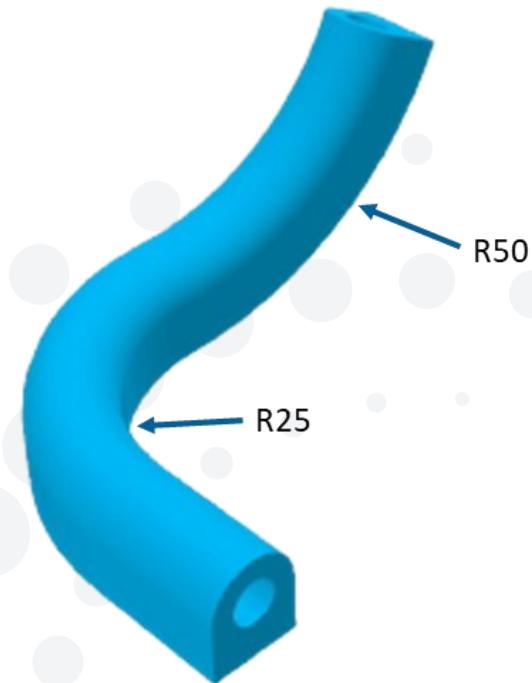


DATASHEET

MOULD SEAL: RD-20-0013

'D' section mould seal for use as a primary resin seal in the majority of 'Light' RTM and RTM tooling.

General Specifications	
Silicone Type:	General Purpose
Colour:	Blue
Overall Height:	14 mm
Overall Width:	12 mm
Cross Sectional Area:	124 mm ²
Shore Hardness:	55 shore
Service Temperature:	Continuous use: maximum 180°C Single use: maximum 200°C
Compressive Force:	9 kN/m *to fully close mould seal on a metal RTM channel
Shelf Life:	5 — 10 years *if stored correctly
*All extrusion dimensions must be to Silicone Extrusion Tolerance E1.	

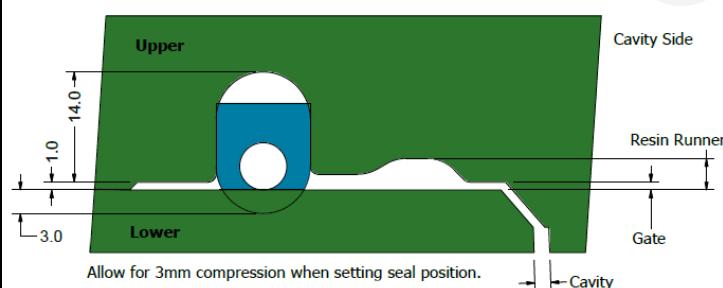


Groove Specifications

To avoid seal damage: please ensure that the cross sectional area of the seal groove is approximately 10% larger than the area of seal being used. This applies to both composite and metal tooling.

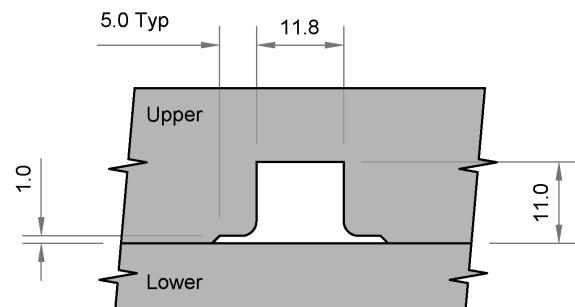
Note: the largest practical bend radius, particularly in the vertical direction for the mould tooling is preferable.

Composite VRTM — Peripheral Fill



D seal groove to suit RD-20-0013 or RD-20-0011. Use RD-20-0010 (white) to form groove. Use RD-20-0016 (red) to form resin runner. Blend edge of groove R2 Typ.

