

HAWKEYE

INTERNATIONAL, LTD.

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DATA SHEET

A8888 RELEASE FABRIC

A8888 RELEASE FABRIC is an open weave synthetic polyamide fabric with good “hand” and drapability, coated with a specially formulated release agent. It has been used on 350 degrees F (177 degree C) cures and has released from epoxies and polyester resin systems. Certain types of phenolic resins may adhere to synthetics, we therefore suggest a test specimen to be run prior to product usage.

This fabric is particularly recommended where furnished parts are subjected to secondary bonding or painting as it does not transfer or leave a residue. In lay-up, it conforms readily to the contours of your parts and tools.

SPECIFICATIONS

Width:	43” & 60” - Standard
Length:	100 yards
Temperatures:	350 degrees (176 degrees C) Maximum Recommended

NOTE: Technical information furnished by HAWKEYE is based on laboratory findings and is believed to be correct. No warranties of any kind are made except that materials supplied are HAWKEYE standard quality. All risk and liability arising from handling, storage and use of HAWKEYE products, as well as compliance with applicable legal restrictions rests with the buyer.

DATA SHEET

B4444 RELEASE FABRIC

Similar to our Release Fabric A8888, the B4444 RELEASE FABRIC is also a synthetic polyamide fabric with a soft “hand” and drapability, but is a tighter weave leaving a smoother finish. Coated with the same specially formulated release agent, the various chemicals reacting under regulated heat conditions insures a bond between the coating and the fabric that will not leave a residue. For this reason, it is particularly recommended where furnished parts are subjected to secondary bonding or painting. In lay-up, it conforms readily to contours of your parts and tools.

Because of the natural affinity of some synthetics to various phenolic resin systems, we suggest a test specimen of RELEASE FABRIC B4444 be run prior to production usage.

SPECIFICATIONS

Thickness:	.005”
Width:	45” and 60” Standard
Roll Length	100 Yards
Temperature:	350 degrees F (177 degrees C) Recommended Max.

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DATA SHEET

B4444B RELEASE FABRIC

B4444B RELEASE FABRIC is designed for vacuum bag lay-up composites and metal-to-metal bonding structures. B4444B is a synthetic polyamide fabric with a soft “hand” and drapability with a smooth finish. The fabric leaves a smooth surface impression for priming and secondary bonding. In lay-up, it conforms readily to contours of your parts and tools.

The fabric is not recommended for phenolic systems. The fiber of B4444B melts at approximately 480°F (249°C).

SPECIFICATIONS

Thickness:	.0045” +/- .0005”	(.114 mm)
Width:	58” (min.)	(147 cm)
Length:	250 yds	(229 m)
Weight	1.7 oz/yd ²	(57 g/m ²)
pH:	4.5-7.0	
Temperature:	350°F	(177°C)
Melt Temperature:	480°F	(249°C)
Finish Count		
Warp:	104 ends/in	(40 ends/cm)
Fill:	86 picks/in	(33 picks/cm)
Tensile Strength (Grab)		
Warp:	115 lbs (min.)	(533 Newtons)
Fill:	105 lbs. (min.)	(467 Newtons)
Color:	Blue	

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DATA SHEET

C6666 RELEASE FABRIC

C6666 RELEASE FABRIC is construction of a 181 type fiberglass cloth, coated with our specially formulated release agent. It has a soft "hand" with good drapability, which lends itself well to high pressure and high temperature composite laminates. C6666 RELEASE FABRIC will not transfer, thus ending the necessity for solvent cleaning or sanding if painting or subsequent bonding is required.

SPECIFICATIONS

Thickness:	.009" (approx.)
Width:	38", 50" and 60" Standard
Roll Length	100 Yards
Weight:	10 oz/sq. yard (approx.)
Temperature:	900 degrees F (482 degrees C)

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DATA SHEET

D100SRG RELEASE FABRIC

D100SRG is similar to our B4444 Release Fabric as it is also a synthetic polyamide fabric with a soft "hand" and drapability. D100SRG is a tighter weave which leaves a smoother finish. D100SRG is coated with the same specially formulated release agent, which under regulated heat conditions insures a bond between the coating and the fabric which will not leave a residue. For this reason it is particularly recommended where finished parts are subjected to secondary bonding or painting. In the lay-up, it conforms readily to contours of your parts and tools.

