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Clear RTV Rubber **R-2640 RP 120 A/B** Product Data Sheet

DESCRIPTION:

R-2640 RP 120 A/B is a two-part, high strength, high clarity clear silicone rubber designed for mold making and prototyping applications. It's formulated with extra platinum to provide the user with minimized rubber inhibition (Non-Cure) when creating molds from 3D Printed parts, especially SLA. It also provides additional working time of 120 minutes to assist in bubble free molds when degassing mix.

As a mold, it is used cast polyester, urethane, epoxy, low melt metal (600F), thermoplastics (Polyvinyl), wax, soap, plaster, and any material where a release free casting is required. *Add Silicone Pigments for tinting applications if parts are to be made.*

Available Sizes: Qrt Kit (2 lb) Gal Kit (9 lb) & 5 Gal Kit (44 lbs)

PHYSICAL PROPERTIES (TYPICAL VALUES):

Uncured Compound

Color: Clear A and B
Viscosity @ R.T.: 80,000cps Mixed: 38,000
Mixing Ratio A/B: 10/1 By Weight

Cured Compound

24 hrs. @ 77F. (25C)
Specific Gravity: 1.06
Durometer: 40 (+-2)

Tensile Strength (psi): 625
Tear Strength (psi): 120

Elongation %: 425

Thermal Conductivity BTU-FT F.: 1.5²

Coefficient of Thermal Expansion IN./IN.F.: 8.5 x 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.

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 materials/surfaces.**

CURING CHART

TEMPERATURE	POT LIFE	CURE TIME
77 F	120 MIN	12-16 HOURS
150 F	5 MIN	30 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 ON ANY PARTICULAR PATENT.