

## **DATA SHEET**

# **HK900 BAGGING FILM**

HAWKEYE HK900 BAGGING FILM is a cast nylon, heat-stabilized film. This film has a melt point of 510 degrees F (265 degrees C) for increased stability in higher temperature applications where the film is exposed to elevated temperatures over prolonged time periods.

HK900 is extremely flexible for cold conformability in bagging applications and hoot thermo-formability in vacuum forming. The clarity of the film optimizes visibility of contained products through the film.

HK900 has good release qualities for ease of removal in curing applications. The thinner gauge provides improved cost-effectiveness and reduced waste with the loss of strength commonly associated with thinner films.

HK900 BAGGING FILM contains no caprolactan.

### **SPECIFICATIONS**

Thickness:	.00125" - .004"*
Widths:	10" - 88" (254mm - 2235mm)
Color:	Clear (colors available on request)

\*other sizes available

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## **DATA SHEET**

# **HK800 BAGGING FILM**

HK800 BAGGING FILM is a modified heat stabilized blown nylon film, developed for temperatures to 350 degrees F (177 degrees C) for limited periods of time. This modified nylon film is generally softer and more flexible than standard nylon films. This film exhibits a lower elastic module while retaining its tensile strength and heat stability.

The proper use of bagging films cannot be established by thermal properties alone. Consideration must be given to conditions such as: the maximum temperature of cure, pressure used, condition of autoclave and length of time exposed.

### **SPECIFICATIONS**

Forms Available:	Roll Stock and Tubing
Thickness:	.002" and .003" Standard
Color:	Clear or Yellow
Widths:	160" Maximum without seams
Shelf Life:	1 Year (Depending on conditions)
Suggested Use Temperature:	350 degrees F (177 degrees C)

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## **DATA SHEET**

# **HK800 CAST BAGGING FILM**

HK800 CAST BAGGING FILM offers some distinctive advantages not found in blown films. Cast film does not have suspended particles found in blown film and is more resistant to pin holes. This is due to the roller process used during the casting procedure. There is no shrinkage at 350 degrees F (177 degrees C), therefore it will not pull away from the vacuum bag sealant.

### **SPECIFICATIONS**

Forms Available:	Roll Stock
Thickness:	.002" and .003" Standard
Widths:	88" Maximum Unseamed
Color:	Clear
Elongation (%):	400 - 600
Tensile Strength (psi):	11,000 - 15,000

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## **DATA SHEET**

# **HK7400 BAGGING FILM**

HK7400 BAGGING FILM is a high performance nylon film for advanced composite manufacturing. This film has been specially modified to provide heat stability, high elongation and a high resistance to puncture and pinholing.

HK7400 will perform well to temperatures of up to 400 degrees F (205 degrees C). The use of proper bagging films cannot be established by thermal properties alone. Consideration must also be given to the maximum temperature of cure, autoclave conditions, length of time and the pressure used.

## **SPECIFICATIONS**

Forms Available:	Rolls Stock, Tubing
Thickness:	.002" and .003" Standard
Widths:	Maximum 160" Unseamed
Color:	Green
Yield (sq. in./lb./mil):	24,000
Gauge Control:	+/- 10%
Elongation (%):	425
Maximum Use Temperature:	410 degrees F (210 degrees C)
Heat Sealing Range	430 - 475 degrees F (221-246 degrees C)
Melting Point:	428 degrees F (220 degrees C)
Flammability:	Self Extinguishing
Shrinkage at 350 degrees F:	Less than 1%

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## **DATA SHEET**

# **HK7500 CAST BAGGING FILM**

HK7500 CAST BAGGING FILM offers the same advantages as our HK800 Cast film combined with the advantages of the higher temperature range of our HK7400 blown films. HK7500 performs well to temperatures of 410 degrees F (210 degrees C).

### **SPECIFICATIONS**

Forms Available:	Roll Stock
Thickness:	.002" and .003" Standard
Widths:	88" Wide Maximum Unseamed
Color:	Green
Yield Strength (psi):	4000 - 6000
Tensile Strength (psi):	11,000 - 15,000
Elongation (%):	400-600
Maximum Use Temperature:	410 degrees F (210 degrees C)
Minimum Recommended Use Temperature:	-80 degrees F (-61 degrees C)
Flammability:	Self Extinguishing
Shrinkage (% at 5 hrs at 300 degrees F):	Less than 2.0
Melting Point:	424 - 428°F (218 - 220°C)

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## **DATA SHEET**

# **HK8400 BAGGING FILM**

HK8400 BAGGING FILM is a blue tinted, heat stabilized blown film, produced from modified nylon resin. Blown film is recommended as bagging film for advanced composite fabrication and other high temperature applications where softness, workability or anti-static characteristics are essential. In addition, HK8400 has excellent heat stability and resistance to pinholing. HK8400 can be used at temperatures up to 450 degrees F (232 degrees C) for typical composite cure cycle times.

