

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 hot thermoformability 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" – 120"" (254mm – 3048mm)
Color:	Clear (colors available on request)
Elongation at Break:	365%
Tensile Strength:	12000per square inch
Maximum Use Temperature:	510°F/265°C

*other sizes available

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.

HAWKEYE

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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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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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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:	Roll Stock, Tubing or Sheeting
Thickness:	.002" and .003" Standard
Widths:	Maximum 160" Unseamed
Color:	Green or Clear
Yield (sq. in./lb./mil):	24,000
Gauge Control:	+/- 10%
Elongation (%):	425
Maximum Use Temperature:	410 degrees F (210 degrees C)
Heat Sealing Range C)	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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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 degrees F (218 - 220 degrees C)

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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 pin-holing. 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
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:	475 - 500 degrees F (246-260 degrees C)
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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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 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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HK1000 BAGGING FILM

HK1000 BAGGING FILM is a modified heat stabilized blown nylon film, developed for temperatures to 390 degrees F (199 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
Thickness:	.002" and .003" Standard
Color:	Clear
Widths:	120" Maximum without seams
Shelf Life:	1 Year (Depending on conditions)
Suggested Use Temperature:	390 degrees F (199 degrees C)

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HK5900TOS BAGGING FILM

HK5900TOS BAGGING FILM is an almost universally inert film as a result of the molecular structure of the resin. HK5900TOS conforms well to compound contours. The material exhibits excellent impermeability to most corrosive liquids, vapors and gases even at elevated temperatures to 650 degrees F (340 degrees C), as well as under pressure and vacuum. HK5900TOS Bagging Film is treated one side (TOS) to provide for acceptance of Hawkeye Bag Sealants such as HK780.

HK5900TOS Bagging Film has a low deformation under load allowing higher pressures to be used. Creep under compressive stress is considerably reduced. Other advantages are a higher dielectric strength and high elongation at break.

SPECIFICATIONS

Thickness:	.003" Standard
Width:	48" - Standard
Temperature (Maximum Recommended):	650 degrees F (340 degrees C)
Shrinkage (1 Hour at 550 degrees F (285 degrees c):	1/2 of 1%
Specific Gravity:	2.16
Tensile Strength (psi):	4,500
Elongation:	800%

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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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