

SILPAK, INC.

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

R - 2364 A/B

Room Temperature / Heat Cure Silicone
Product Data Sheet

INTRODUCTION:

R-2364 A/B is two-part silicone rubber designed for tool hardness, physical properties and chemical resistance. R-2364 A/B has excellent high tear and tensile properties; typical applications would be relief type molds because of its firmness and molds with deep undercuts, which are tough to de-mold.

PHYSICAL PROPERTIES (TYPICAL VALUES):

Uncured Compound

Color: "A" Tan/"B" Blue

Viscosity @ R.T.: mixed 100,000 cps

Mixing Ratio A/B: 100/10

Shelf Life: 6 months

Tensile Strength (PSI): 650

Coefficient of Thermal Expansion (cm/cm/ °c) 8.4×10^{-4}

Cured Compound

24 hrs. @ 77F (25C)

Specific Gravity: 1.28

Shore A Hardness: 65

Elongation % 250

Tear Strength (PSI): 110

Conditions of test:

Post cure of 1 hour @ 400F after room temperature cure 24 hours.

MIXING INSTRUCTIONS:

The base and curing agent are mixed just before using. Mix 100 parts base to 10 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 material will expand as much as four times its original volume. Remove from vacuum chamber and pour.

***Note** - If settling should occur at the bottom of your container do not mix material manually. Please call for further instructions.

INHIBITION:

Certain materials will cause inhibition or neutralizing of the curing agent: sulfur and organo-metallic salt containing compounds found in organic rubbers, and 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 substances.

CURING CHART

TEMPERATURE	POT LIFE	CURE TIME
100 F	30 MIN	2 HOURS
150 F	10 MIN	30 MIN
300 F	----	5 MIN

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.