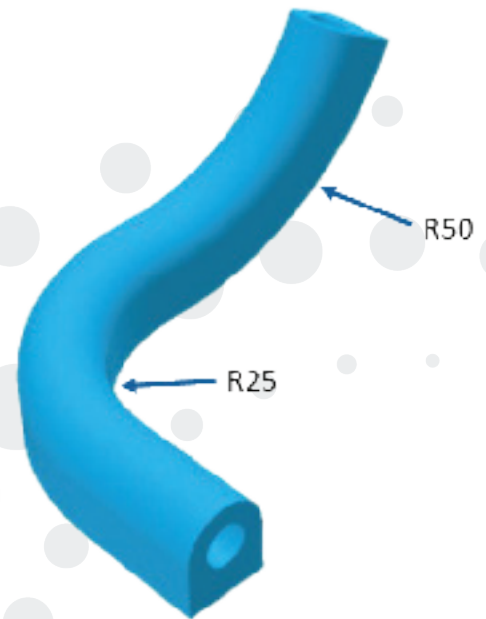


## DATASHEET

# 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.

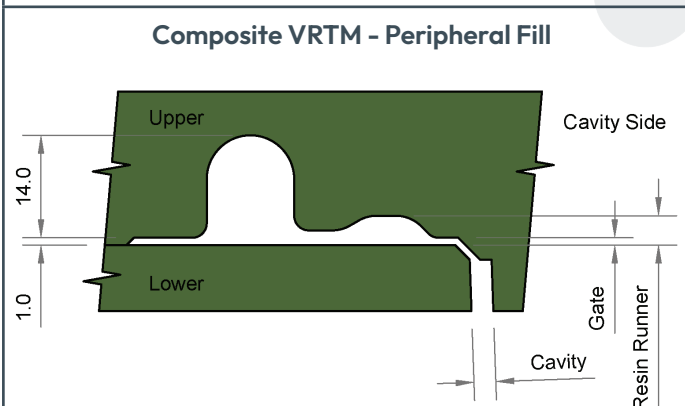
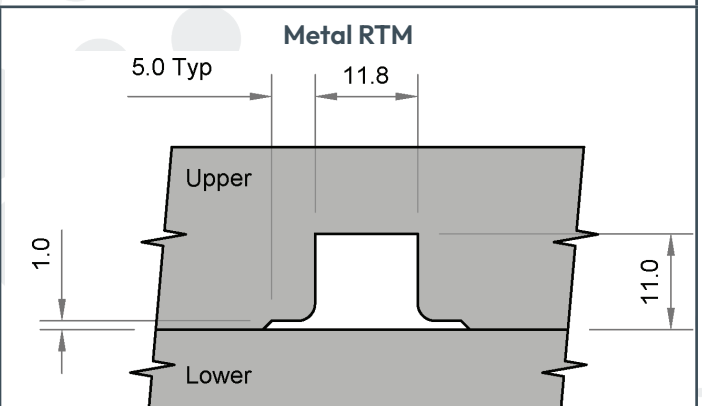
General Specifications	
Silicone Type:	General purpose
Colour	Blue
Overall Height	14 mm
Overall Width	12 mm
Cross Sectional Area	124 mm <sup>2</sup>
Shore Hardness	55 shore
Service Temperature	Continuous use: maximum 180°C Single use: Maximum 200°C
Compressive Force	9 kN/m *to fully close mould seal on a metal RTM channel
Shelf Life	5 - 10 years *if stored correctly



### 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.

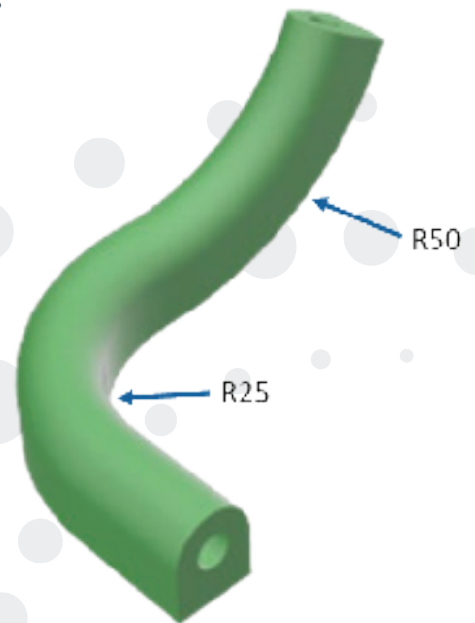
Composite VRTM - Peripheral Fill	Metal RTM
 <p>D seal groove to suit RD-20-0013 or RD-20-0011. Use RD-20-0010 (white) to form groove. Use RD-20-0016 (red) to form resin runner. Blend edge of groove R2 Typ.</p>	 <p>D seal groove to suit: RD-20-0010 (white), RD-20-0011 (green) and RD-20-0013 (blue). Runner detail varies on application.</p>

