

SILPAK, INC.

470 E. BONITA AVE. POMONA, CA 91767
PH (909) 625-0056 WWW.SILPAK.COM FX (909) 625-0082

Addition Cure Clear RTV Rubber Product Data Sheet

These systems are two-part, addition cure silicone rubbers that are formulated for clarity while providing excellent physical properties. The controlled coefficient of thermal expansion makes these materials ideal for casting pressure pads and for use as an advanced composite tooling rubber. Use for mold making, embedding, electrical applications, thermal expanding tools, and clear part fabrication.

PHYSICAL PROPERTIES (TYPICAL VALUES):

	R-2310	R-2320 LM	R-2230	R-2550
Color:	Clear	Clear	Clear	Clear
Mixed Viscosity@ R.T.:	20,000	35,000	35,000	60,000
Specific Gravity:	1.12	1.12	1.08	1.08
Mix Ratio A/B:	10/1	10/1	10/1	10/1
Cured Compounds @ 77F (25C)				
Durometer A Shore:	15	25	30 (+/-5)	53
Tensile Strength (PSI):	360	450	750	940
Elongation %:	325	310	350	372
Tear Strength (PSI):	60	80	85	152

MIXING INSTRUCTIONS:

The base and curing agent are mixed just before using. Mix 10 parts base to 1 part curing agent by weight. Automatic mixing equipment or manual mixing may be used to combine base and curing agent. Immediately after mixing, place the material in a vacuum chamber to remove trapped air. As the vacuum is drawn, the materials will expand as much as four times it's original volume. Remove from vacuum chamber and pour very gently, so as not to incorporate air back into the material

INHIBITION:

Certain materials will cause inhibition or neutralizing of the curing agent: sulfur and organo-metallic salt containing compounds found in organic rubbers, many condensation cure RTV, chloride solvents, and amines-epoxy. Inhibition may easily be determined by brushing a small quantity of these materials over a localized area of the part to be reproduced. If the material remains gummy or uncured after the curing time, then the part's surface is acting as an inhibitor. ****See Addition Cure Technical Data Sheet for inhibiting materials.**

THE INFORMATION AND DATA CONTAINED BELOW HEREIN ARE BASED ON INFORMATION WE BELIEVE RELIABLE. EACH USER OF THE MATERIAL SHOULD THOROUGHLY TEST ANY APPLICATION AND INDEPENDANTLY CONCLUDED SATISFACTORY PERFORMANCE BEFORE COMMERCIALIZING SUGGESTIONS OF USES SHOULD NOT BE TAKEN AS INDUCEMENTS TO INFRINGE ON ANY PATICULAR PATENT.