

## SECTION GUIDE

## Bagging films

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# DATA SHEET

## Securlon® L-500Y

### Economical multi-layer vacuum bagging film

#### ■ DESCRIPTION

Securlon® L-500Y vacuum bag film is a wide multilayer extruded film providing multiple layers of safety. These layers reduce the concerns for "pinholes", weak spots, brittleness and inconsistency in films. Securlon® L-500Y is strong, has a high elongation and is suitable for cure temperatures up to 171 °C. Securlon® L-500Y is not recommended for autoclave applications.

#### ■ TECHNICAL DATA

Material type	Nylon, multi-layer	Test method
Elongation at break	350 %	ASTM D 882
Tensile strength	34 MPa	ASTM D 882
Maximum use temperature	171 °C	
Flammability (self extinguishing)	No	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Colour	Yellow	

#### ■ SIZES

Thickness	Width	Length	Weight/ roll	Forms available *
50 µm	1,2 m	610 m	37 Kg	SHT
50 µm	2,28 m	305 m	35 Kg	SHT
50 µm	4 m	229 m	47 Kg	CF to 2 m
75 µm	4 m	152 m	46 Kg	CF to 2 m
75 µm	6 m	152 m	54 Kg	SHT (W-fold)
50 µm	7,6 m	167,6 m	60 Kg	SHT (W-fold)

#### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Securlon® L-750

Low cost vacuum bagging film for commercial, marine, and wind energy applications

### ■ DESCRIPTION

Securlon® L-750 is a multi-layer vacuum bagging film that is designed for low cost commercial, marine, wind energy and low temperature applications.

#### **Benefits:**

- > Offers improved performance in low humidity conditions for ease of use
- > Available in multiple mil thicknesses, roll widths, and lengths for use in multiple processes and applications
- > Widths available up to 7,1 meters
- > Multi-layer film for maximum security
- > Packaged and shipped in recyclable materials.

### ■ TECHNICAL DATA

		Test method
Material type	Multi-layer	
Elongation at break	350 %	ASTM D 882
Tensile strength	27,5 MPa	ASTM D 882
Maximum use temperature	177 °C	
Materials to avoid	Phenolic resins/Strong oxidizers	
Colour	Milky violet	

### ■ SIZES

A variety of sizes (width, thickness and length) available. Widths available up to 7,1 meters. Contact Airtech or your local distributor for current stock or a specific request.

### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.

# DATA SHEET

## Securlon® L-1000

### Multi-layer vacuum bagging film

#### ■ DESCRIPTION

Securlon® L-1000 vacuum bag film is a multilayer extruded film providing multiple layers of safety. These layers reduce the concerns for "pinholes", weak spots, brittleness and inconsistency in films. Securlon® L-1000 is strong, has a high elongation capability and a temperature resistance up to 202 °C. Securlon® L-1000 vacuum bag film is the most secure nylon film made for high value laminate constructions.

#### ■ TECHNICAL DATA

		Test method
Material type	Nylon, multi-layer	
Elongation at break	500 %	ASTM D 882
Tensile strength	82 MPa	ASTM D 882
Maximum use temperature	202 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Colour	Purple	

#### ■ SIZES

Thickness	Width	Length	Weight / roll	Forms available*
0,002 inch (50 µm)	60 inches (1,52 m)	1000 feet (305 m)	27 Kg	SHT
0,002 inch (50 µm)	80 inches (2,03 m)	750 feet (229 m)	54 Kg	LFT
0,002 inch (50 µm)	120 inches (3,04 m)	500 feet (152 m)	27 Kg	CF to 60 inches

#### ■ NOTES

> Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.

> Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Securlon® L-2000

### Multi-layer vacuum bagging film

#### DESCRIPTION

Securlon® L-2000 vacuum bag film is a multi-layer extruded film providing multiple layers of safety. These layers reduce the concerns for "pinholes", weak spots, brittleness and inconsistency in films. Securlon® L-2000 is strong, has a high elongation capability and a temperature resistance up to 218 °C.

#### TECHNICAL DATA

		Test method
Material type	Nylon, multi-layer	
Elongation at break	450 %	ASTM D 882
Tensile strength	62 MPa	ASTM D 882
Maximum use temperature	218 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Strong oxidizers	
Colour	Blue	

#### SIZES

Thickness	Width	Length	Weight / roll	Forms available*
0,002 inch (50 µm)	60 inches (1,52 m)	1000 feet (305 m)	27 Kg	SHT
0,002 inch (50 µm)	120 inches (3,04 m)	500 feet (152 m)	27 Kg	CF to 60 inches

#### NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.
- > Custom designed shapes and sizes are available to fit your individual requirements.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Big Blue L-100

Inexpensive, low temperature multi-layer bagging film

### ■ DESCRIPTION

Big Blue L-100 vacuum bag film is a multi-layer film for applications where a wide film is required. It is suitable for resin infusion and wet lay-up where the cure temperature does not exceed 121 °C.

