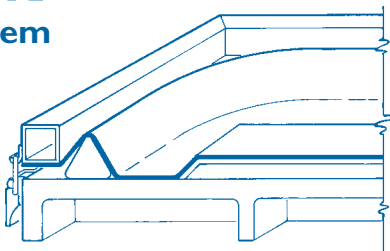


TRIANGULAR SEAL

Aerovac Triangular Seal System

The Triangular Seal system has the following component parts:

- High performance 600% elongation Mosites rubber diaphragm.
- Effective to 230°C.
- Diaphragms can be customised to simple 3-D shapes.
- Aluminium and composite support frame option for diaphragm.
- Triangular edge dam, seal bonded to mould tool periphery.
- Through diaphragm vacuum breach units, with non-return plugs, fitted to customer design.
- Edge clips are used, to restrain the support frame down to the mould tool periphery.



BENEFITS

- Conforms to simple 3-D shapes giving all-round intensification.
- Robust and reusable.
- Eliminates bagging film and sealant tape.
- Easily repairable.
- Quickly applied with low operator skills.

HOW SYSTEM OPERATES

The diaphragm, which is bonded to its aluminium support frame, is placed on to the mould tool and held or clipped into position.

The triangular edge dam seal, which is bonded to the mould tool flange, forms an interference seal with the diaphragm.

Vacuum is then applied to the vacuum breach unit fitted into the diaphragm and as the cavity between the diaphragm and the mould tool is evacuated, the rubber elongates down the inside face of the triangular seal, resulting in an efficient rubber to rubber interface.

The diaphragm will continue to conform to the component shape, but where the component is highly profiled, adjacent to the seal, bridging can occur between the apex of the seal and the top of the component, thus preventing vacuum initiation. In this scenario consideration should be given to the Vacuum Cavity Seal system.

DESIGN REQUIREMENTS

The triangular seal systems requires a flange area of not less the 80mm to accommodate the seals (this is the distance from the outer edge of the mould tool to the outside edge of the consumable package). Special consideration should be given to the corners of the lay-up where the triangular seal requires a minimum 100mm radius around the corner.

The Triangular Seal system can be made to fit most irregular edged profile mould tools.

Consideration should be given to the location of the vacuum pull and monitor plugs as these may intensify and mark off on the finished component. Also they should not be located where they can interfere with the base seal and diaphragm interface. It is normal to locate the monitor plug as far from the vac pull plug as possible.

Aerovac Systems Ltd.

Tel: 01274 550500 Fax: 01274 550501 e-mail: sales@aerovac.com website: www.aerovac.com

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