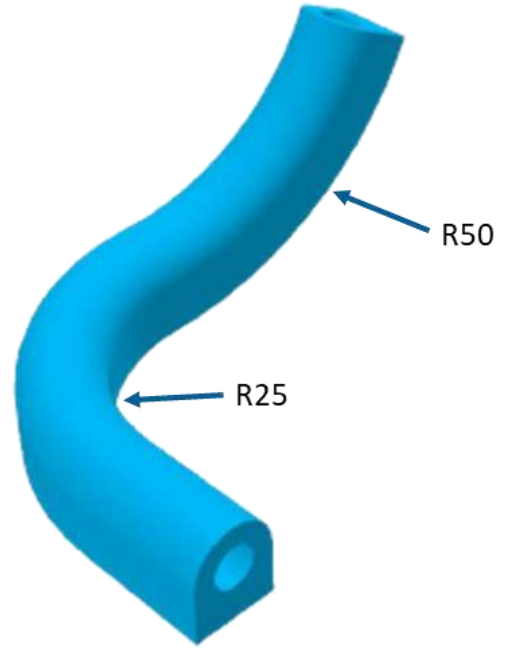


Mould Seal Data Sheet: RD-20-0013

'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 Table E1	

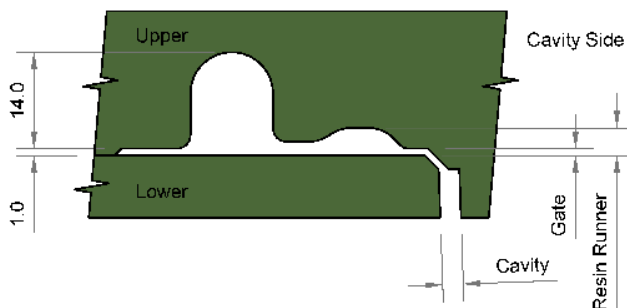


Groove Specifications

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.

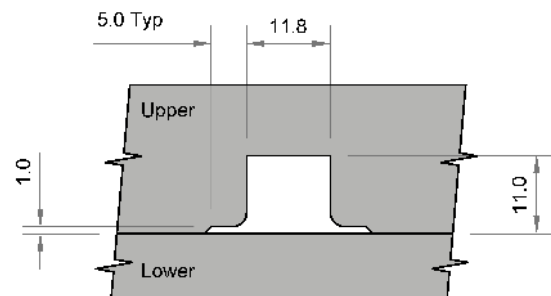
Note: The largest practical bend radius, particularly in the vertical direction for the mould tooling is preferable.

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



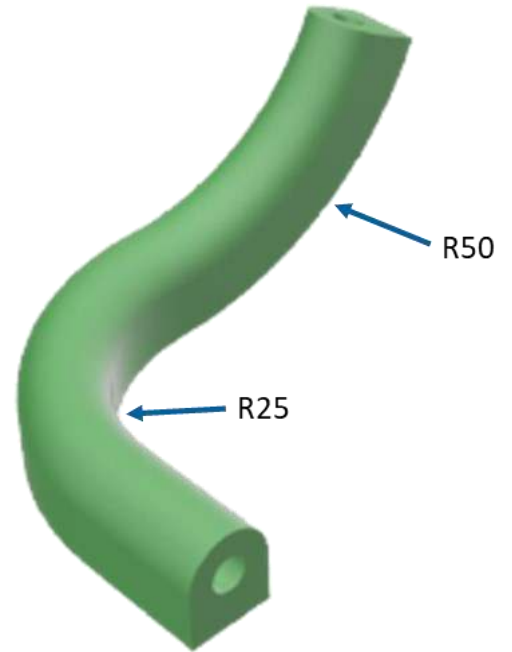
D Seal groove to suit:
RD-20-0010 (white)
RD-20-0011 (green)
RD-20-0013 (blue)
Runner detail varies on application



Mould Seal Data Sheet: 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 Table E1	