### ■ TECHNICAL DATA

Material type	Polyolefin, multi-layer	Test method
Elongation at break	350 %	ASTM D 882
Tensile strength	22 MPa	ASTM D 882
Maximum use temperature	121 °C	
Flammability (self extinguishing)	No	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Colour	Blue	

### ■ SIZES

Thickness	Width	Length	Weight / roll	Forms available*
75 µm	6 m	110 m	50 Kg	SHT (W-fold)
75 µm	8 m	83 m	50 Kg	SHT (W-fold)
75 µm	10 m	67 m	50 Kg	SHT (W-fold)
75 µm	12 m	56 m	50 Kg	SHT (W-fold)

### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Stretchlon® 200

Bagging film with the highest elongation

### ■ DESCRIPTION

Stretchlon® 200 vacuum bag film is a high elongation elastomeric film which can be used for cures up to 121 °C and debulking operations. When parts with multiple contours are vacuum bagged, Stretchlon® 200 is an excellent choice as the high elongation will stretch into complex features. This film is not affected by low humidity environment. It is recommended for cures with epoxy and phenolic resins.

### ■ TECHNICAL DATA

Material type	Thermoplastic elastomer	Test method
Elongation at break	500 %	ASTM D 882
Tensile strength	55 MPa	ASTM D 882
Maximum use temperature	121 °C	
Materials to avoid	Bismaleimide (BMI)/ Polyester and vinylester	
Yield	35,8 m <sup>2</sup> /Kg/25,4 µm	
Colour	Green	

### ■ SIZES

Thickness	Width	Length	Weight / roll	Forms available *
0,0015 inch (38 µm)	60 inches (1,52 m)	2000 feet (610 m)	39 Kg	SHT
0,0015 inch (38 µm)	120 inches (3,04 m)	1000 feet (305 m)	39 Kg	CF to 60 inches

### ■ NOTES

- > Sale and use of the product covered by US Patent n° 5123985.
- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.
- > Customer manufactured shapes are available to fit your individual requirements.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Stretchlon® 255

Economical film for debulk and low temperature cures

### DESCRIPTION

Stretchlon® 255 is an economical film with high elongation intended for debulk applications. Stretchlon® 255 can also be used for low temperature cures up to 124 °C. When used in debulk applications, the high elongation properties of Stretchlon® 255 will result in lower labour costs due to a reduced need for pleating.

### TECHNICAL DATA

Material type	Thermoplastic elastomer	Test method
Elongation at break	>700 %	ASTM D 882
Maximum use temperature	124 °C	
Materials to avoid	Polyester and vinylester	
Yield	32,3 m <sup>2</sup> /Kg/25,4 µm	
Colour	Semi opaque yellow	

### SIZES

Thickness	Width	Length	Weight / roll	Forms available*
0,002 inch (50 µm)	60 inches (1,52 m)	1000 feet (305 m)	14,3 Kg	SHT
0,002 inch (50 µm)	120 inches (3,04 m)	1000 feet (305 m)	28,7 Kg	CF to 60 inches
0,003 inch (75 µm)	60 inches (1,52 m)	1000 feet (305 m)	21,5 Kg	SHT
0,003 inch (75 µm)	120 inches (3,04 m)	750 feet (229 m)	32,3 Kg	CF to 60 inches

### NOTES

> Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.  
> Other sizes available up to 80 inches CF (opens to 160 inches SHT) for further reducing the costs of debulking large parts. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = Lay-flat tubing gusseted.



# DATA SHEET

## Stretchlon® HT-350

High temperature, high elongation vacuum bagging film

### DESCRIPTION

Stretchlon® HT-350 is a higher temperature version of Stretchlon® 200.

Stretchlon® HT-350 can be used with all standard epoxy resin systems. The very high elongation makes this film easy to use on contour lay-ups and is an excellent choice for ply compaction. It is not recommended for autoclave processing.

This film is not affected by low humidity conditions.

It is not suitable for use with polyester or vinylester resins.

### TECHNICAL DATA

		Test method
Material type	Thermoplastic elastomer	
Elongation at break	>550 %	ASTM D 882
Tensile strength	62 MPa	ASTM D 882
Maximum use temperature	162 °C	
Materials to avoid	Polyester and vinylester	
Yield	34,3 m <sup>2</sup> /Kg/25,4 µm	
Colour	Grey	

### SIZES

Thickness	Width	Length	Weight / roll	Forms available *
0,003 inch (75 µm)	120 inches (3,04 m)	750 feet (229 m)	60,8 Kg	CF to 60 inches

### NOTES

> Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.

> Other sizes upon request. Minimum order quantity required.

> Customer manufactured shapes are available to fit your individual requirements.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = Lay-flat tubing gusseted.

# DATA SHEET

## Stretchlon® 700

Bagging film with an excellent flexibility

### DESCRIPTION

Stretchlon® 700 vacuum bag film is a high elongation elastomeric film which is designed for cures up to 195 °C. It is particularly suitable for applications where softness and elongation are required. The risk of bridging in the corners is highly reduced due to the elasticity of the film. This film stays soft even in a very low humidity environment.

