

# KRAIBON<sup>®</sup> Temp

## Description

Calendared FKM-based film on 0.5 mm x 500 mm for direct bonding to pre-preg systems.

## Application

- To improve the impact behavior
- To improve the fragment binding when broken
- To improve the component acoustics
- Achievement of a ductile failure pattern
- Avoidance of contact corrosion
- Constrained Layer Damping (CLD)
- To improve the heat resistance
- Resistant to oil and petrol
- Resistant to weather influences

## Processing guideline

### Finishing

**KRAIBON<sup>®</sup>** can be cut with a cutter, scissors, jet water or a die cutter. Cooled material is easier to cut.

Like pre-preg, **KRAIBON<sup>®</sup>** is inserted, doubled and draped. During the liquid time ( $T_{10}$ ), the material flows into the desired shape under pressure and can therefore also be formed into complex contours. To do this, the film only has to be finished roughly. The malleability and tack (stickiness) can be brought to the desired level by heating (not above 100°C) using a hot-air gun / heat channel or similar.

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### Hardening/vulcanization

Vulcanization conditions / mixture hardening times

Temperature (°C)	Min. absolute pressure (bar)	Processing time or liquid time t10 (min)	Hardening time t90 (min)
<b>120</b>	2.0	15	90
<b>130</b>	2.7	6	36
<b>140</b>	3.6	2.5	18
<b>150</b>	4.8	1.1	3.8
<b>160</b>	6.2	0.7	2.0
<b>170</b>	8.0	0.6	1.3

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

Contact with oxygen during the hardening process must be avoided as it inhibits vulcanization and leads to an uncured and sticky surface.

To avoid porousness in the elastomer, 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.

### Storage

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

The calendar rolls must be stored in a suspended position to prevent pressure points or to make it less difficult to loosen the film. Freezing the material significantly prolongs the shelf life. When thawed, penetration of condensation must be prevented.

Version 03/2021

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