## DATASHEET

# MOULD SEAL: RD-20-0011

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

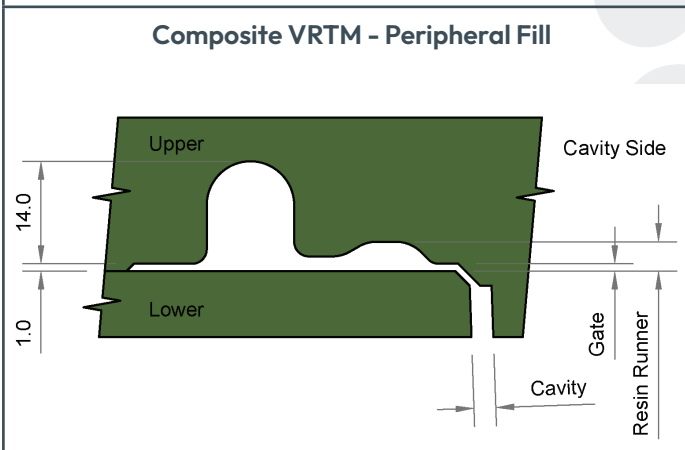
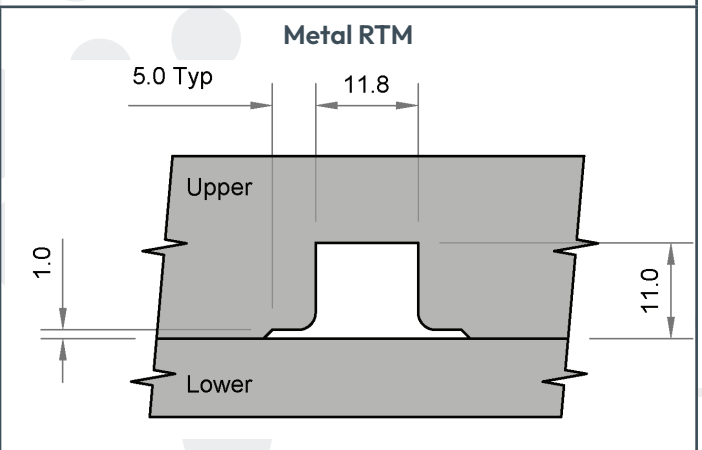
General Specifications	
Silicone Type:	General purpose
Colour	Green
Overall Height	14 mm
Overall Width	12 mm
Cross Sectional Area	133 mm <sup>2</sup>
Shore Hardness	55 shore
Service Temperature	Continuous use: maximum 180°C Single use: Maximum 200°C
Compressive Force	16 kN/m *to fully close mould seal on a metal RTM channel
Shelf Life	5 - 10 years *if stored correctly



### 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.

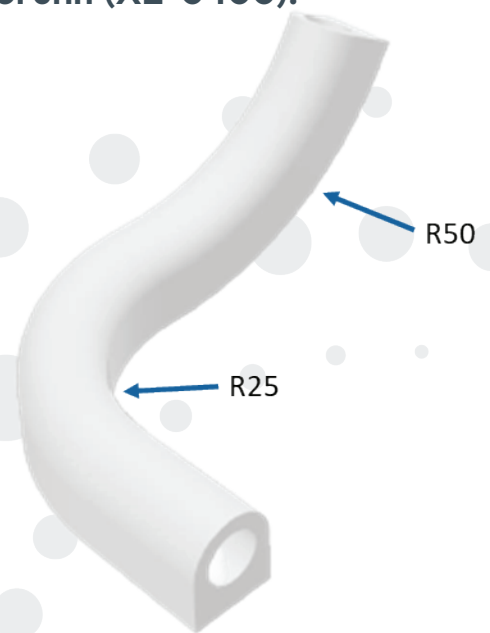
Composite VRTM - Peripheral Fill	Metal RTM
 <p>D seal groove to suit RD-20-0013 or RD-20-0011. Use RD-20-0010 (white) to form groove. Use RD-20-0016 (red) to form resin runner. Blend edge of groove R2 Typ.</p>	 <p>D seal groove to suit: RD-20-0010 (white), RD-20-0011 (green) and RD-20-0013 (blue). Runner detail varies on application.</p>