## **SPECIFICATIONS**

Forms Available:	Roll Stock, Tubing, Seamed Wide
Widths	
Thickness:	.002" and .003" Standard
Width:	To 120" Wide
Color:	Blue
Yield Strength (psi):	9500
Gauge Control:	+/- 10%
Tensile Strength (lbs/sq. in.):	14,000
Elongation (%):	300
Maximum Use Temperature:	450 degrees F (232 degrees C)
Heat Sealing Range: degrees C)	475 - 500 degrees F (246-260
Crystalline Melt Point:	500 degrees F (260 degrees C)
Flammability:	Self extinguishing
Shrinkage at 350 degrees F (177 degrees C):	Less than 1%

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## **DATA SHEET**

# **HK8500 CAST BAGGING FILM**

HK8500 CAST BAGGING FILM is a blue tinted, heat-stabilized flat cast film, produced from modified nylon resin. Flat cast film is recommended as bagging film for advanced composite fabrication and other high temperature applications where dimensional stability, adherence to sealant sealant tapes and uniform film gauge are essential. In addition, HK8500 has an excellent heat stability and resistance to pinholing.

HK8500 can be used at temperatures up to 450 degrees F (232 degrees C) for typical composite cure cycle times.

## **SPECIFICATIONS**

Forms Available:	Roll Stock, Bags, Seamed Wide Widths
Thickness:	.002" and .003" Standard
Width:	To 120" Wide
Color:	Light Blue
Yield Strength (psi):	6500
Gauge Control:	+/- 10%
Tensile Strength (lbs/sq.in):	14,000
Elongation (%):	350
Tearing Strength (gms):	90
Maximum Use Temperature:	425 degrees F (218 degrees C)
Heat Sealing Range:	430-475 degrees F (221-246 degrees C)
Flammability:	Self Extinguishing
Shrinkage at 300 degrees F:	Less than 1%

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## **DATA SHEET**

# **HK6600 HIGH TEMPERATURE BAGGING FILM**

HK6600 BAGGING FILM represents a new generation of fluorocarbon polymer bagging film specifically developed to molding applications involving complex shapes and/or high temperature resins.

HK6600 has significantly improved drapability relative to release films typically used for epoxy and other resins cured at temperatures up to 350 degrees F (176 degrees C). In addition, it proves to be the only thermally stable, yet highly conformable parting film applicable to advanced polyamides such as PMR, and to new thermoplastics. The superior performance of HK6600 is based on its outstanding properties in the most critical areas of composite molding. HK6600 has been used for 6 hours at 765 degrees F (407 degrees C).

### **SPECIFICATIONS**

Thickness:	.003"
Width:	54" - Standard
Maximum Use Temperature:	700 degrees F (371 degrees C)
Elongation (%):	450

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## **DATA SHEET**

# **HK8000 HIGH TEMPERATURE BAGGING FILM**

HK8000 HIGH TEMPERATURE BAGGING FILM is a unique polyimide film used for high temperature applications. This film has ultra high heat resistance, high tensile modulus, and dimensional stability.

The HK8000 films contain a layer of fluoropolymer on one or both sides. This can then be bonded to itself or to other stable materials.

We offer this film in several grades:

HK8000R	An uncoated, flexible high-heat film
HK8000S	An uncoated, ultra high temperature, high tensile modulus film
HK8000SS	Super stabilized version of the HI8000-S film

We suggest using any of the above films together with HK780 Sealant Tape for a total high temperature bonding package.

## **SPECIFICATIONS**

Thickness:	.002"/.003" - Standard (.0005"-.005" Available)
Width:	60" Maximum
Temperature (Recommended Maximum):	752 degrees F (400 degrees C)
Elongation (%):	83
Color:	Amber
Yield (sq.in./lb./mil):	19,584

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## **DATA SHEET**

# **HK2200R BAGGING FILM**

**HK2200 BAGGING FILM is a cast film for low or room temperature applications. It is produced from a modified nylon 6 resin specifically designed for debulk or compaction operations. HK2200 is an economical film used for removal of volatiles and air prior to final cure.**

## **SPECIFICATIONS**

Forms Available:	Roll Stock
Thickness:	.0015"
Width:	90" Maximum Unseamed
Elongation (%):	400 - 600
Tensile Strength (psi):	11,000 - 15,000
Use Temperature:	300 degrees F (148 degrees C)

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## **DATA SHEET**

# **HK357 HIGH STRETCH BAGGING FILM**

HK357 HIGH STRETCH BAGGING FILM is designed for use in the composite shop as a general purpose bagging film for 350 degree F (177 degree C) and 250 degree F (121 degree C) cure cycles. HK357 is not a polyamide and overcomes problems normally associated with nylon film. HK357 has a very high elongation and lower modulus than nylons. For cures of 250-350 degrees F (121-177 degrees C) with epoxy or phenolic resins, the speed and ease of HK357 bag construction cannot be equaled. After cure, HK357 is not significantly degraded and releases more easily than other films. The film increases quality and lowers cost by: Reduced pleating and folding, Increased elongation, Toughness and Pliability.

