

MISCELLANEOUS

IMPRESSION SET-V	Impression film for prefit
SHRINK TAPE I	Polyvinyl fluoride (PVF) release tape
SHRINK TAPE II	Orientated polyester tape
SHRINK TAPE III	Polyvinyl alcohol (PVA) tape
CUREPAD	Non-silicone uncured tooling rubber
CURETAPE-127	Non-silicone "B" staged tooling rubber, tape
RICHDAM SE	Silicone rubber resin dam
RICHDAM 27	Non-silicone rubber resin dam tape
FLASHSORB	Adhesive and resin absorption material
T.S.B. SYSTEM	Tool Surface Breathing
RICHCAST TABLE TOPS	Moca cured polyurethane cutting table top with high durability
PRE-FABRICATED VAC-PAK® VACUUM BAGS and ASSEMBLIES	Custom bags for complex or simple bagging requirements and laminated bag assemblies
RAD-PID CUT	Cut hand held cutting tools
ELECTRIC SCISSORS	Hand held battery powered electric scissors
LATEX RUBBER	High elongation rubber sheet with 350°F temperature resistance
DRS	Dust collection system
SEWN CONSTRUCTION BLANKETS	Insulating (reusable) blankets or edge breathers made to Customer's specifications

IMPRESSION SET "V"

Pre-fit Verification Film

DESCRIPTION:

IMPRESSION SET "V" is a multipurpose .012" (.3mm) thick Fluorescent vinyl based film designed to take and set the imprint of metallic and non-metallic details during pre-fit of sub-assemblies, including face sheets to structural foam core and honeycomb core. **IMPRESSION SET "V"** is intended to be used where other pre-fit inspections cannot be accomplished or easily verified.

APPLICATION:

IMPRESSION SET "V" can be applied to the sub-assemblies to simulate a bond line or mating joint and will take on the same configuration as the simulated bond line or mating surfaces. The **IMPRESSION SET "V"** can then be inspected to determine if additional steps need to be taken to ensure proper bond lines or fitting.

IMPRESSION SET "V" can be processed at temperatures from 150° F (65°C) up to 200°F (93°C) and minimal pressure will provide adequate imprints for analysis.

PHYSICAL PROPERTIES:

Film color:	Fluorescent Red	
Film thickness:	.012	.3 mm
Width:	56"	1.42 m
Roll length:	50 yards	45.7 m
Elongation:	250%	
Tensile strength:	3600 PSI	24.8MPa
Softening Point:	150°F	65°C

Other colors and thicknesses may be available.

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<i>SHRINK TAPE II</i>
Oriented Polyester Tape

DESCRIPTION:

SHRINK TAPE II is an oriented polyester tape designed to shrink during the cure cycle and apply pressure to the composite lay-up or adhesive bond.

APPLICATION:

SHRINK TAPE II is normally wrapped over the laminate on the mold with pressure sensitive tape put in place to prevent movement during cure. The assembly is then exposed to heat and the **SHRINK TAPE II** begins applying pressure (onset of shrink) at 175°F (79°C) with maximum shrinkage at 400°F (205°C). **SHRINK TAPE II** is available with or without perforations or release agent coating.

PHYSICAL PROPERTIES:

Roll width:	1.25" and 2.50"	3.17 cm & 6.33 cm
Roll length:	100 yards.	91.4 m
Shrinkage:	20 % maximum	
Onset	175°F	79°C
Maximum use temperature:	400°F	205°C

Other widths are available.

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SHRINK TAPE III

PVA Shrink Tape

DESCRIPTION:

SHRINK TAPE III is an oriented PVA tape designed to shrink during the cure cycle and apply pressure to the composite lay-up or adhesive bond.

APPLICATION:

SHRINK TAPE III is normally wrapped over the laminate on the mold with pressure sensitive tape put in place to prevent movement during cure. The assembly is then exposed to heat and the **SHRINK TAPE III** begins applying pressure (onset of shrink) at 190°F (88°C) with maximum shrinkage at 300°F (149°C).

PHYSICAL PROPERTIES:

Roll width:	1.25" and 2.50"	3.17 cm & 6.33 cm
Roll length:	100 yards.	91.4 m
Shrinkage:	<15 % maximum	
Onset	190°F	88°C
Maximum use temperature:	300°F	149°C

Other widths are available.