Metal RTM



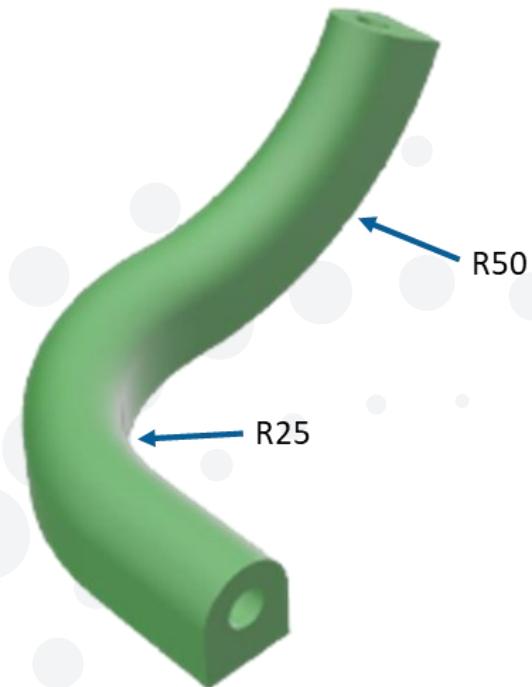
D seal groove to suit: RD-20-0010 (white), RD-20-0011 (green) and RD-20-0013 (blue). Runner detail varies on application.

DATASHEET

MOULD SEAL: RD-20-0011

'D' section mould seal which is a harder and more resilient version of the standard 'D' mould seal. For use in high pressure RTM applications.

General Specifications	
Silicone Type:	General Purpose
Colour:	Green
Overall Height:	14 mm
Overall Width:	12 mm
Cross Sectional Area:	133 mm ²
Shore Hardness:	55 shore
Service Temperature:	Continuous use: maximum 180°C Single use: maximum 200°C
Compressive Force:	16 kN/m *to fully close mould seal on a metal RTM channel
Shelf Life:	5 — 10 years *if stored correctly
*All extrusion dimensions must be to Silicone Extrusion Tolerance E1.	

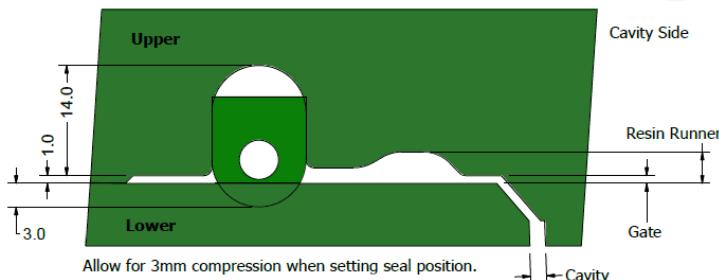


Groove Specifications

To avoid seal damage: please ensure that the cross sectional area of the seal groove is approximately 10% larger than the area of seal being used. This applies to both composite and metal tooling.

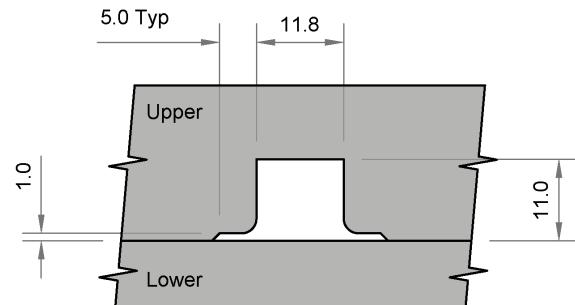
Note: the largest practical bend radius, particularly in the vertical direction for the mould tooling is preferable.

Composite VRTM — Peripheral Fill



D seal groove to suit RD-20-0013 or RD-20-0011. Use RD-20-0010 (white) to form groove. Use RD-20-0016 (red) to form resin runner. Blend edge of groove R2 Typ.

Metal RTM



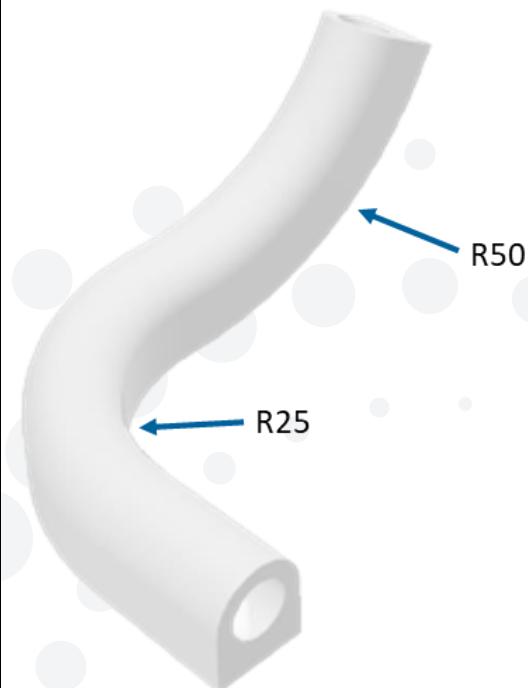
D seal groove to suit: RD-20-0010 (white), RD-20-0011 (green) and RD-20-0013 (blue). Runner detail varies on application.