Stretchlon® 700 is recommended for cures with phenolic and epoxy resins.

Small tubes are available from 2 inches to 22 inches.

### TECHNICAL DATA

		Test method
Material type	Thermoplastic elastomer	
Elongation at break	500 %	ASTM D 882
Tensile strength	45 MPa	ASTM D 882
Maximum use temperature	195 °C	
Materials to avoid	Bismaleimide (BMI) / Polyester and vinylester	
Yield	32,0 m <sup>2</sup> /Kg/25,4 µm	
Colour	Cream	

### SIZES

Thickness	Width	Length	Weight / roll	Forms available *
0,003 inch (75 µm)	60 inches (1,52 m)	1000 feet (305 m)	44 Kg	SHT
0,003 inch (75 µm)	120 inches (3,04 m)	500 feet (152 m)	44 Kg	CF to 60 inches

### NOTES

- > Sale and use of the product covered by US Patent n° 5123985.
- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.
- > Customer manufactured shapes are available to fit your individual requirements.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Stretchlon® 800

Soft, flexible nylon bagging film

### ■ DESCRIPTION

Stretchlon® 800 vacuum bag film has the highest elongation from all nylon films and is suitable for cure temperatures up to 204 °C. When parts with multiple contours are vacuum bagged, Stretchlon® 800 is a good choice offering to stretch into most areas. This film is designed to remain more flexible than standard nylon films in low humidity conditions. Stretchlon® 800 is recommended for epoxy and BMI resins.

### ■ TECHNICAL DATA

		Test method
Material type	Nylon	
Elongation at break	450 %	ASTM D 882
Tensile strength	69 MPa	ASTM D 882
Maximum use temperature	204 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Yield	34,8 m <sup>2</sup> /Kg/25,4 µm	
Colour	Orange	

### ■ SIZES

Thickness	Width	Length	Weight / roll	Forms available*
0,002 inch (50 µm)	60 inches (1,52 m)	1000 feet (305 m)	27 Kg	SHT
0,002 inch (50 µm)	120 inches (3,04 m)	1000 feet (305 m)	54 Kg	CF to 60 inches

### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.
- > Customer manufactured shapes are available to fit your individual requirements.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

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# DATA SHEET

## Stretchlon® 850

High flexible bagging film

### DESCRIPTION

Stretchlon® 850 is a high elongation film in tube form with a good softness which will conform to complex contours. This film is designed to remain more flexible than standard nylon films in low humidity conditions. Stretchlon® 850 is recommended for epoxy and BMI resins. Small tubes are available from 2 inches to 22 inches. For sheeting, see Stretchlon® 800.

### TECHNICAL DATA

		Test method
Material type	Nylon	
Elongation at break	450 %	ASTM D 882
Tensile strength	82 MPa	ASTM D 882
Maximum use temperature	204 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Yield	34,5 m <sup>2</sup> /Kg/25,4 µm	
Colour	Orange	

### SIZES

Thickness	Width	Length	Weight / roll	Forms available*
0,002 inch (50 µm)	27 inches (0,68 m)	1000 feet (305 m)	25 Kg	LFT
0,002 inch (50 µm)	36 inches (0,91 m)	1000 feet (305 m)	33 Kg	LFT
0,002 inch (50 µm)	48 inches (1,21 m)	1000 feet (305 m)	44 Kg	LFT
0,002 inch (50 µm)	54 inches (1,37 m)	1000 feet (305 m)	49 Kg	LFT
0,002 inch (50 µm)	60 inches (1,52 m)	1000 feet (305 m)	54 Kg	LFT
0,002 inch (50 µm)	72 inches (1,82 m)	1000 feet (305 m)	65 Kg	LFT
0,002 inch (50 µm)	80 inches (2,03 m)	750 feet (229 m)	54 Kg	LFT
0,002 inch (50 µm)	90 inches (2,29 m)	750 feet (229 m)	61 Kg	LFT

### NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.
- > Customer manufactured shapes are available to fit your individual requirements.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Ipplon® KM1300

Soft nylon film with a high elongation

### ■ DESCRIPTION

Ipplon® KM1300 is a vacuum bagging film with a good elongation and is suitable for cure temperatures up to 212 °C. It is recommended for bagging applications where a higher softness is required. An excellent film for autoclave use or resin infusion.

### ■ TECHNICAL DATA

		Test method
Material type	Nylon	
Elongation at break	425 %	ASTM D 882
Tensile strength	48 MPa	ASTM D 882
Maximum use temperature	212 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Yield	34,8 m <sup>2</sup> /Kg/25,4 µm	
Colour	Pink	

### ■ SIZES

Consult the dimensional chart in this section for dimensional information. Other sizes available on special order.

### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Custom designed shapes are available to fit your individual requirements. Please consult Airtech for further information.
- > Minimum order quantity required.