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CUREPAD

Non-Silicone Tooling Rubber

DESCRIPTION:

CUREPAD is a "B-staged" non-silicone rubber that can be formed into complex shapes to assist in the even application of pressure on assemblies. **CUREPAD** should be used where normal bagging procedures cause difficulty in preventing bridged conditions. **CUREPAD** can also be used where normal bagging procedure could cause unwanted mark off on the assembly.

CUREPAD is not a silicone product and requires a release media between the rubber and the assembly being cured. Normal mold release products work well with Curepad.

APPLICATION:

CUREPAD should be used where it can assist in the even distribution of cure pressure and where a high quality surface is necessary. **CUREPAD** can be used many times after the material has been formed to the desired shape during the initial cure of the **CUREPAD** assembly. **CUREPAD** can be used as pads for tooling pins, sharp edges, etc. Interleaving with a fiberglass cloth during the initial **CUREPAD** forming cure can increase the durability of **CUREPAD** as well as reduce the effects of shrinkage during subsequent cures.

PHYSICAL PROPERTIES:

Standard thickness:	0.062" and .125"	1.57mm and 3.17mm
Standard widths:	40" and 54"	1.02m and 1.37m
Roll length:	50'	15.2 m
Standard cure temperature:	350°F	177°C) for 1 hr.
Standard cure pressure:	>25 PSI.	175 MPa
Standard cure duration:	60 minutes at temperature	
Maximum use temperature:	400°F	205°C

NOTE: Shelf life limitations apply.

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CURETAPE-127

Non-Silicone Tooling Rubber

DESCRIPTION:

CURETAPE 127 is a "B-staged" non-silicone rubber that can be formed into complex shapes to assist in the even application of pressure on assemblies. **CURETAPE 127** should be used where normal bagging procedures cause difficulty in preventing bridged conditions.

CURETAPE 127 is not a silicone product and requires a release film between the rubber and the assembly being cured.

APPLICATION:

CURETAPE 127 should be used to minimize bridging problems and provide even distribution of cure pressure where a high quality surface is necessary. **CURETAPE 127** is not intended to be a reusable system. **CURETAPE 127** can be used as pads for tooling pins, sharp edges, etc.

PHYSICAL PROPERTIES:

Standard thickness:	.125"	3.17mm
Standard widths:	.750" and 1.00"	19 mm and 25.4 mm
Roll length:	25'/rl.	7.6 m
Maximum cure temperature	>175°F	49°C

NOTE: Shelf life limitations apply.

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RICHDAM SE

Silicone Rubber Resin Dam

DESCRIPTION:

RICHDAM SE is a fully-cured silicone rubber damming material with a fully cured Silicone or Acrylic adhesive backing.

APPLICATION:

RICHDAM SE controls the outward resin flow from a composite lay up or metal bond assembly. It also prevents the resin from flowing into vacuum valves potentially causing failure of the vacuum system. **RICHDAM SE** can be used with all resin, adhesive and prepreg systems for control of resin flow up to 550°F (287°C). Being fully cured silicone, **RICHDAM SE** removes easily for the finished part.

PHYSICAL PROPERTIES:

Standard width:	1/2" and 3/4"	12.7mm and 19.5mm
Standard thickness:	1/4" and 1/2"	6.35mm and 12.7mm
Durometer:	50 + 5 "Shore D"	
Color:	Red	
Maximum use temperature:	550°F	288°C

When ordering **RICHDAM SE** with Silicone adhesive, refer to **RICHDAM SE –S**. When ordering **RICHDAM SE** with Acrylic adhesive, refer to **RICHDAM SE –A**.

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RICHDAM - 27

Non-Silicone Resin Dam Tape

DESCRIPTION:

RICHDAM-27 is an uncured "B" staged non-silicone rubber that is designed to be used as a highly conformable resin dam tape. **RICHDAM-27** has good tack which makes applying to complex curves easy.

APPLICATION:

RICHDAM-27 controls the outward resin flow from a composite lay up or metal bond assembly.