DATASHEET

MOULD SEAL: RD-20-0010

'D' section mould seal used as a resin seal in 'Light' RTM or RTM tooling. This can be inflated or collapsed under vacuum using a seal control unit (XE-0400).

General Specifications	
Silicone Type:	General Purpose
Colour:	White
Overall Height:	14 mm
Overall Width:	12 mm
Cross Sectional Area:	109 mm ²
Shore Hardness:	55 shore
Service Temperature:	Continuous use: maximum 180°C Single use: maximum 200°C
Compressive Force:	4.5 kN/m * to fully close mould seal on a metal RTM channel
Shelf Life:	5 — 10 years * if stored correctly
*All extrusion dimensions must be to Silicone Extrusion Tolerance E1.	

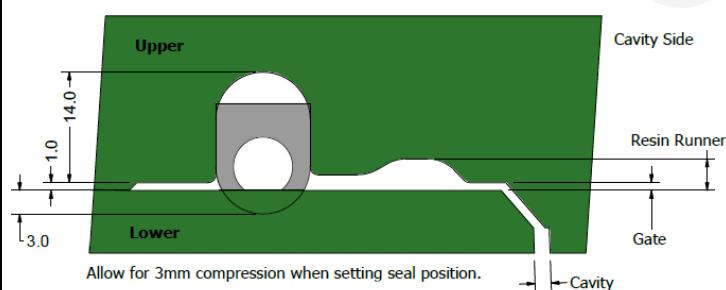


Groove Specifications

To avoid seal damage: please ensure that the cross sectional area of the seal groove is approximately 10% larger than the area of seal being used. This applies to both composite and metal tooling.

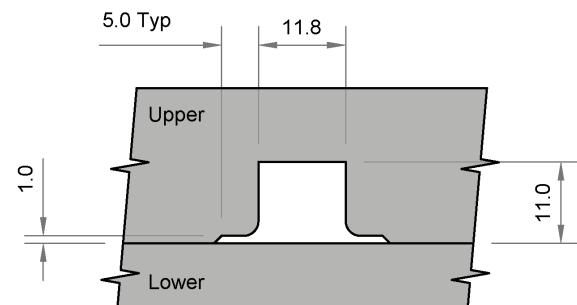
Note: the largest practical bend radius, particularly in the vertical direction for the mould tooling is preferable.

Composite VRTM — Peripheral Fill



D seal groove to suit RD-20-0013 or RD-20-0011. Use RD-20-0010 (white) to form groove. Use RD-20-0016 (red) to form resin runner. Blend edge of groove R2 Typ.

Metal RTM



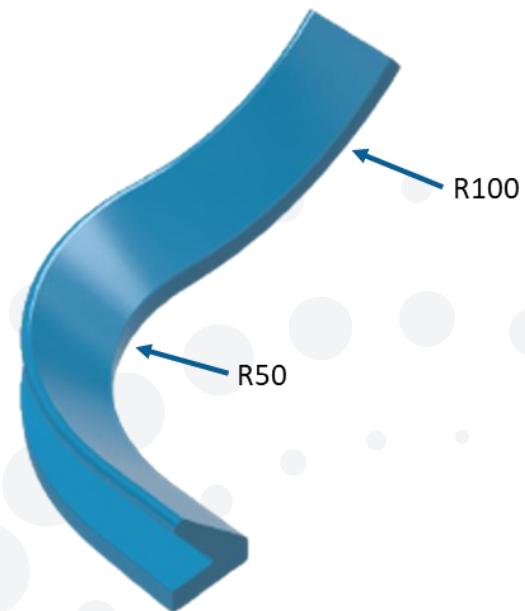
D seal groove to suit: RD-20-0010 (white), RD-20-0011 (green) and RD-20-0013 (blue). Runner detail varies on application.