# DATA SHEET

## Ipplon® DP1000

Soft nylon film with an excellent elongation

### ■ DESCRIPTION

Ipplon® DP1000 is a vacuum bagging film with a high elongation and is suitable for cure temperatures up to 212 °C. It is recommended for bagging applications where a higher softness is required.

### ■ TECHNICAL DATA

		Test method
Material type	Nylon	
Elongation at break	450 %	ASTM D 882
Tensile strength	48 MPa	ASTM D 882
Maximum use temperature	212 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Yield	34,8 m <sup>2</sup> /Kg/25,4 µm	
Colour	Salmon	

### ■ SIZES

Consult the dimensional chart in this section for dimensional information. Other sizes available on special order.

### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Custom designed shapes are available to fit your individual requirements. Please consult Airtech for further information.
- > Minimum order quantity required.

# DATA SHEET

## Ipplon® DPT1000

High temperature nylon bagging film with a good elongation

### ■ DESCRIPTION

Ipplon® DPT1000 is a heat-stabilised nylon film for cure temperatures up to 246 °C. Ipplon® DPT 1000 can be used when high temperature and high pressure are required. It is the recommended material for cures with phenolic resins.

### ■ TECHNICAL DATA

		Test method
Material type	Nylon	
Elongation at break	375 %	ASTM D 882
Tensile strength	62 MPa	ASTM D 882
Maximum use temperature	246 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Strong oxidizers	
Yield	34,5 m <sup>2</sup> /Kg/25,4 µm	
Colour	Orange	

### ■ SIZES

Consult the dimensional chart in this section for dimensional information. Other sizes available on special order.

### ■ NOTES

- > Maximum use temperature is dependant upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Minimum order quantity required.

# DATA SHEET

## Ipplon® WN1500

High temperature nylon bagging film with a good elongation

### ■ DESCRIPTION

Ipplon® WN1500 is a heat-stabilised nylon film for cure temperatures up to 246 °C. Ipplon® WN1500 can be used when high temperature and high pressure are required. Ipplon® WN1500 is the recommended material for cures with phenolic resins.

### ■ TECHNICAL DATA

		Test method
Material type	Nylon	
Elongation at break	375 %	ASTM D 882
Tensile strength	62 MPa	ASTM D 882
Maximum use temperature	246 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Strong oxidizers	
Yield	34,5 m <sup>2</sup> /Kg/25,4 µm	
Colour	Blue	

### ■ SIZES

Consult the dimensional chart in this section for dimensional information. Other sizes available on special order.

### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Minimum order quantity required.



# DATA SHEET

## Wrightlon® 5400

### Standard medium temperature nylon vacuum bagging film

#### ■ DESCRIPTION

WL5400 is a nylon bagging film with a good elongation for cure temperatures up to 177 °C.

#### ■ TECHNICAL DATA

		Test method
Material type	Nylon	
Elongation at break	375 %	ASTM D 882
Tensile strength	48 MPa	ASTM D 882
Maximum use temperature	177 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Yield	34,8 m <sup>2</sup> /Kg/25,4 µm	
Colour	Clear	

#### ■ SIZES

Consult the dimensional chart in this section for dimensional information. Other sizes available on special order.

#### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Custom designed shapes are available to fit your individual requirements. Please consult Airtech for further information.
- > Minimum order quantity required.

# DATA SHEET

## Wrightlon® 7400

### Vacuum bagging film

#### ■ DESCRIPTION

WL 7400 is a heat-stabilised nylon film with a high elongation which is suitable for cure temperatures up to 204 °C.

WL7400 is also offered with our embossed, cracked ice pattern making it a breather, release film and vacuum bag all-in-one.

#### ■ TECHNICAL DATA

		Test method
Material type	Nylon	
Elongation at break	400 %	ASTM D 882
Tensile strength	55 MPa	ASTM D 882
Maximum use temperature	204 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Yield	34,8 m <sup>2</sup> /Kg/25,4 µm	
Colour	Green	

#### ■ SIZES

Consult the dimensional chart in this section for dimensional information.  
Other sizes available on special order.

#### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Custom designed shapes are available to fit your individual requirements. Please consult Airtech for further information.
- > Minimum order quantity required.

# DATA SHEET

## Wrightlon® 8400

### High temperature nylon vacuum bagging film

#### ■ DESCRIPTION

WL8400 is a high temperature nylon vacuum bagging film with more than 30 years worldwide proven performance.

It is called out on many aerospace specifications for use temperatures up to 232 °C. It is recommended for cures with phenolic resins.

#### ■ TECHNICAL DATA

		Test method
Material type	Nylon	
Elongation at break	350 %	ASTM D 882
Tensile strength	62 MPa	ASTM D 882
Maximum use temperature	232 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Strong oxidizers	
Yield	34,5 m <sup>2</sup> /Kg/25,4 µm	
Colour	Blue	

#### ■ SIZES

Consult the dimensional chart in this section for dimensional information. Other sizes available on special order.

#### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Minimum order quantity required.

