

Name _____ **Date** _____ **Project** _____

Objective: _____

Tool Prep

- Obtain a tool of your choice. Tool #/Description _____
- Once you have obtained your tool use a cleaning solvent and a Scotch Brite Pad to clean any debris.
- Use a Class A Wiper to clean the leftover debris.
- Tape around the perimeter of your tool with masking tape. This area is where your sealant tape will be applied.

Verified

Applying Frekote®

- Use a Class A Wiper to apply 3 layers of Frekote® mold release.
- Allow 5-10 minutes between each coat for solvent evaporation.

Note: Move the wiper with a steady motion alternating from top to bottom and left to right after each coat. Avoid wiping over the same area that was applied until the solvent has evaporated.

Coat	Time	Dry Time
1		
2		
3		

Verified

Pre-Staging Work Area

- Cut and gather the required bagging materials.
- Layout the required vacuum bagging materials in the order of operation.
- Remove the blue masking tape and apply vacuum bagging sealant tape around perimeter.
Note: Do not remove backing on sealant tape until the final bag.
- Create a ply table for the part being manufactured.
- Cut and label plies according to ply chart with the ply number and orientation.
- Obtain two vacuum probes, a vacuum gauge, and a vacuum hose.
- Verify that your vacuum source is working properly.

- Nylon Vacuum Bagging Film
- Breather Cloth
- Nylon Peel Ply
- Non-Perf and Perf Parting Film
- Vacuum Probes, Guage, Hose

Roll Serial #: _____

Roll #: _____

Material Type: _____

Verified

Lay-Up

- Remove any debris from the plies.
- If applicable remove the backing on one side of the material.
- Locate the first ply on the tool.
- Continue to lay-up the part according to the ply table.
- Verify each ply is laid-up.

Resin System _____ Mix Ratio _____

Pot Life _____ Resin Weight _____

Cure Time _____ Hardener Weight _____

Mix Start Time _____ Total _____

Weight of Fabric _____ Mix Time _____

Verified

Vacuum Bagging

- Apply a 1" wide edge breather continuously around the perimeter of the part.
- Apply perforated parting film onto part. Apply nylon peel ply.
- Apply non-perforated parting film over perorated parting film.
- Apply breather cloth and probe pads.
- Apply vacuum probes and nylon vacuum bag. Apply vacuum hose and vacuum pressure.

Vacuum Bag Leak Check (Min. 22"Hg)

Vacuum Pressure _____

Vacuum Lost within 5 Minutes (no more than 2") _____

Verified

Curing

 Cure Temperature _____ Hold cure temperature for _____ minutes
 Cure Time _____ Ramp up rate 3° a minute for _____ minutes. Ramp down rate 3° a minute.
 Target Temp a° - Ambient Temp t° = e° ÷ 3° = r minutes to ramp up to a°

Note: Vacuum can be removed once part temperature drops below 135°F.

Verified