DATASHEET

MOULD SEAL: RD-20-0012

'Lip' section mould seal for use as an outer vacuum seal in 'Light' RTM moulds.

General Specifications	
Silicone Type:	General Purpose
Colour:	Blue
Overall Height:	20 mm
Overall Width:	19 mm
Cross Sectional Area:	205 mm ²
Shore Hardness:	55 shore
Service Temperature:	Continuous use: maximum 180°C Single use: maximum 200°C
Shelf Life:	5 — 10 years *if stored correctly
*All extrusion dimensions must be to Silicone Extrusion Tolerance E1.	

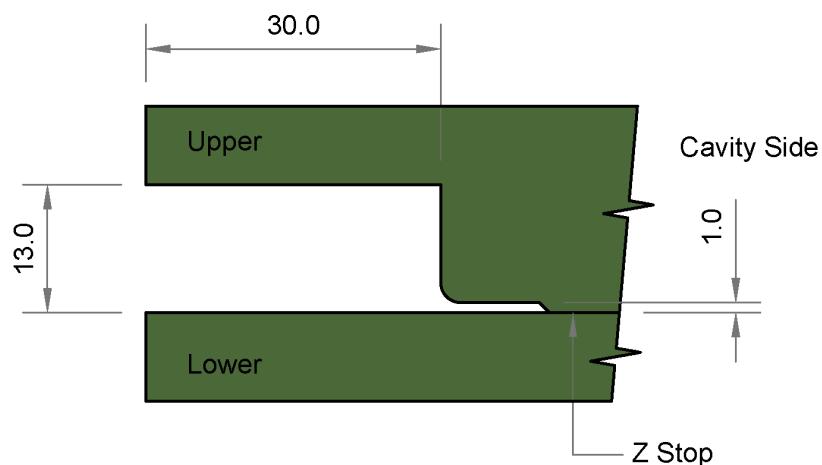


Groove Specifications

To avoid seal damage: please ensure that the cross sectional area of the seal groove is approximately 10% larger than the area of seal being used. This applies to both composite and metal tooling.

Note: the largest practical bend radius, particularly in the vertical direction for the mould tooling is preferable.

Composite and Metal VRTM



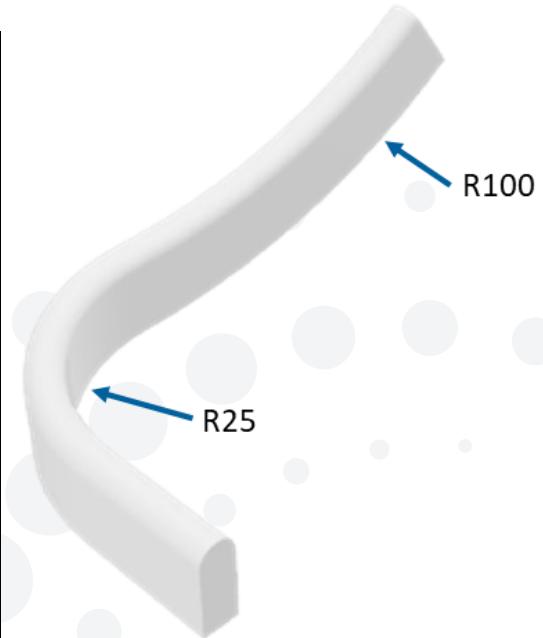
'Lip' seal groove to suit RD-20-0012. Use RD-20-0017 (white) to form groove.
Blend edge of groove R2 Typ.

DATASHEET

MOULD SEAL: RD-20-0009

10 x 5 'D' section mould seal with radius used with small RTM applications where standard 'D' mould seals would not be applicable.

General Specifications	
Silicone Type:	General Purpose
Colour:	White
Overall Height:	12.5 mm
Overall Width:	5 mm
Cross Sectional Area:	60 mm ²
Shore Hardness:	55 shore
Service Temperature:	Continuous use: maximum 180°C Single use: maximum 200°C
Shelf Life:	5 — 10 years *if stored correctly
*All extrusion dimensions must be to Silicone Extrusion Tolerance E1.	