# DATA SHEET

## WL600V

Low cost vacuum bagging film for commercial, wind energy and autoclave applications

### ■ DESCRIPTION

WL600V vacuum bagging film is designed for low cost, commercial applications yet still performs with high pressure autoclave cure cycles.

WL600V has good elongation and stays soft in low humidity conditions.

### ■ TECHNICAL DATA

Elongation at break	400 %	Test method
Tensile strength	62 MPa	ASTM D 882
Maximum use temperature	190 °C	ASTM D 882
Flammability (self extinguishing)	Yes	ATP-5034
Yield	34,5 m <sup>2</sup> /Kg/25,4 µm	
Materials to avoid	Phenolic resins/Strong oxidizers	
Colour	Violet	

### ■ SIZES

Thickness	Width	Length	Weight / roll	Forms available *
0,002 inch (50 µm)	180 inches (4,5 m)	500 feet (152 m)	41 Kg	CF to 90 inches
0,003 inch (75 µm)	180 inches (4,5 m)	500 feet (152 m)	61 Kg	CF 90 to inches

### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Dahlar® Release Bag 125

Economical vacuum bag with excellent release properties

### DESCRIPTION

Dahlar® Release Bag 125 is an economical film designed for both vacuum bagging and release applications. Dahlar® Release Bag 125 can be used for cures up to 141 °C and will release from most resins associated with aerospace, marine, and recreational products. This formulation has improved tear resistance and elongation over products previously offered as low temperature, multiple process films. Dahlar® Release Bag 125 (0,001 inch) is the ideal release film for polyester or vinylester resins as well as epoxies and phenolics. See the release film section. Dahlar® Release Bag 125 is also offered with our embossed, cracked ice pattern making it a breather, release film and vacuum bag all-in-one.

### TECHNICAL DATA

		Test method
Material type	Polyolefin, multi-layer	
Elongation at break	400 %	ASTM D 882
Tensile strength	65 MPa	ASTM D 882
Maximum use temperature	141 °C	
Materials to avoid	Compatible with most resin systems	
Colour	Green	

### SIZES

Thickness	Width	Length	Weight / roll	Forms available *
0,002 inch (50 µm)	60 inches (1,52 m)	2000 feet (610 m)	49 Kg	SHT
0,002 inch (50 µm)	120 inches (3,04 m)	1000 feet (305 m)	49 Kg	CF to 60 inches

### NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Dahlar® Release Bag 375R

### Multi-layer self releasing tubular bagging film

#### DESCRIPTION

Dahlar® Release Bag 375R is a self releasing multi-layer bagging film for direct contact with pre-preg for fabrication of hollow parts such as bicycle components, fishing rods, masts etc. Dahlar® Release Bag 375R exhibits superior strength, temperature resistance and vacuum integrity of Airtech's multi-layer film technology.

Dahlar® Release Bag 375R exhibits excellent release off epoxy and polyester resins.

Dahlar® Release Bag 375R is also available in gusseted folding (LFT-G).

Thanks to the gusset folding, the Dahlar® Release Bag 375R is easier to position accurately in hollow parts. Upon application of pressure the bag will easily expand to fit to the shape of the part which is very useful in applications where there are variations in the part diameter. This development ensures even application of internal pressure in cases of small diameter parts, where the insertion of a standard lay flat tube bagging film can be problematic.

#### TECHNICAL DATA

		Test method
Material type	Nylon, Polyolefin, multi-layer	
Elongation at break	475 %	ASTM D 882
Tensile strength	40 MPa	ASTM D 882
Maximum use temperature	155 °C	
Materials to avoid	Compatible with most resin systems	
Colour	Red	

#### SIZES

Thickness	Width	Length	Weight / roll	Forms available*
0,0027 inch (70 µm)	2 inches (0,050 m)	500 feet (152,4 m)	1,10 Kg	LFT
0,0027 inch (70 µm)	3 inches (0,076 m)	500 feet (152,4 m)	1,59 Kg	LFT
0,0027 inch (70 µm)	4 inches (0,101 m)	500 feet (152,4 m)	2,12 Kg	LFT / LFT-G
0,0027 inch (70 µm)	6 inches (0,152 m)	500 feet (152,4 m)	3,18 Kg	LFT / LFT-G
0,0027 inch (70 µm)	8 inches (0,203 m)	500 feet (152,4 m)	4,24 Kg	LFT / LFT-G
0,0027 inch (70 µm)	12 inches (0,304 m)	500 feet (152,4 m)	6,36 Kg	LFT
0,0027 inch (70 µm)	18 inches (0,457 m)	500 feet (152,4 m)	9,54 Kg	LFT

#### NOTES

- > Elongation at break and tensile strength are measured in transverse direction.
- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Dahlar® Release Bag 460

### High temperature self releasing tubular bagging film

#### DESCRIPTION

Dahlar® Release Bag 460 is a self releasing multi-layer bagging film for direct contact with pre-preg for fabrication of hollow parts. Dahlar® Release Bag 460 exhibits superior strength, temperature resistance and vacuum integrity of Airtech's multi-layer film technology. Dahlar® Release Bag 460 exhibits excellent release of epoxy and polyester resins.