## 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).

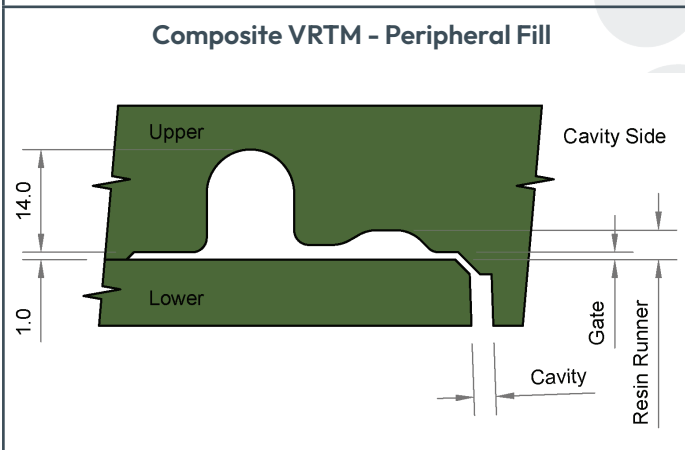
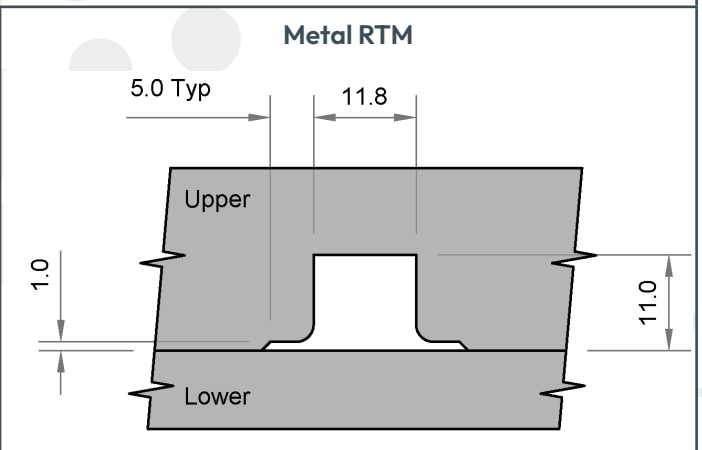
General Specifications	
Silicone Type:	General purpose
Colour	White
Overall Height	14 mm
Overall Width	12 mm
Cross Sectional Area	109 mm <sup>2</sup>
Shore Hardness	55 shore
Service Temperature	Continuous use: maximum 180°C Single use: Maximum 200°C
Compressive Force	4.5 kN/m *to fully close mould seal on a metal RTM channel
Shelf Life	5 - 10 years *if stored correctly



### 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.

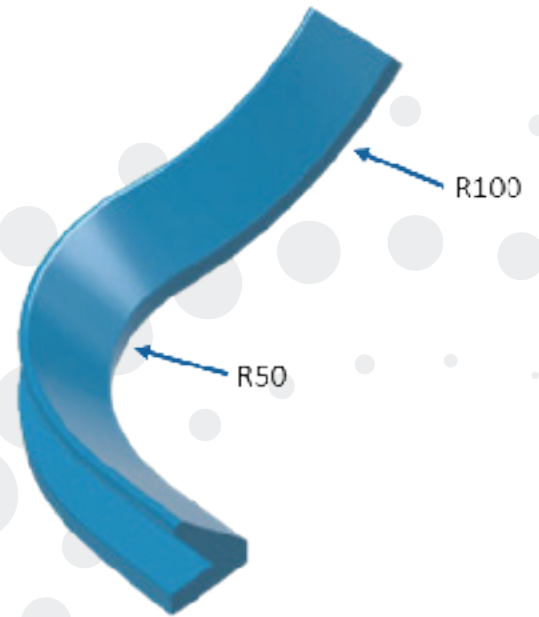
Composite VRTM - Peripheral Fill	Metal RTM
 <p>D seal groove to suit RD-20-0013 or RD-20-0011. Use RD-20-0010 (white) to form groove. Use RD-20-0016 (red) to form resin runner. Blend edge of groove R2 Typ.</p>	 <p>D seal groove to suit: RD-20-0010 (white), RD-20-0011 (green) and RD-20-0013 (blue). Runner detail varies on application.</p>