Because of the natural affinity of some synthetics to various phenolic resin systems, we suggest a test specimen of D100SRG Release Fabric be run prior to production useage.

SPECIFICATIONS

Thickness:	.004" - .005"
Width:	60"
Roll Length:	100 yds
Weave:	160 ends X 103 pics
Temperature:	480°F (248.88°C)

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DATA SHEET

E5555 RELEASE FABRIC

E5555 RELEASE FABRIC is a high temperature porous bleeder and release fabric. It is produced from a 116 fiberglass cloth, with the same proprietary formulations used in our Release Fabric A8888. The porosity lends itself to either bleeder or breather applications where release is essential. Its soft "hand" and drapability makes it ideal for high pressure and high flow composite laminates. E5555 RELEASE FABRIC does not transfer, so there is no necessity for sanding or solvent cleaning if painting or further bonding is necessary.

SPECIFICATIONS

Thickness:	.006"
Width:	38", 50" and 60" Standard
Roll Length:	100 Yards
Weight:	4.0 oz./sq. yard
Temperature:	900 degrees F (482 degrees C)

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DATA SHEET

J4848 RELEASE FABRIC

J4848 Release Fabric is a synthetic polyamide fabric with excellent drapability, used primarily for vacuum bag lay-up composites and metal-to-metal bonding structures. The fabric is coated with a specially formulated release agent for a smooth release from the part. The fabric leaves a fine surface impression ideal for priming and secondary bonding. The fabric is not recommended for phenolic systems.

SPECIFICATIONS

Thickness:	.009 in.	(.229 mm)
Width:	58"	(147 cm)
Roll Length:	250 yds	(229 m)
Weight:	3.0 oz/yd ²	101 g/m ²
pH:	4.5-7.0	
Melt Temperature:	480°F	249°C
Finish Count		
Warp:	66 ends/in (min.)	25 ends/cm
Fill:	50 picks/in (min.)	20 picks/cm
Break Strength (Grab)		
Warp:	225 lbs (min.)	1001 Newtons
Fill:	115 lbs. (min.)	690 Newtons
Color:	Blue or Green	

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DATA SHEET

S2222 RELEASE FABRIC

S2222 RELEASE FABRIC contains a “chemically modified silicone release agent”, specifically compounded and applied to quality woven fiberglass fabric. Designed for complex prepreg molding operations, metal bond applications and advanced composite structures, this release fabric offers the following advantages:

- Uniform bag pressure over the entire surface
- “Pink” color to identify release fabric from laminating cloths
- Quick and easy removal of bleeder and vacuum bag materials
- Soft “hand” and excellent drapability
- Minimizes transfer of cloth pattern too finished part
- “Bridging” problems diminished
- Good for all resin systems including phenolic
- Good breathing characteristics for escape of solvents
- Excellent for autoclave and pressure bag systems

SPECIFICATIONS

Thickness:	.009”
Width:	38”
Roll Length:	250 yards
Weight:	11.0 oz/sq. yard
Temperature:	800 degrees F (426 degrees C)

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DATA SHEET

T3333 RELEASE FABRIC

T3333 RELEASE FABRIC was designed and produced for one reason only...to provide the ultimate in all characteristics required of a multiple release fabric for all resin systems and adhesives.

To quality woven fiberglass cloth, we have added special finish consisting of a "chemically modified tetrafluorocarbon derivative" that has been compounded to a specific formulation. The result is a fabric with excellent release qualities without sacrificing drapability that is essential in complex molding techniques, metal bonding and composite structures. Further, there can be no transfer of the chemically inert finish to the product, as all of these qualities are unaffected by temperatures of 500 degrees F or higher. This makes it particularly suitable where autoclave temperatures and pressure are employed. With T3333 RELEASE FABRIC, "bridging" problems are minimized or eliminated.