## **SPECIFICATIONS**

Forms Available:	Roll Stock
Thickness:	.003"
Widths:	120" Maximum
Tensile Strength (astm D882)	5600 psi
Elongation (astm D882):	750%
Modulus at 100% Elongation:	2400 psi
Tear Strength:	900 pii
Maximum Use Temperature:	370 degrees F (187 degrees C)
Yield per thousandth inch:	162 sq. ft./lb.

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## **DATA SHEET**

# **HK108 DEBULKING FILM**

HK108 DEBULKING FILM is a very stretchable film designed for slightly increased pressure or vacuum. To allow the film to stretch evenly, the vacuum should be utilized slowly. This is especially true for areas of deep draws. When no heat is used, as in prepreg debulking, HK108 can be often be re-used.

### **SPECIFICATIONS**

Forms Available:	Roll Stock
Thickness:	.0015"
Maximum Width:	115"
Ultimate Tensile Strength	6000 psi
Ultimate Elongation	>500%
Modulus at 100% Elongation	1300 psi
Tear Resistance	800 g/mil
Maximum Use Temperature	250 Degrees F (121 degrees C)
Yield per Thousandth Inch:	150 sq. ft/lb

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## **DATA SHEET**

### **PVA FILM**

HAWKEYE'S POLYVINYL ALCOHOL (PVA) FILM is a general purpose and mold release material based on polyvinyl alcohol resins on controlled molecular weight. Because of its special properties, PVA film has broad application in the forming and processing of reinforced plastics, both as a mold release agent and as a blanket for uniform wall thickness. PVA film is currently being used by several major industries in many processes; blanket vacuum molding, pressure bag molding, autoclave molding, low pressure laminating, tool molding, hand lay-up molding and pre-form processing.

Vacuum and pressure bagging processes and autoclave molding using PVA film has some advantages over other types of film such as moderate tooling and unit labor costs, uniform physical properties and part uniformity. PVA film offers outstanding properties as a mold release in pressure molding, especially polyester epoxy and diallylphthalate fiberglass reinforced plastics as a separator, mold release or parting agent.

Polyvinyl Alcohol (PVA) Film is also available non-adhesive tape form, in widths as narrow as 1/2 inch.

### **SPECIFICATIONS**

Forms Available:	Roll Stock, Non-Adhesive Tape
Thickness:	.002" and .003"
Width:	54" wide - unseamed
Yield (Sq. in./lb/mil):	21,600
Tensile Strength (psi):	3,000-12,000
Elongation:	250% - 600%
Tear (Elmendorf):	250 - 800 gm/mil

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## **DATA SHEET**

# **HK300 BAGGING FILM**

HAWKEYE'S HK300 BAGGING FILM is a general purpose and mold release material based on modified polyvinyl alcohol resins on controlled molecular weight. Because of its special properties, HK300 Bagging Film has broad application in the forming and processing of reinforced plastics, both as a mold release agent and as a blanket for uniform wall thickness. HK300 Bagging Film is currently being used by several major industries in many processes; blanket vacuum molding, pressure bag molding, autoclave molding, low pressure laminating, tool molding, hand lay-up molding and pre-form processing.

Vacuum and pressure bagging processes and autoclave molding using HK300 film has some advantages over other types of film such as moderate tooling and unit labor costs, uniform physical properties and part uniformity. HK300 film offers outstanding properties as a mold release in pressure molding, especially polyester epoxy and diallylphthalate fiberglass reinforced plastics as a separator, mold release or parting agent.

HK300 Film is also available non-adhesive tape form, in widths as narrow as 1/2 inch.

## **SPECIFICATIONS**

Forms Available:	Roll Stock, Non-Adhesive Tape
Thickness:	.002" and .003" Standard
Width:	54" wide - unseamed
Yield (Sq. in./lb/mil):	21,600
Tensile Strength (psi):	3,000-12,000
Elongation:	250% - 600%
Tear (Elmendorf):	250 - 800 gm/mil

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### **PVC FILM**

HAWKEYE'S POLYVINYL CHLORIDE (PVC) FILM is a general purpose and mold release material based on polyvinyl chloride resins on controlled molecular weight.

#### **SPECIFICATIONS**

Thickness:	.008" Standard
Width:	54" Wide - Standard
Ultimate Elongation	Machine Direction: 350% Minimum Transverse Direction 300% Minimum
Tensile Strength	Machine Direction 3,000 psi Minimum Transverse Direction 2,000 psi Minimum
Tensile Tear Resistance	Machine Direction 450% Minimum Transverse Direction 375% Minimum
Plasticizer Volatility:	4% Maximum
Soapy Water Extraction:	2% Maximum
Low Temperature:	Minus 40 degrees
Dim. Stability:	7% Maximum
Heat Distortion Temperature	130 - 140°F (54-60°C)
Yield: (lbs/sq yd./mil):	.06

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