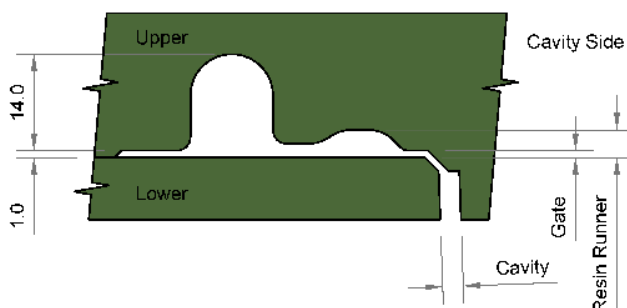


Groove Specifications

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



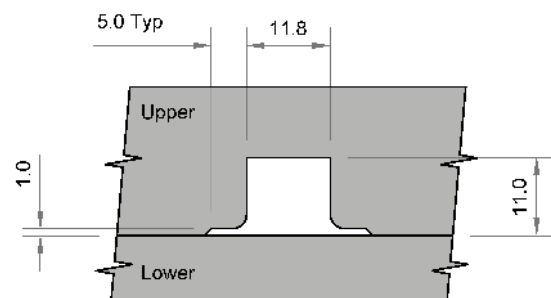
D seal groove to suit RD-20-0013 or RD-20-0011

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)

RD-20-0013 (blue)

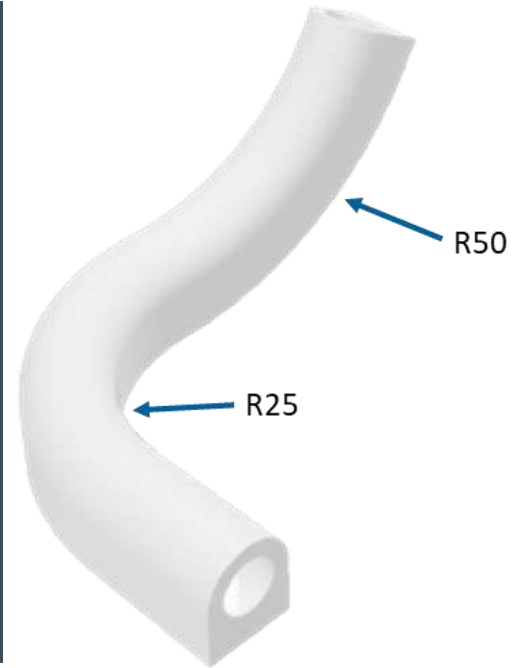
Runner detail varies on application



Mould Seal Data Sheet: 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 Table E1	

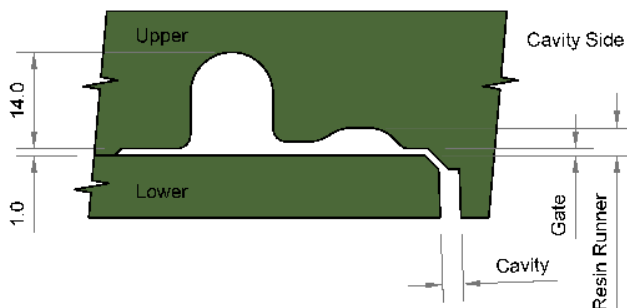


Groove Specifications

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.

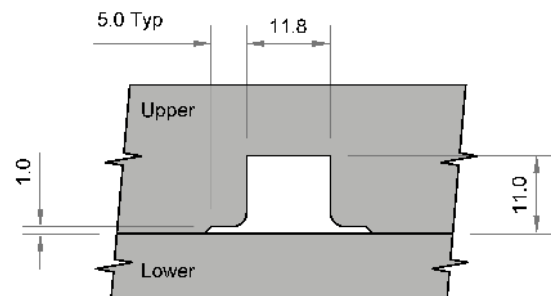
Note: The largest practical bend radius, particularly in the vertical direction for the mould tooling is preferable.

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



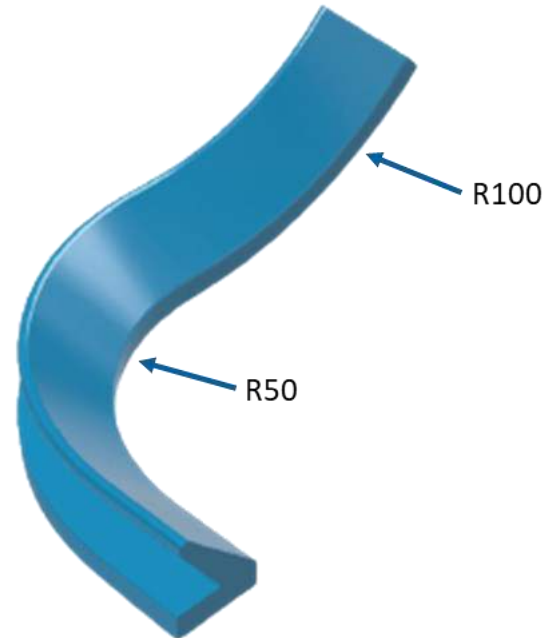
D seal groove to suit:
RD-20-0010 (white)
RD-20-0011 (green)
RD-20-0013 (blue)
Runner detail varies on application