SPECIFICATIONS

Thickness:	.011"
Width:	38"
Roll Length	250 Yards
Weight:	10.0 oz./sq. yard
Temperature:	500 degrees F (260 degrees C)

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DATA SHEET

A100 RELEASE FABRIC

A100 PEEL PLY is a polyamide fabric that has been heat-set and scoured to remove the sizing from the fibers needed during the weaving process. Removal of this sizing cleanses the materials so that it can be used against the laminates or bond lines particularly where secondary bonding, painting or finishing is required. A100 PEEL PLY will release from most commercial resin systems. Because of the natural affinity between phenols and nylons, this material is not recommended for use with phenolic resin systems. If, at temperatures of 350 degrees F (176 degrees C), you should encounter sticking, we suggest the use of one of our coated release fabrics.

SPECIFICATIONS

Thickness:	.006"
Width:	45" and 60" Standard
Roll Length:	250 Yards
Weight:	1.9 oz/sq. yard
Temperature:	350 degrees F (176 degrees C)

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DATA SHEET

SUPER A

Super A is designed specifically for “heavy duty” laminating projects where the lighter weight fabrics such as A100 or F100 are not strong enough to stand up to the peel strength.

Super A will release from virtually all prepregs in one easy step while leaving an uncontaminated surface. **Super A** is constructed of a polyamide fabric that has been heat-set and scoured to remove the sizing from the fibers needed during the weaving process. Removal of this sizing cleanses the materials so that it can be used against the laminates or bond lines, particularly where secondary bonding, painting or finishing is required. Further sanding is not necessary, therefore decreasing work time on a part.

SPECIFICATIONS

Color:	Off White
Thickness	.009” (.023cm)
Width	60” wide (142.4cm)
Roll Length	250 yds (229m)
Weight	4.10 oz/yd ² (139 gm/m ²)
Temperature Useage	450°F (232°C) Maximum
Yarn Type:	Nylon
Construction	
Warp	80 Ends/inch (+/-3)/ 314ends/dm (+/-12)
Fill	60 Ends/inch (+/-2)/ 157 Ends/dm (+/-8)
Grab Tensile (lbs/inch)	
Warp	300 lbs/in (525 N/cm)
Fill	250 lbs/in (438 N/cm)
Extractables	.5% Max.

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DATA SHEET

B100 RELEASE FABRIC

B100 PEEL PLY is smoother, tighter weave version of the same release characteristics as PEEL PLY A100. The tighter thread count in both the warp and the fill gives closer control of the resin bleedout, by restricting the amount that squeezes through. It also minimizes stripping problems by cutting down on the possibility of "mechanical bond" if too much resin flows through the interstices of the fabric. Again, we caution against the use of this material with phenolic resin systems. If sticking occurs at elevated temperatures, we once more recommend the use of one of our coated release fabrics.

SPECIFICATIONS

Thickness:	.004"
Width:	45" and 60"
Roll Length:	250 Yards
Weight:	2.3 oz/sq. yard
Temperature:	350 degrees F (176 degrees C)

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DATA SHEET

C100 Release Fabric

C100 Peel Ply is a synthetic which will not contaminate the surface of the part. There is no silicone or other release agent on C100. C100 is scoured and heat-set fabric.

C100 Release Fabric has an operating temperature of 350°F (176°C) with pressures of 100PSI (7.03 Kg/sq cm). It will not breakdown after 15 cycles. C100 Release Fabric will release from 350°F degrees Kevlar prepregs.

The standard color of C100 Release Fabric is natural.

SPECIFICATIONS

Roll Size:	60" X 250 yds
Thread Count:	103 X 87
Weight:	1.8 oz per sq yd (1.5 per sq mt)
Max Recommended Use Temp:	400°F (204°C)

DATA SHEET

D100 Release Fabric

D100 Peel Ply is a smoother, tighter version of the Hawkeye B100 Nylon Peel Ply. The tighter thread count in both the warp and the fill gives closer controls of the resin bleedout. The tighter weave minimizes stripping problems by cutting down the the possibility of “mechanical bond”.

Again, we caution against the use of this material with phenolic resin systems. If sticking occurs at elevated temperatures, we once again recommend the use of one of our coated release fabrics.

SPECIFICATIONS

Thickness:	.004” - .005”
Width:	60” *
Roll Length:	250 yds
Weave:	160 ends X 103 pics
Temperature:	480°F (248.99°C)
Weight:	1.85 oz/sq yd (52.44 g/sq mt)

*Available in slit widths

Available with a release coating – See Product D100SRG

DATA SHEET

F100 RELEASE FABRIC

F100 RELEASE FABRIC is a synthetic fabric used as a peel ply against the surface on composite parts. It will not contaminate the surface of the composite part. F100 Release Fabric adheres to the composite surface more than our other non-coated Release Fabrics. A higher lap shear will be obtained using F100 Release Fabric than with the usual sanding. There is no coating on F100 Release Fabric and the goods are scoured and heat-set.