## DATASHEET

# MOULD SEAL: RD-20-0012

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

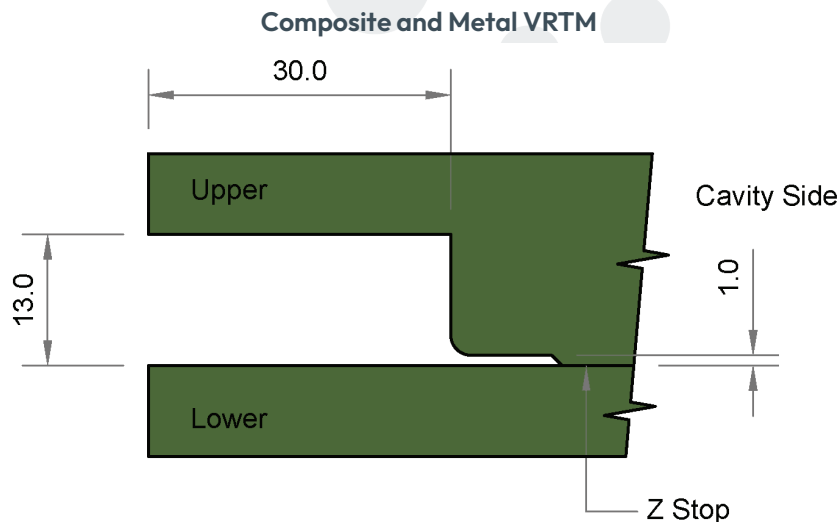
General Specifications	
Silicone Type:	General purpose
Colour	Blue
Overall Height	20 mm
Overall Width	19 mm
Cross Sectional Area	205 mm <sup>2</sup>
Shore Hardness	55 shore
Service Temperature	Continuous use: maximum 180°C Single use: Maximum 200°C
Shelf Life	5 - 10 years *if stored correctly
*All extrusion 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.



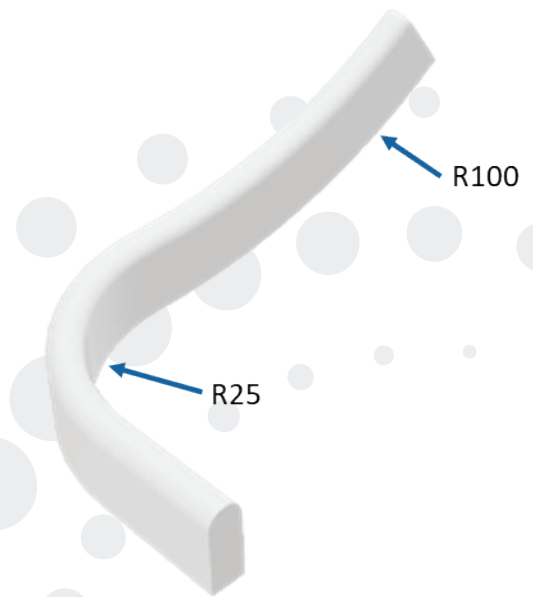
Lip seal groove to suit RD-20-0012. Use RD-20-0017 (white) to form groove. Blend edge of groove R2 Typ.

## 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.

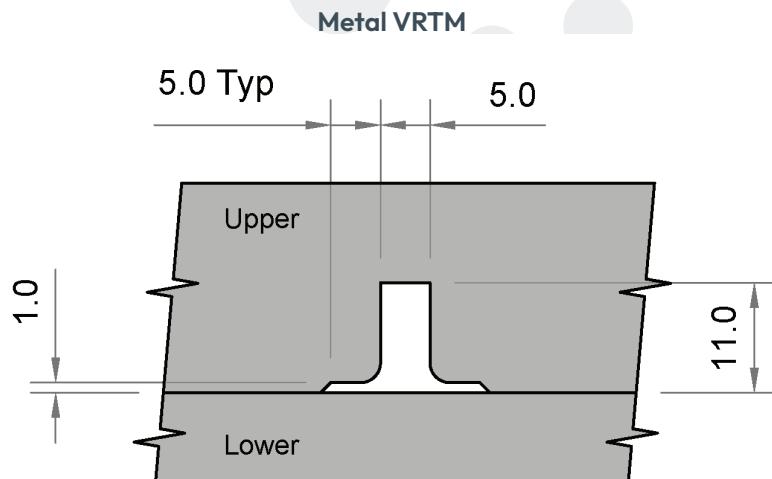
General Specifications	
Silicone Type:	General purpose
Colour	White
Overall Height	12.5 mm
Overall Width	12 mm
Cross Sectional Area	60 mm <sup>2</sup>
Shore Hardness	55 shore
Service Temperature	Continuous use: maximum 180°C Single use: Maximum 200°C
Shelf Life	5 - 10 years *if stored correctly
*All 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.



