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Clear RTV Rubber

R-2550 A/B

Product Data Sheet

INTRODUCTION:

R-2550 A/B is a two-part, clear silicone rubber designed for its Hardness (Durometer), Clarity and Tear Resistance. The controlled coefficient of thermal expansion makes R-2550 A/B ideal for casting pressure pads and for use as an advanced composite tooling rubber where RTV clarity assists in mold cut out or as a visual aid for injecting resin.

PHYSICAL PROPERTIES (TYPICAL VALUES):

Uncured Compound

Color: Clear
Viscosity @ R.T.: 100,000 cps Mixed: 60,000
Mixing Ratio A/B: 10/1

Cured Compound 24 hrs. @ 77F. (25C)

Specific Gravity: 1.06
Durometer: 53
Elongation %: 372
Tensile Strength (psi): 940
Tear Strength (psi): 152
Work Time: 45 minutes **Cure Time:** 16 hours

Thermal Conductivity BTU-FT F.: 1.5²

Coefficient of Thermal Expansion IN./IN.F.: 8.5×10^{-5}

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 vacuum is drawn, the material will expand as much as four times its original volume. Remove from vacuum chamber. Material may require 48 hours for full hardness, or Post cure at 250f for 1 hour.

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

CURING CHART

TEMPERATURE	POT LIFE	CURE TIME
80 F	45 MIN	16 HOURS
150 F	5 MIN	60 MIN
300 F	----	5 MIN

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