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# Vacuum bagging consumables — bagging consumables

Core density is written in pounds per cubic foot: 3.0 is about 48 kg/m³.

## Designation

| Item | Value |
|---|---|
| Designation | Vacuum bagging consumables |
| Class | Composites |
| Type | bagging consumables |

## Vacuum bagging consumables: typical values

| Item | Typical value | Source |
|---|---|---|
| Breather, polyester, FAA guidance | 4 oz below 50 psi; 10 oz for 50–100 psi | FAA-H-8083-31, p. 7-21 |
| Airweave N-4 breather/bleeder (polyester) | 4 oz/yd² (135 g/m²); max recommended 400 °F (204 °C) | Airtech Airweave data sheet, p. 3 |
| Airweave N-7 | 7 oz/yd² (237 g/m²); 400 °F (204 °C) | Airtech Airweave data sheet, p. 3 |
| Airweave N-10 | 10 oz/yd² (339 g/m²); 400 °F (204 °C) | Airtech Airweave data sheet, p. 3 |
| Airweave Super 18 | 18 oz/yd² (610 g/m²); 400 °F (204 °C) | Airtech Airweave data sheet, p. 3 |
| Airweave A (rayon, waffle bleeder for wet layup) | 1.6 oz/yd² (54.3 g/m²); 400 °F (204 °C) | Airtech Airweave data sheet, p. 3 |
| Peel ply / release fabric: Release Ease 234 TFP (PTFE-coated glass) | 0.0024 in (0.060 mm) thick; max 288 °C (550 °F); weight not stated on the sheet | Airtech Release Ease 234 TFP data sheet |
| Bagging film: Wrightlon 7400 (nylon) | 0.002 in (50 µm) or 0.003 in (75 µm); 400 % elongation, 55 MPa tensile; max 204 °C; avoid phenolic resins | Airtech Wrightlon 7400 data sheet |
| Sealant tape: AT-200Y (synthetic rubber, yellow) | 1/8 × 1/2 in (3 × 12 mm); max 400 °F (204 °C) | Airtech AT-200Y data sheet |

The FAA handbook gives breather weights and pressures only; it gives no weights for bleeder, peel ply, film or tape. Airweave and tape numbers are Airtech's nominal values for that product; other makes differ.

## Notes

- **Not a bagging schedule.** The stack, plies and cure come from the SRM or the repair data. These tables only identify typical products.
- **Not a core substitution table.** Core type, cell size, density and thickness are engineering data; a different density is a different part.
- **Temperature ratings are maximums, not working points.** They depend on time at temperature; test before use.

SOURCES · Hexcel HexWeb HRH-10 Product Data Sheet · Airtech Airweave Non-Woven Polyester Breathers/Bleeders data sheet, p. 3 · Airtech Wrightlon 7400 Nylon Vacuum Bagging Film data sheet · Airtech AT-200Y data sheet · Airtech Release Ease 234 TFP data sheet · FAA-H-8083-31, AMT Handbook — Airframe, Volume 1, Chapter 7, pp. 7-11, 7-12, 7-21, 7-22

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Reference data. The aircraft manufacturer's documentation (SRM / IPC) takes precedence.