Mould Seal Data Sheet: 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 Table E1	

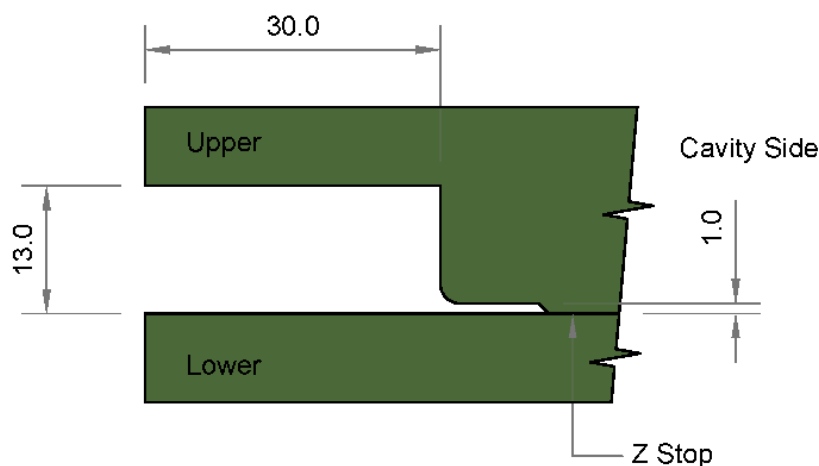


Groove Specifications

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



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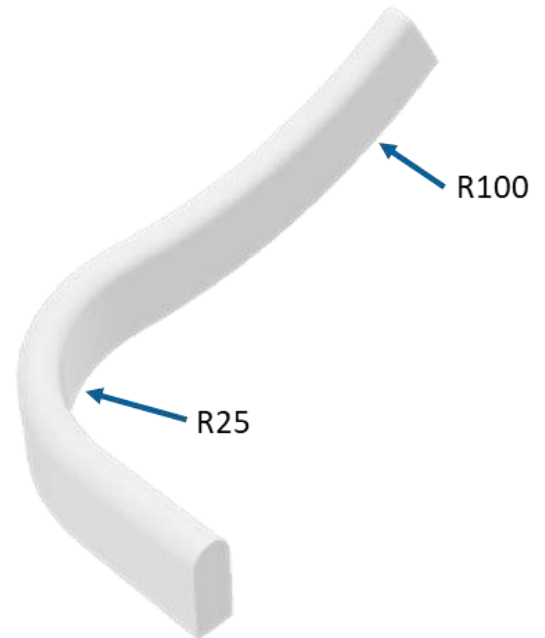
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DS-0018-F Issued: 11.09.2023

Mould Seal Data Sheet: 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 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 Table E1	

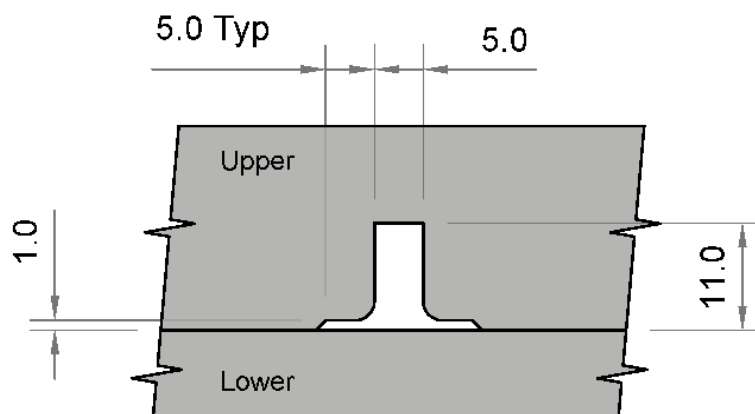


Groove Specifications

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.