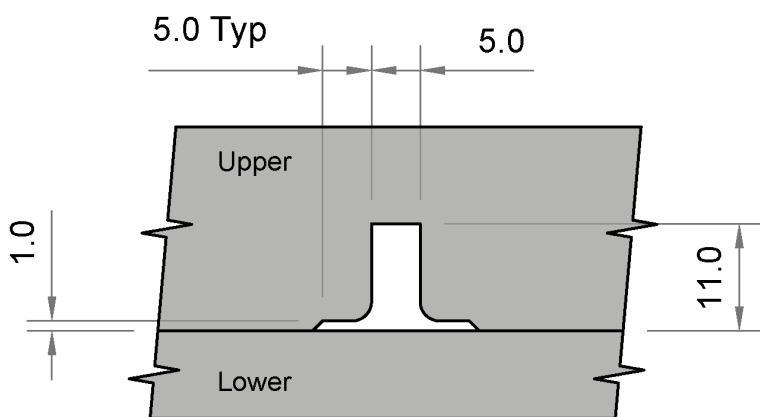


Groove Specifications

To avoid seal damage: please ensure that the cross sectional area of the seal groove is approximately 10% larger than the area of seal being used. This applies to both composite and metal tooling.

Note: the largest practical bend radius, particularly in the vertical direction for the mould tooling is preferable.

Composite and Metal VRTM



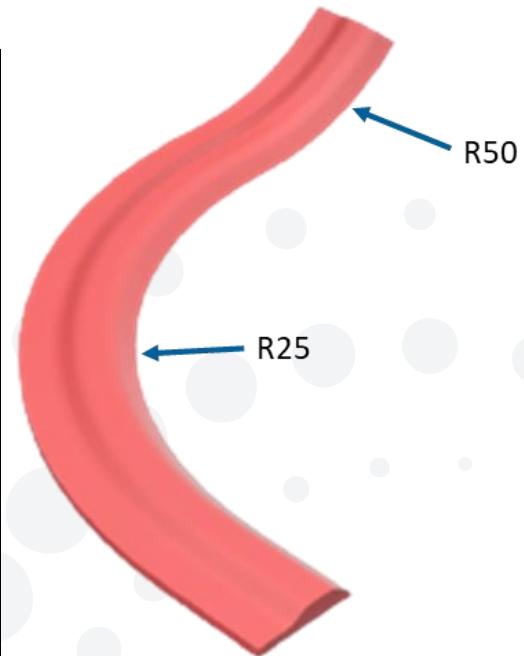
'D' seal groove to suit RD-20-0009. Runner detail varies on application.
Blend edge of groove R2 Typ.

DATASHEET

MOULD SEAL: RD-20-0016

Resin runner mould seal that provides correct resin runner detail in VRTM tooling. This can also be formed around horizontal and vertical radii.

General Specifications	
Silicone Type:	General Purpose
Colour:	Red
Overall Height:	4 mm
Overall Width:	20 mm
Cross Sectional Area:	55 mm ²
Shore Hardness:	55 shore
Service Temperature:	Continuous use: maximum 180°C Single use: maximum 200°C
Shelf Life:	5 — 10 years *if stored correctly
*All extrusion dimensions must be to Silicone Extrusion Tolerance E1.	

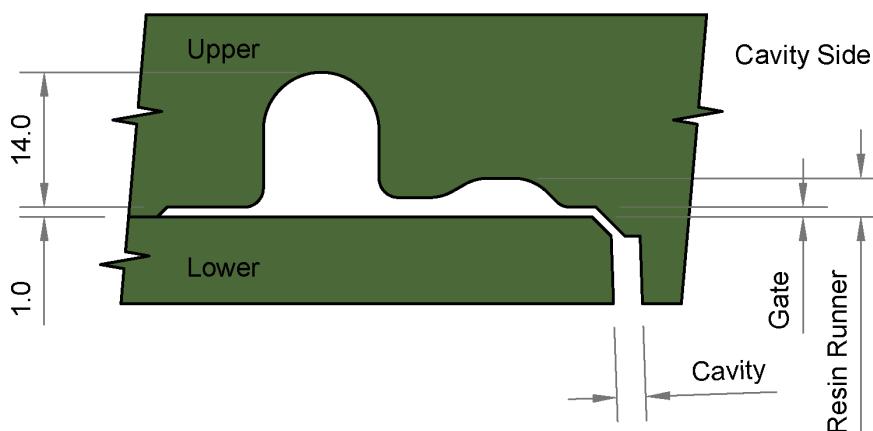


Groove Specifications

To avoid seal damage: please ensure that the cross sectional area of the seal groove is approximately 10% larger than the area of seal being used. This applies to both composite and metal tooling.