PHYSICAL PROPERTIES:

Standard thickness:	.125"	3.17mm
Standard width:	.50"	12.7mm
Roll length:	30' roll.	9.1 m)
Maximum use temperature:	400°F	205°C
Rolls/case:	32 rolls	

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FLASHSORB

Excess Flash Absorbent Composite

DESCRIPTION:

FLASHSORB is a high temperature (400°F / 205°C) material suitable for most adhesive bond and co-cure assembly applications. **FLASHSORB** is a composite of Richmond's peel-ply, breather/bleeder and release film. Flash-sorb is custom constructed to the customers needs and is normally used in 2 inch to 6 inch wide tapes however, wide width **FLASHSORB** is available.

APPLICATION:

FLASHSORB is a multi-layered composite material designed to absorb excess adhesive/resin flash from flash line areas or assemblies and when stripped, leaves a virtually "clean-up free" flash line area.

CONSTRUCTION:

All **FLASHSORB** is custom made to customers needs. **FLASHSORB** ordering as follows:

(Example)	61	07	E	6	15
	Peel-Ply	Breather	Release Film	Width in Inch	Length in Feet

MATERIAL IDENTIFIERS:

Peel Plies: **59** = 51789
 61 = 60001
 62 =60002

Breather: **04** = A3000 4
 07 = A3000 7
 10 = RC-3000-10
 10B = RC-3000-10B
 02 = 4819

Release film: **E** = E3760 or **EP** = E3760 perforated
 A = A5000 or **AP** = A5000 perforated
 E4 = E4760 or **E4P** = E4760 perforated
 A6 = A6200 or **A6P** = A6200 perforated

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T. S. B. SYSTEM
(Tool Surface Breathing)

DESCRIPTION:

T.S.B. is a high temperature (400°F / 205°C) material, suitable for use with most adhesive and resin systems, used in the manufacture of fabric reinforced plastic (FRP) laminates or co-curing of FRP sandwich construction assemblies in a single stage.

T.S.B. is a product consisting of a specially designed breather/bleeder and a vapor permeable release film.

T.S.B. can be furnished in roll form or custom constructed to meet the customers needs.

APPLICATION:

T.S.B. is designed to provide a passage for volatiles and gases generated during the curing of the laminates to escape from the tool surface of the assembly. This results in producing an improved porosity free surface, suitable for finishing. Reduces needs for additional glazing and filling needed to produce a cosmetically acceptable surface.

CONSTRUCTION:

All **T.S.B.** is custom-made to customers needs. Order as follows:

(Example)	5819	T	54	12
	Breather	Vapor Permeable Release Film	Width in Inches	Length in Feet

MATERIAL IDENTIFIERS:

Breather: Code 5819

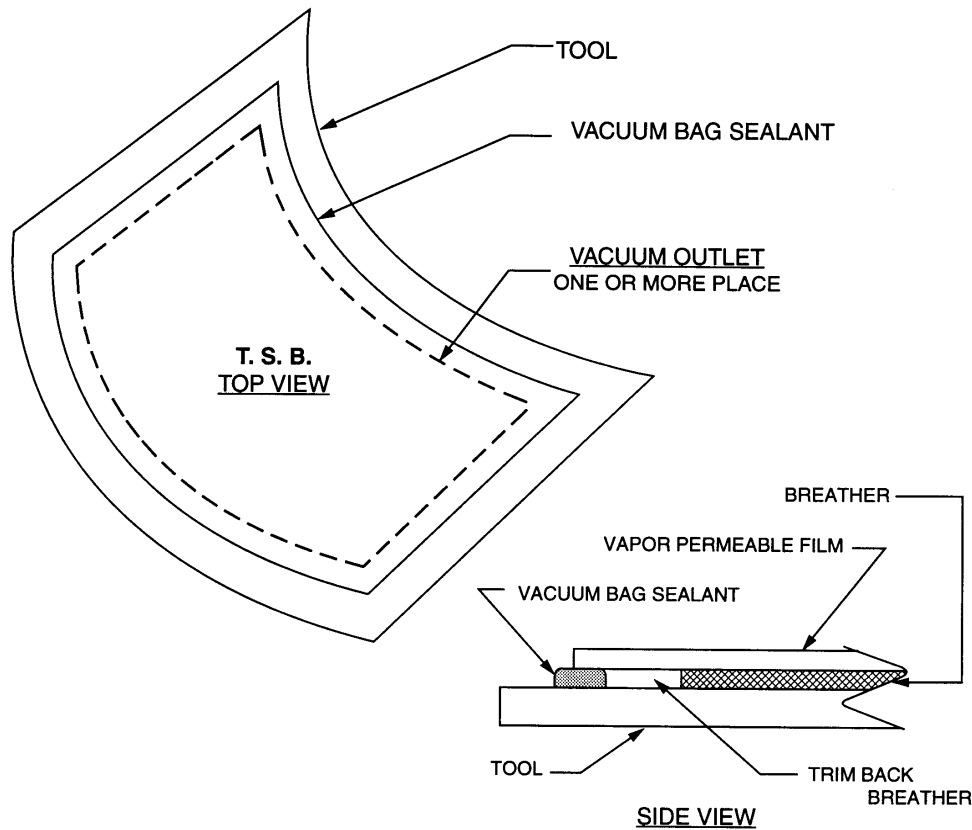
Vapor permeable release film:

- T** - E3760
- P** - E4760
- F** - A5000
- A** - A6200

Other combinations are available

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T. S. B. SYSTEM APPLICATIONS



STEPS

1. Place vacuum bag sealant around periphery of tool (outside edge of laminate).
2. Locate and seal edge of vapor permeable film to sealant. Stretch film slightly, so that when vacuum is applied, the T.S.B. will conform to the tool surface (some hand forming may be required to remove any wrinkles that may form).
3. Insert vacuum probe, apply vacuum.
4. Perform lay up procedures in normal manner (do not cut on bag surface).

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RICHCAST

Cast Polyurethane Table Tops

DESCRIPTION:

RICHCAST is a cast polyurethane tabletop with a moca curing additive that provides a tougher, more durable cutting surface. **RICHCAST** is designed for use as cutting table and workbench tops in the composite shop fabrication area. **RICHCAST** tabletops are available in a variety of colors. Please specify your color preference when inquiring.

APPLICATION:

RICHCAST tabletops are primarily used for composite prepregs and adhesive film cutting tables. **RICHCAST** have a self-healing characteristic that prevents cutting blade deflection from scarred working surfaces or from flaking or chipping that would potentially be a concern of contamination with prepregs, adhesives or other materials coming in contact with the tabletop. **RICHCAST** is suitable for use with ultrasonic cutting devices and forceful methods of cutting.

RICHCAST tabletops are easy to clean with conventional cleaning solutions.

PHYSICAL PROPERTIES:

Standard sizes:	Richcast table tops are made to order. Sizes is to be determined by the customer.
Standard hardness:	90 Shore A (standard)
Color:	To order as specified by the customer.

Other hardness and thickness available.

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PRE-FABRICATED VAC-PAK[®] BAGS AND ASSEMBLIES

Custom Bags for Complex Assemblies

Richmond Aircraft Products Inc. is the industry leader in the manufacture of pre-fabricated vacuum bags or sheets of any shape or size. We can fabricate the bag to customer's specification and can also provide engineering to design a bag for the customer.

With the demand for larger composite structures and metal bonded assemblies, the use of pre-fabricated, pre-shaped vacuum bags become more essential to the vacuum bagging process. Richmond Aircraft Products Inc. has developed new technologies to laminate multiple components of vacuum bagging process materials (i.e. Release Film, Breather and Bag film) into one assembly. This allows the customer to simply un-roll the vacuum bag assembly then simply sealant tape the edges to the tool eliminating many single step operations.

Richmond Aircraft Products Inc. has the finest state-of-art equipment and many years of expertise in the manufacture of prefabricated bags.

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RAP-PID CUT

Rotary Cutting System and Cutting Devices

DESCRIPTION:

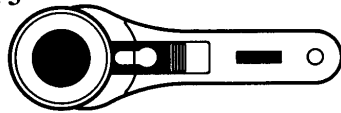
RAP-PID CUT is a heavy duty, hand held rotary wheel cutting system with a built-in adjustable brake for easy control cutting depth, as well as an automatic safety to cover the cutting wheel when not in use.

APPLICATION:

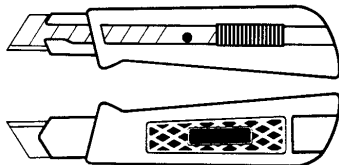
RAP-PID CUT is designed as a manual method to safely and easily cut prepregs, adhesive, bag film, peel plies, breather materials and other film and cloth materials used in composite industry. **RAP-PID CUT** is simple to operate and requires only light downward pressure on the cutting wheel to provide a quick and easy cut.