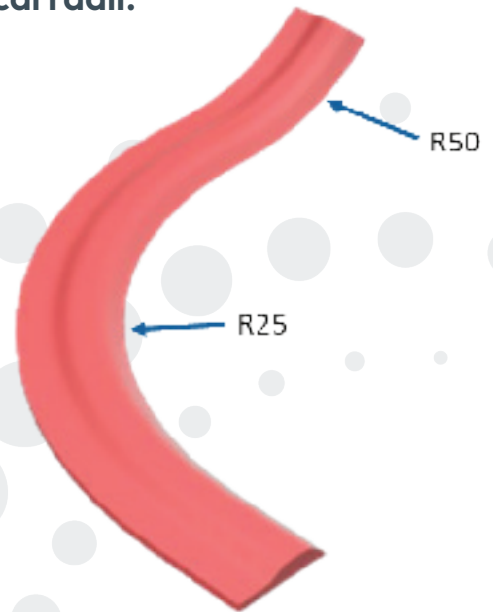
D seal groove to suit RD-20-0009. Runner detail varies on application. Blend edge of groove R2 Typ.

## 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.

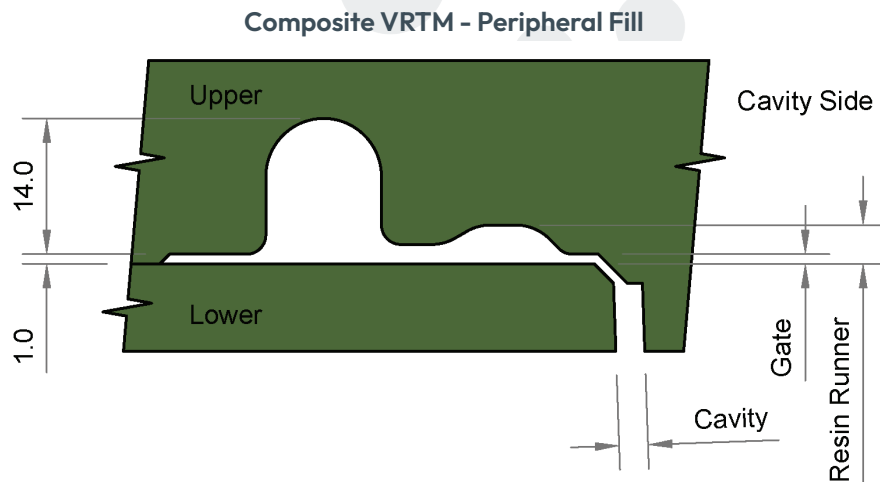
General Specifications	
Silicone Type:	General purpose
Colour	Red
Overall Height	14 mm
Overall Width	12 mm
Cross Sectional Area	55 mm <sup>2</sup>
Shore Hardness	55 shore
Service Temperature	Continuous use: maximum 180°C Single use: Maximum 200°C
Shelf Life	5 - 10 years *if stored correctly
*All extrusion 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.



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.

## 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.

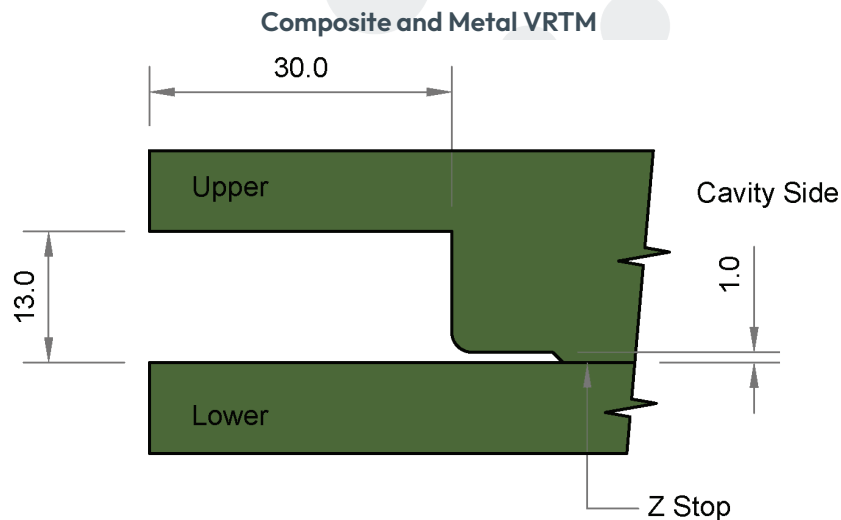
General Specifications	
Silicone Type:	General purpose
Colour	White
Overall Height	25 mm
Overall Width	12 mm
Cross Sectional Area	300 mm <sup>2</sup>
Shore Hardness	55 shore
Service Temperature	Continuous use: maximum 180°C Single use: Maximum 200°C
Shelf Life	5 - 10 years *if stored correctly
*All extrusion 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.



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