F100 Release Fabric has an operating temperature of 400 degrees F (204 deg. C) with pressures of 100 PSI. It will not breakdown after 15 hour cycles. F100 Release Fabric will release from 350 degrees F Kevlar prepregs.

The standard color of F100 Release Fabric is natural, but is available in blue, international orange or printed.

SPECIFICATIONS

Thickness:	.006"
Width:	46" (116.84 cm) or 60" (152.4 cm)
Roll Length:	250 Yds (228.6 m)
Weight:	2.7 (+/- .3) oz/sq yd
Temperature:	400 Degrees F (204 Deg. C)
Yarn Type:	Polyester
Construction:	Warp 76 ends/inch (+/- 2) Fill 56 picks/inch (+/- 2)

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HK60001 RELEASE FABRIC

HK60001 Release Fabric provides high quality, technically designed polyester filaments woven fabrics for markets where performance is key. This fabric is woven and finished to meet specific requirements and the quality is assured through rigorous process and quality control measures. Fabrics can be finished with water repellent, flame retardant, antimicrobial and other custom designed treatments.

SPECIFICATIONS

Thickness:	.005" (.127 mm)
Width:	60" (152. cm)
Roll Length:	300 Yds (275 m) +/- 10%
Weight:	2.50 oz/ yd ² (85 g/m ²)
Construction:	Warp: 70 ends/in (28.0 ends/cm) Fill: 50 picks/in (19.0 picks/cm)
pH:	4.5 - 7.0

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DATA SHEET

HK7016 RELEASE FABRIC

HK7016 RELEASE FABRIC is a porous TFE coated glass fabric, style 106 plain weave. HK7016 can be used in metal bond lay-ups or reinforced fiberglass lamination. This material will release from most resin systems without causing contamination problems. It is particularly desirable for use in boron or graphite advanced composites for smooth texture finish and release from the part with minimal disturbance of surface fibers.

- Non-Migrating
- Non Sticking
- Controlled Porosity

SPECIFICATIONS

Thickness:	.002"
Width:	38"
Roll Length:	100 Yards
Weight:	0.9 oz./sq. yard
Temperature	500 degrees F (260 degrees C)

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DATA SHEET

G100 RELEASE FABRIC (WITH AND WITHOUT TRACERS)

G100 RELEASE FABRIC is woven from polyester fibers which have been scoured and heat-set. G100 Release Fabric offers a surface free of contamination. The unique construction offers an ideal surface for secondary bonding or painting. The highest quality lap shears and peel strengths are achieved with G100 Release Fabric. Tracers, if requested, will be supplied on one inch centers.

G100 Release Fabric will release from the part in one continuous piece, even after bonding temperatures have reached 400 degrees F (204 degrees C).

SPECIFICATIONS

Thickness::	.005" (+/- .0005 inch) (.0127 cm +/- .00127 cm)
Width:	46 inch and 60 inch
Roll Size::	250 yards per roll
Weight:	2.4 +/- .3 oz/sq yard (81.37 grams +/- 8.505 grams/sq m.)
Temperature:	400 Degrees F (204 deg. C)
Yarn Type:	Polyester
Construction:	Warp: 120 ends/inch +/- 2 (472.44 ends/cm +/- 8) Fill: 64 picks/inch +/- 2 (251.97 picks/cm +/- 8)
Extractable Material:	.5% maximum
Shelf Life:	Indefinite

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DATA SHEET

200TFP RELEASE FABRIC

HAWKEYE 200TFP RELEASE FABRIC is a porous TFE coated glass fabric, style 108 plain weave. Designed for Bleeder and Filter applications, it is particularly desirable for metal bond lay-ups or reinforced fiberglass laminations. This material will release from most resin systems without causing contamination problems.