Also available are other **SPECIALTY CUTTING DEVICES** such as: Kevlar Shears, Snap Off Blade Cutters, Compass Cutters, Panel Cutters and many different configurations of **WORK KNIVES**.

RT-1,2, & 3



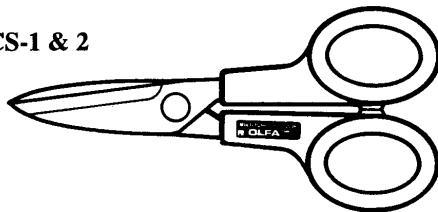
AL



180



SCS-1 & 2



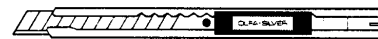
L-2



A



SVR-1



NOTE: Replacement cutting wheels and blades are available upon request.

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ELECTRIC SCISSORS KIT

Fabric and Film cutting system

DESCRIPTION:

Electric Scissors is a hand held, lightweight, ergonomically designed, multi-use cutting tool.

Electric Scissors Kit includes the electric scissors handle, standard blade set, blade set with shoe, rechargeable battery, battery charger, AC adaptor and a 110V transformer.

Electric Scissors features a lightweight, ergonomically design for comfort and easy use, changeable and replaceable blades, rechargeable battery with holder. **Electric Scissors** are safe and easy to operate.

APPLICATION:

Electric Scissors easily cuts fabrics (Fiberglass, Graphite, Kevlar, Polyester, Nylons etc.) with minimal fiber orientation disturbance, cuts breather materials, films, foil and fiber mat materials.

Electric Scissors are not recommended for cutting prepreg materials, as resin buildup will affect the operating performance of the blades.

REPLACEMENT PARTS:

Standard blade set
Blade set with shoe
Rechargeable battery
Battery charger
AC adaptor
110V transformer



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LATEX RUBBER SHEET

High Elongation, High Temperature Non-Silicone

DESCRIPTION:

Our **Latex Rubber** Sheet is a specially formulated high elongation and high temperature (up to 350°F) for short periods of time. This material also exhibits good tensile strength as well as excellent tear and abrasion resistance.

APPLICATION:

In a sheet form **Latex Rubber** Sheet can be used as a debulk bag and oven cures. The material will not take a “set” and will return to its natural flat shape even after multiple cycles. The **Latex Rubber** can also be formed into complicated shapes for internal pressure bladders or be used as conformal vacuum bags.

PHYSICAL PROPERTIES:

Color:	Beige	
Thickness:	.012” - .048”	.3mm – 1.2mm
Tensile strength:	4177 PSI	28.8 MPa
Elongation:	900%	
Maximum use temperature:	350°F	177°C

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DRS – DUST COLLECTING PADS

DESCRIPTION:

DRS Dust Removal System is a hand held tacky cleaning rollers and cleaning pads. The **DRS** dust removal system is the ultimate tool for cleaning particulate contaminant. Unwanted particles as small as one micron are readily removed from the substrate.

APPLICATION:

The **DRS** Dust Removal System cleans by passing the **DRS** roller over a flat surface. The tacky polymer of the roller lifts particulate matter from the surface without liquids or sprays. The roller can be cleaned by passing it directly onto the **DRS** Cleaning Pad surface
Great for removing dust and particulate contaminates
Ideal for use in clean rooms, glass lamination facilities
Completely reusable for numerous cycles



ORDERING GUIDE:

Roller width: 6", 12" or 18"
Handle angle: Straight, 30°, 90° or straight-double handle
Weight: Standard or Light
Tack level: Low, Medium or High

Start-up kit: 1 Hand Roller.
5 Cleaning Pads.
1 Cleaning Pad Holder.

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SEWN CONSTRUCTION BLANKETS

Dedicated Insulation and Breather Blankets

DESCRIPTION:

RICHMOND AIRCRAFT PRODUCTS can fabricate blankets for internal or external use on bagged assemblies. These blankets are intended to provide insulation and/or breathing for the assembly being manufactured.

A variety of materials can be used in the fabrication of the blankets including release treated covers to prevent adherence of the blanket to the resin from the assembly.

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