Dahlar® Release Bag 460 is also available in gusseted folding (LFT-G).

Thanks to the gusset folding, the Dahlar® Release Bag 460 is easier to position accurately in hollow parts. Upon application of pressure the bag will easily expand to fit to the shape of the part which is very useful in applications where there are variations in the part diameter. This development ensures even application of internal pressure in cases of small diameter parts, where the insertion of a standard lay flat tube bagging film can be problematic.

#### TECHNICAL DATA

		Test method
Material type	PMP, Nylon, multi-layer	
Elongation at break	425 %	ASTM D 882
Tensile strength	60 MPa	ASTM D 882
Maximum use temperature	190 °C	
Materials to avoid	Compatible with most resin systems	
Colour	Clear	

#### SIZES

Thickness	Width	Length	Weight / roll	Forms available *
0,0027 inch (70 µm)	2 inches (0,050 m)	500 feet (152,4 m)	1,35 Kg	LFT
0,0027 inch (70 µm)	3 inches (0,076 m)	500 feet (152,4 m)	2,02 Kg	LFT
0,0027 inch (70 µm)	4 inches (0,101 m)	500 feet (152,4 m)	2,69 Kg	LFT / LFT-G
0,0027 inch (70 µm)	6 inches (0,152 m)	500 feet (152,4 m)	4,04 Kg	LFT / LFT-G
0,0027 inch (70 µm)	8 inches (0,203 m)	500 feet (152,4 m)	5,39 Kg	LFT / LFT-G
0,0027 inch (70 µm)	12 inches (0,304 m)	500 feet (152,4 m)	8,08 Kg	LFT

#### NOTES

- > Elongation at break and tensile strength are measured in transverse direction.
- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Dahlar® Release Bag 500

Very high temperature self releasing tubular bagging film

### DESCRIPTION

Dahlar® Release Bag 500 is a self releasing multi-layer bagging film for direct contact with pre-preg for fabrication of hollow parts. Dahlar® Release Bag 500 exhibits superior strength, temperature resistance and vacuum integrity of Airtech's multi-layer film technology. Dahlar® Release Bag 500 exhibits excellent release of epoxy and polyester resins.

Dahlar® Release Bag 500 is also available in gusseted folding (LFT-G).

Thanks to the gusset folding, the Dahlar® Release Bag 500 is easier to position accurately in hollow parts. Upon application of pressure the bag will easily expand to fit to the shape of the part which is very useful in applications where there are variations in the part diameter. This development ensures even application of internal pressure in cases of small diameter parts, where the insertion of a standard lay flat tube bagging film can be problematic.

### TECHNICAL DATA

		Test method
Material type	ETFE, Nylon, multi-layer	
Elongation at break	400 %	ASTM D 882
Tensile strength	60 MPa	ASTM D 882
Maximum use temperature	230 °C	
Materials to avoid	Compatible with most resin systems	
Colour	Orange	

### SIZES

Thickness	Width	Length	Weight / roll	Forms available*
0,0027 inch (70 µm)	2 inches (0,050 m)	500 feet(152,4 m)	1,35 Kg	LFT
0,0027 inch (70 µm)	2,5 inches (0,064 m)	500 feet (152,4 m)	1,69 Kg	LFT
0,0027 inch (70 µm)	3 inches (0,076 m)	500 feet (152,4 m)	2,02 Kg	LFT
0,0027 inch (70 µm)	4 inches (0,101 m)	500 feet (152,4 m)	2,69 Kg	LFT / LFT-G
0,0027 inch (70 µm)	4,5 inches (0,114 m)	500 feet (152,4 m)	3,04 Kg	LFT
0,0027 inch (70 µm)	5 inches (0,127 m)	500 feet (152,4 m)	3,38 Kg	LFT
0,0027 inch (70 µm)	6 inches (0,152 m)	500 feet (152,4 m)	4,04 Kg	LFT / LFT-G
0,0027 inch (70 µm)	8 inches (0,202 m)	500 feet (152,4 m)	6,0 Kg	LFT / LFT-G

### NOTES

- > Elongation at break and tensile strength are measured in transverse direction.
- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

Last updated : 2011-06-21

Catalogue position : [Bagging films](#)



# DATA SHEET

## Dahlar® Release Bag 921

### Polyolefin self releasing tubular bagging film

#### DESCRIPTION

Dahlar® Release Bag 921 is a self releasing tubular bagging film developed for direct contact use with prepreg for fabrication of hollow parts such as bicycle components, fishing rods, masts, etc.

Dahlar® Release Bag 921 is also available in gusseted folding (LFT-G).

Thanks to the gusset folding, the Dahlar® Release Bag 921 is easier to position accurately in hollow parts. Upon application of pressure the bag will easily expand to fit to the shape of the part which is very useful in applications where there are variations in the part diameter. This development ensures even application of internal pressure in cases of small diameter parts, where the insertion of a standard lay flat tube bagging film can be problematic.