- Non-Migrating
- Non-Sticking
- Controlled Porosity
- Best Heat/Cold/Chemical Resistance
- Dimensionally Stable under Heat and Pressure
- Smoothest Surfaces

SPECIFICATIONS

Thickness:	.003"
Width	38" and 50":
Roll Length:	100 Yards
Weight:	1.5 oz/sq. yard
Temperatures:	500 degrees F (260 degrees C)

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DATA SHEET

200TFNP RELEASE FABRIC

HAWKEYE 200TFNP RELEASE FABRIC is a non-porous TFE coated glass fabric, style 108 plain weave. It is designed for release applications. Impervious and smooth, it release from most commercial resin systems without migration. In addition to its application in metal-bond and fiberglass lay-up where bleeding must be completely restricted, this versatile material is used as release sheets on heat-sealing machines and laminating presses. It also exhibits non-stick surfaces for paints, adhesives and food products; gaskets, seals and bearings (for steam, chemicals, oils, gasses); pipe and tubing (for high temperature and chemical resistance); covers for hot plates, pallets, chutes, hoppers, scale pans, troughs and rolls).

- Non-Migrating
- Non-Sticking
- Best Heat/Cold/Chemical Resistance

SPECIFICATIONS

Thickness:	.003"
Width:	38" and 50"
Roll Length:	100 Yards
Weight:	4.0 oz/sq. yard
Temperature:	500 degrees F (260 degrees C)

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DATA SHEET

HK7015 RELEASE FABRIC

HK7015 RELEASE FABRIC is a porous TFE coated glass fabric, style 104 plain weave. Used in metal bond lay-ups or reinforced fiberglass lamination. This material will release from most resin systems without causing contamination problems. It is particularly desirable for use in boron or graphite advanced composites for smooth texture finish and release from the part with minimal disturbance of surface fibers.

- Non-Migrating
- Non Sticking
- Controlled Porosity

SPECIFICATIONS

Thickness:	.001"
Width:	38"
Roll Length:	100 Yards
Weight:	0.5 oz./sq. yard
Temperature	500 degrees F (260 degrees C)

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DATA SHEET

HK7050 RELEASE FABRIC

HK7050 RELEASE FABRIC is a non-porous TFE coated glass fabric, excellent for use in high pressure, hot bond presses up to 250 tons. Used between the platens of the press and wet lay-up of honeycomb sandwich or solid polyurethane panels being bonded to the skins. Some customers have reported as high as one hundred successful uses of the same sheets before having to discard.

This fabric is also extremely good for use as a barrier to stop the flow of excess resins between bleeder and breather materials in vacuum bag autoclave cure laminates or bonded parts.

HK7050 is also a SUPERIOR GRADE of Teflon* with the highest dielectric strength. Applications include Class H Motors, Coils, Transformers & Generators, Armatures and Field Coil Windings, Spacers, Phase Separators, Slot Liner Insulation and Commutator Insulation.

- Average Minimum Volts per mil - 1000
- Power Factor 60 to 1mm cycles - .0020
- Dielectric Constant 60 cycles - 1.9

SPECIFICATIONS

Thickness:	.005"
Width:	38" and 50"
Roll Length	100 Yards
Weight:	8.0 oz/sq. yard
Temperature:	500 degrees F (260 degrees C)

* Registered Trademark

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HK7100 RELEASE FABRIC

HK7100 RELEASE FABRIC is a non-porous TFE coated glass fabric, excellent for use in high pressure, hot bond presses up to 250 tons. HK7100 can be used between the platens of the press and wet lay-up of honeycomb sandwich or solid polyurethane panels being bonded to the skins. Some customers have reported as many as 100 successful uses of the same sheets before having to discard.

HK7100 is extremely effective when used as a barrier to stop the flow of excess resins between bleeder and breather materials in vacuum operations.

HK7100 is a SUPERIOR GRADE of TFE with the highest dielectric strength. HK7100 does not absorb moisture and will retain the insulating properties under the most severe conditions. Applications include Class H Motors; Coils; Transformers & Generators; Armatures and Field Coil Windings; Spacers; Phase Separators; Slot Liner Insulation and Commutator Insulation

SPECIFICATIONS

Thickness:	.010"
Width:	38" X 50" Standard
Roll Length	100 Yards - Standard
Weight:	15.0 oz/sq. yard
Temperature:	500 degrees F (260 degrees C)

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