

SWORL, Inc.

Dedicated to providing innovative solutions and quality service
(512)846-2444 www.sworl.net

PRSI 308 Viton Strip

Technical Data Sheet

PRSI 308 Viton Strip is utilized during the process of preparing post cured and uncured SWORL reusable vacuum bags to accept the use of Chromate/Bagging tape for use in sealing the bag to the tool flange.

Physical Properties

The physical properties shown below were obtained on 0.080 inch thick molded ATSM samples.

Hardness (Shore A).....	78
Tensile Strength (psi).....	2684
Elongation (%).....	268%
Modulus at 100% Elongation (psi).....	741
Tear Strength (ppi).....	130

Method 1. Bonding Viton or other to newly spray fabricated PRSI 308 bag.

- Step 1 Mask and protect all areas of the tool frame, stand, and floor from all overspray before starting.
- Step 2 Using Chromate tape stack a double layer to the outside edge of the tool.
- Step 3 Use gloves (powder free to eliminate oil or other contamination from fingers). Position clean Viton strips (as received) on the tool flange in the required area. To secure the Viton in place wedge (press) the Viton edge into the previously applied Chromate tape at the tool flange surface. Overlap cuts and splices by .50" minimum. Acetone or other solvent may be used to tack the overlaps together and on Viton to tool surface. Use sparingly--ensure that Viton is fully secure to itself and the flange at the joints to the Viton tap.
- Step 4 Position PRSI 308 Adhesive Tape on top of Viton strips or other, hand roll to ensure uniform contact. Leave a thin outside edge of Viton free of adhesive tape, with the topside release liner in place. Secure the inside edge of the Viton in place by smudging the adhesive tape onto the flange.
- Step 5 Apply a wet bead of PRSI 308 on top of Viton/tape layup. This wet bead will fixture the Viton/tape in place so as to not be disturbed during the spray process. Spray bag to .125" finished thickness.
- Step 6 At 75°F (24°C), allow bag to room temp cure for two hours. Afterwards remove Chromatic tape from the edge, being careful not to disrupt the Viton, adhesive tape, and SWORL bag layer. If required, it is acceptable to cut SWORL bag to remove the tape.

PRSI 308 Viton Strip TDS, continued

Step 7 Envelope the newly formed SWORL bag. Include breather fabric on top of the newly formed SWORL bag contents and envelope or enclose the disposable vacuum bag. UNDER pressure of 60 psi minimum, co-cure all of the materials together for 60 minutes at 300°F (149°C). **QC the bag for quality; repair as necessary before the Post-Cure.**

Alternate Cure process: Two hours at 275°F (135°C) at 60 PSI minimum.

Step 8 Post-Cure: Once QC has been completed for quality, envelope SWORL bag and post-cure the prepared bag at 400°F (205°C) for 4 hours. The bag should be prepared using a layer of breather atop uncured bag but inside of envelope.

Storage and Handling:

PRSI 308 Viton Strip is supplied in 1" wide rolls. Storage in a freezer at temperatures below 40°F (5°C) will ensure shelf stability of at least 6 months. Material should be removed from the freezer and allowed to reach room temperature prior to use. Any moisture that condenses on rubber surface should be removed with a dry cloth. If the surface needs to be freshened, use a cloth saturated with Acetone or MEK solvent. Any unused material should be repackaged and returned to the freezer.

Do not subject the tape to temperature in excess of 302°F (150°C) in an oxygen environment. Before using this product, please refer to the Safety Data Sheet (SDS).

NON – WARRANTY Except for a warranty that the materials supplied substantially comply with the data presented in the Manufacturer's latest bulletin describing the product, "All Materials are sold AS-IS, and without any warranty expressed or implied as to merchantability, fitness for a particular purpose, patent, or any other matter. In no event shall Manufacturer's liability for damages exceed manufacturer's sale price of the particular quantity with respect to which damages are claimed.

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