#### TECHNICAL DATA

		Test method
Material type	Polyolefin	
Elongation at break	800 %	ASTM D 882
Tensile strength	21 MPa	ASTM D 882
Maximum use temperature	145 °C	
Materials to avoid	Compatible with most resin systems	
Yield	43 m <sup>2</sup> /Kg/25,4 µm	
Colour	Translucent white	

#### SIZES

Thickness	Width	Length	Weight / roll	Forms available*
0,003 inch (75 µm)	2 inches (0,050 m)	500 feet (152,4 m)	1,10 Kg	LFT
0,003 inch (75 µm)	3 inches (0,076 m)	500 feet (152,4 m)	1,59 Kg	LFT
0,003 inch (75 µm)	4 inches (0,101 m)	500 feet (152,4 m)	2,12 Kg	LFT / LFT-G
0,003 inch (75 µm)	6 inches (0,152 m)	500 feet (152,4 m)	3,18 Kg	LFT / LFT-G
0,003 inch (75 µm)	8 inches (0,203 m)	500 feet (152,4 m)	4,24 Kg	LFT / LFT-G
0,003 inch (75 µm)	12 inches (0,304 m)	500 feet (152,4 m)	6,36 Kg	LFT
0,003 inch (75 µm)	18 inches (0,457 m)	500 feet (152,4 m)	9,54 Kg	LFT

#### NOTES

- > Elongation at break and tensile strength are measured in transverse direction.
- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## VB-3

### Ultra high temperature bagging film

#### ■ DESCRIPTION

VB-3 vacuum bagging film is a high temperature, high elongation film which is suitable for cure temperatures up to 315 °C. It is recommended for high temperature cure cycles where a good softness and drapability are required.

#### ■ TECHNICAL DATA

		Test method
Material type	Fluoropolymer	
Elongation at break	500 %	ASTM D 882
Tensile strength	27 MPa	ASTM D 882
Maximum use temperature	315 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	None	
Yield	18,3 m <sup>2</sup> /Kg/25,4 µm	
Colour	Green	

#### ■ SIZES

Thickness	Width	Length	Weight / roll	Forms available *
0,003 inch (75 µm)	50 inches (1,27 m)	175 feet (53 m)	11 Kg	SHT

#### ■ NOTES

- > The sealant tape should only be applied to the matte surface of the VB-3 film.
- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Thermalimide

### Ultra high temperature bagging film

#### ■ DESCRIPTION

Thermalimide is a high performance bagging film for cure temperatures up to 426 °C.

#### ■ TECHNICAL DATA

		Test method
Material type	Polyimide	
Elongation at break	95 %	ASTM D 882
Tensile strength	240 MPa	ASTM D 882
Maximum use temperature	426 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	None	
Yield	27,7 m <sup>2</sup> /Kg/25,4 µm	
Colour	Amber	

#### ■ SIZES

Thickness	Width	Length	Weight / roll	Forms available *
0,002 inch (50 µm)	60 inches (1,52 m)	255 feet (78 m)	8,6 Kg	SHT

#### ■ NOTES

- > Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.
- > Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Airdraw 2

### Embossed vacuum bag designed for rapid air removal

#### ■ DESCRIPTION

Airdraw 2 vacuum bagging film is embossed with a "cracked ice" pattern which allows for rapid air removal when placed under vacuum. The film has been formulated to provide increased stiffness to assist in maintaining a breathable pattern.

Airdraw 2 is not affected by environmental conditions and will not soften in high humidity, allowing superior breathability. This product is designed primarily for ply compactation with the added benefit of not requiring a breather.

Airdraw 2 is embossed from one side of the film. Under close examination, the film has a flat side and a raised side. The outer surface of the roll is the raised side. For best results, place the raised side against the part surface on top of a perforated film.

#### ■ TECHNICAL DATA

		Test method
Material type	Polyamid compound	
Elongation at break	450 %	ASTM D 882
Tensile strength	75 MPa	ASTM D 882
Maximum use temperature	121 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Colour	Pink	

#### ■ SIZES

Thickness	Width	Length	Weight / roll	Forms available *
0,003 inch (75 µm)	60 inches (1,52 m)	225 feet (69 m)	9,3 Kg	SHT
0,003 inch (75 µm)	120 inches (3,04 m)	225 feet (69 m)	18,6 Kg	SHT

#### ■ NOTES

- > Maximum use temperature is dependant upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use. This product is not designed or intended for autoclave processing.
- > Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Econolon

### Low cost nylon vacuum bagging film

#### ■ DESCRIPTION

Econolon is an inexpensive nylon film for low temperature cures, compaction or debulking operations.