Note: the largest practical bend radius, particularly in the vertical direction for the mould tooling is preferable.

Composite and Metal VRTM



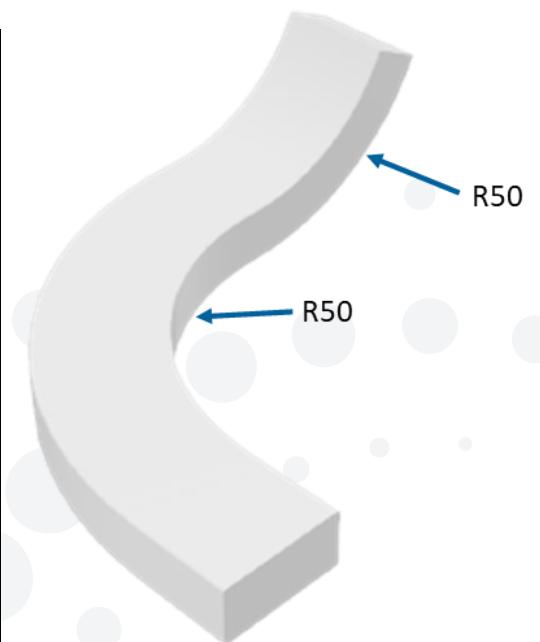
'D' seal groove to suit RD-20-0013 or RD-20-0011. Use RD-20-0017 (white) to form groove. Use RD-20-0016 (red) to form resin runner. Blend edge of groove R2 Typ.

DATASHEET

MOULD SEAL: RD-20-0017

Foam section mould seal that provides correct groove detail for fitting 'Lip' section mould seal. This can be formed around horizontal and vertical radii.

General Specifications	
Silicone Type:	General Purpose
Colour:	White
Overall Height:	12 mm
Overall Width:	25 mm
Cross Sectional Area:	300 mm ²
Shore Hardness:	55 shore
Service Temperature:	Continuous use: maximum 180°C Single use: maximum 200°C
Shelf Life:	5 — 10 years *if stored correctly
*All extrusion dimensions must be to Silicone Extrusion Tolerance E1.	

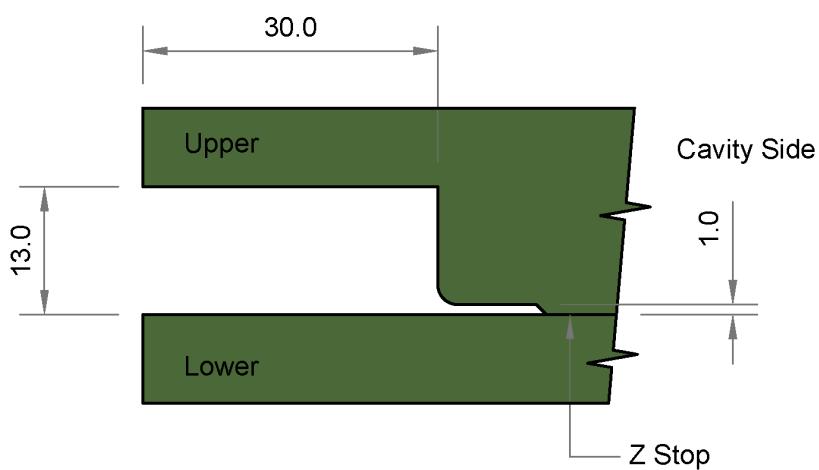


Groove Specifications

To avoid seal damage: please ensure that the cross sectional area of the seal groove is approximately 10% larger than the area of seal being used. This applies to both composite and metal tooling.

Note: the largest practical bend radius, particularly in the vertical direction for the mould tooling is preferable.

Composite and Metal VRTM



'Lip' seal groove to suit RD-20-0012. Use RD-20-0017(white) to form groove.
 Blend edge of groove R2 Typ.