

KRAIBON[®] Damp

Features

Calendared IIR-based elastomer film for direct bonding. Adhesion to epoxy pre-pregs, other matrix systems on request.

Application

Optimised for acoustic applications

Processing guidelines

Finishing

Cutting: KRAIBON[®] can be cut using a cutter.

Draping: Like pre-preg, it can be inserted, doubled and draped. During the liquid time (t_{10}), the material flows into the desired shape under the external pressure and can therefore also be molded into complex contours. This means that the elastomer film only has to be finished roughly. The malleability or tack can be increased by heating (not above 100°C) using a hot-air gun.

Hardening/vulcanization

Vulcanization conditions / mixture hardening times

Temperature (°C)	Absolute pressure (bar)	Processing time or liquid time t_{10} (min)	Hardening time t_{90} (min)
120	2.0	5.3	70
130	2.7	2.2	18.0
140	3.6	1.0	8.4
150	4.8	0.5	8.4

The stated hardening times are minimum values. Longer hardening cycles lasting up to around five times the stated hardening time are not critical.

The penetration of atmospheric oxygen during the hardening process inhibits cross-linking and leads to an uncured and sticky surface. To avoid porousness in the elastomer, according to previous experience, the minimum total pressure stated in the table should be adhered to. The pressure in the vacuum bag and the external pressure, e.g. from the autoclave, must be added to this.

Our processing guidelines are based on our experiences and merely represent a technical description of our products. They do not release the buyer from their obligation to check the product for their purposes and processes. Long-term storage by freezing is not covered by the warranty.

Storage

If stored in accordance with DIN 7716, we guarantee a shelf life of 6 months.

Please store the roll in a suspended position if possible to prevent pressure points or to make it less difficult to loosen the film. Freezing the material prolongs the shelf life. When thawed, penetration of condensation must be prevented.

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