#### ■ TECHNICAL DATA

		Test method
Material type	Nylon	
Elongation at break	375 %	ASTM D 882
Tensile strength	48 MPa	ASTM D 882
Maximum use temperature	149 °C	
Flammability (self extinguishing)	Yes	ATP-5034
Materials to avoid	Phenolic resins/Strong oxidizers	
Colour	Clear	

#### ■ SIZES

Thickness	Width	Length	Weight / roll	Forms available*
0,0015 inch (38 µm)	60 inches (1,52 m)	1000 feet (305 m)	21 Kg	SHT
0,0015 inch (38 µm)	120 inches (3,04 m)	500 feet (152 m)	21 Kg	CF to 60 inches

#### ■ NOTES

> Maximum use temperature is dependent upon the duration at maximum temperature and is process specific. Airtech recommends testing prior to use.

> Other sizes upon request. Minimum order quantity required.

\* SHT = sheeting, CF = centerfold, LFT = lay-flat tubing, LFT-G = lay-flat tubing gusseted.

# DATA SHEET

## Resin compatibility

### Vacuum bag film selection guide

#### NOTE

The following guideline is intended for reference only. Airtech cannot control processing parameters or test all the materials available. Vacuum bagging film samples are available. Risk reduction panel testing is strongly recommended.

Film selection should be based on temperature requirement.

Resin type	Films recommended	Films to avoid	Notes
Epoxy	All vacuum bagging films		
Polyester and vinylester	Securlon® films Econolon Wrightlon® films Ipplon® films Dahlar® Release Bag 125 Dahlar® Release Bag 460	Stretchlon® 200 Stretchlon® 700	Available in 0,002" (50 µm) or 0,003" (75 µm). Thick films are recommended for resin infusion.
Phenolic resins	Securlon® L2000 Stretchlon® 700 Ipplon® WN1500 Ipplon® DPT1000 Wrightlon® 8400 Release Bag® 125 VB-3	Most Nylon films are not compatible with phenolic resins.	Material compatibility testing is highly recommended.
Bismaleimide BMI	Securlon® L2000 Ipplon® WN1500 Ipplon® DPT1000 Wrightlon® 8400 VB-3	Vacuum bagging films with use temperatures below 177 °C.	Preventing direct resin contact with the vacuum bag is highly recommended.
Cyanate ester	Securlon® L1000, L2000 Stretchlon® 800 Ipplon® WN1500 Ipplon® DPT1000 Ipplon® DP1000 Ipplon® KM1300 Wrightlon® 7400, 8400		

Last updated : 2009-11-24

Catalogue position : [Bagging films](#)

# DATA SHEET

## Bagging film dimensional chart

### IPPLON and WRIGHTLON nylon bagging films

#### Sheeting (SHT)

##### 2 mil (50 µm)

Widths		Approximate			
		Length		Weight/roll	
inches	cm	feet	m	lbs	Kg
54	137	2000	610	108	49
60	152	1000	305	60	27
72	183	1000	305	72	33
107	272	1000	305	107	49
120	305	1000	305	120	55
140	356	1000	305	140	64

##### 3 mil (75 µm)

Widths		Approximate			
		Length		Weight/roll	
inches	cm	feet	m	lbs	Kg
54	137	1500	457	122	55
60	152	1000	305	90	41
72	183	1000	305	108	49
107	272	750	229	120	55
120	305	750	229	135	61
140	356	500	152	105	48

#### Centerfold (CF)

##### 2 mil (50 µm)

Widths		Approximate			
		Length		Weight/roll	
inches	cm	feet	m	lbs	Kg
*60 (120)	152 (305)	1000	305	120	55
*75 (150)	191 (381)	750	229	113	51
*80 (160)	203 (406)	750	229	120	55
*90 (180)	229 (458)	750	229	135	61

##### 3 mil (75 µm)

Widths		Approximate			
		Length		Weight/roll	
inches	cm	feet	m	lbs	Kg
*60 (120)	152 (305)	750	229	135	61
*75 (150)	191 (381)	500	152	113	51
*80 (160)	203 (406)	500	152	120	55
*90 (180)	229 (458)	500	152	135	61

#### Lay flat tubing (LFT)

##### 2 mil (50 µm)

Widths		Approximate			
		Length		Weight/roll	
inches	cm	feet	m	lbs	Kg
2-22	5-56	1000	305	-	-
27	69	1000	305	54	25
36	92	1000	305	72	33
48	122	1000	305	96	44
54	137	1000	305	108	49
60	152	1000	305	120	55
72	182	750	229	108	48
80	204	750	229	120	55
90	229	750	229	135	61

##### 3 mil (75 µm)

Widths		Approximate			
		Length		Weight/roll	
inches	cm	feet	m	lbs	Kg
2-22	5-56	1000	305	-	-
27	69	750	229	61	28
36	92	750	229	81	37
48	122	750	229	108	49
54	137	750	229	122	56
60	152	600	183	108	49
72	182	500	152	108	49
80	204	500	152	120	55
90	229	500	152	135	61

> \*Opened to dimension listed in parentheses.

> Other sizes upon request. Sizes over 180 inches will be heat sealed.

> Custom sizes & manufacturing shapes are available to fit your individual requirements. Please consult Airtech for further informations.

Last updated : 2009-04-24

Catalogue position : [Bagging films](#)