DE-COMP COMPOSITES, INC.

CAUL PAD

CAUL PAD is a non-silicone, uncured rubber which remains pliable and should last several hours at 350°F/177°C before degradation begins. CAUL PAD may be used without fear of contamination, as it contains no silicones or silicates of any kind.

USES:

- Form fitting pressure pads
- Resin dams
- Hydroclave bags
- Reduces core crush
- Reduces wrinkles in composite laminates
- Reduces prepreg bridging
- Vacuum bags

PROPERTIES	
Tensile Strength (psi)	1,305 min.
Elongation (%)	300 min.
Specific Gravity	1.15± .05 min.
Durometer (Shore A)	62
Standard Roll Size	.060" x 4" x 50'
Color	Black

RECOMMENDED FIRST CURE

1. Prepare mold surface with a quality non-silicone mold release or release film.
2. Cut and apply CAUL PAD to the mold surface with overlapping joints of 1/16"-1/2".
3. Vacuum bag with a peel ply, porous TFEG, or perforated release film against the CAUL PAD surface followed by a suitable breather under the bag.
4. Cure in the autoclave at 350°F/177°C for 2 hours at 50-100 psi.
5. All rubbers shrink when subjected to heat. Shrinkage may be minimized by sandwiching peel ply, bleeder fabric, breather fabric, wire mesh, cured laminates prepreg, dry cloth, or foam adhesive with less than 1% volatile content between plies of CAUL PAD.

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CAUL PAD (cont.)

6. One side bondable release film may be used with CAUL PAD to provide a permanent release interface. This combination allows the placement of CAUL PAD directly against uncured laminates.
7. CAUL PAD will take a semi-permanent set but remain tacky after the first cure allowing additional materials to be vulcanized to thin spots, reinforcements to be applied, or placement adjustments to be made during the second cure.

CURING ON UNCURED PARTS

NOTE: All statements, technical information and recommendations contained herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed. No warranties of any kind are made except that materials supplied are DE-COMP standard quality. All risk and liability arising from handling, storage, and use of DE-COMP products, as well as compliance with application legal restrictions, rests with the buyer.

- CAUL PAD may be cured against uncured parts provided a release film, release fabric, or peel ply is placed between the uncured rubber and the part.
- Foam adhesives, with less than 1% volatile content, or bleeder/ breather materials may be encapsulated between plies of CAUL PAD to act as fillers for complex contours.
- Cured parts are excellent molds for first cures. Peel ply, release film or fluorocarbon mold release may be used to prevent CAUL PAD to mold surfaces and / or provide a desired surface text.

REPAIR

- Uncured CAUL PAD readily vulcanizes to cured CAUL PAD and may be spliced or patched without mark off or additional adhesives.

CAUTION

- DO NOT cure against mold surfaces treated with silicone bearing compounds. Such materials will permanently contaminate CAUL PAD.
- DO NOT cure against peel ply or release fabrics containing silicone. Such materials will permanently contaminate CAUL PAD.
- CAUL PAD cures to the exact shape of the surface it is cured against. If release materials, used during the first two cures, bridge or wrinkle, CAUL PAD will mold around them.