Metal VRTM



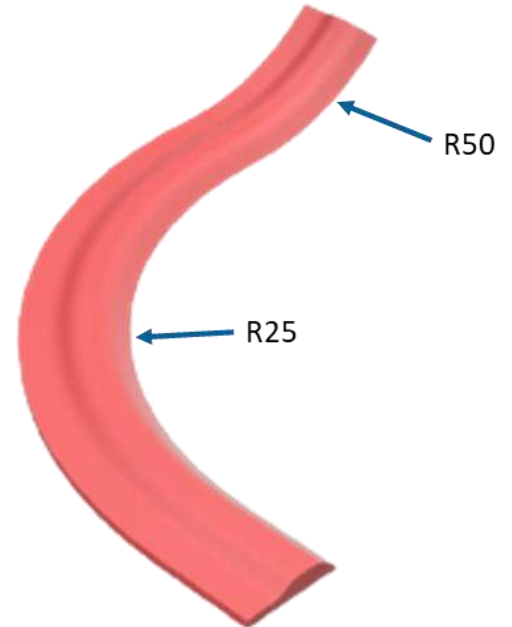
D seal groove to suit RD-20-0009
Runner detail varies on application
Blend edge of groove R2 Typ



Mould Seal Data Sheet: 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 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 Table E1	

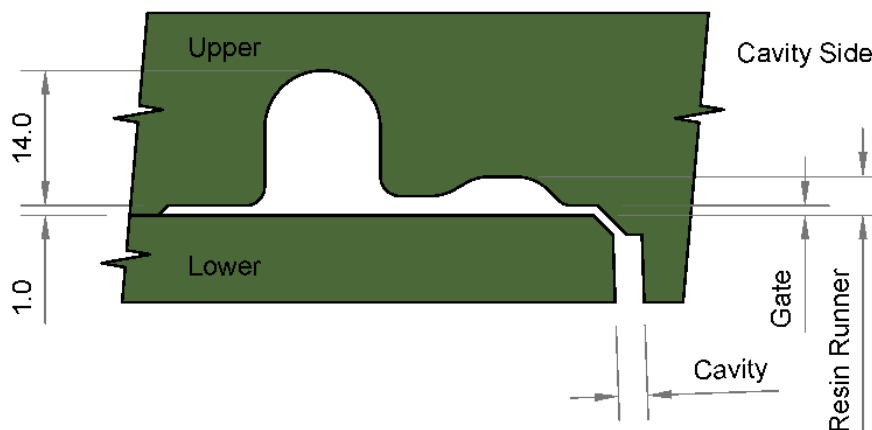


Groove Specifications

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

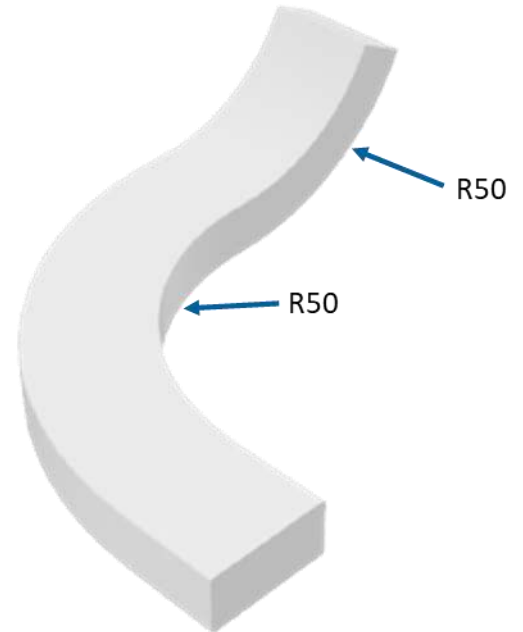
Blend edge of groove R2 Typ



Mould Seal Data Sheet: 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 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 Table E1	

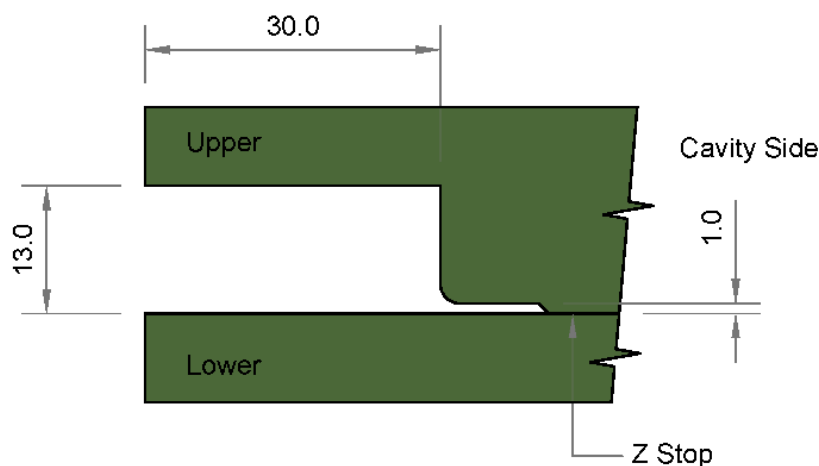


Groove Specifications

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

