



## KE-1310ST Heat-Cure, Mold Making Silicone

### FEATURES:

- Translucent, See the Master Through the Mold
- For Long Mold Life When Casting Epoxies or Urethanes
- Superior Strength and Elongation
- Will not Damage the Master
- Easy 10:1 Mix Ratio by Weight
- Offers Extremely Low Shrinkage with Inhibition and Resin Resistance

Shin-Etsu's KE-1310ST is a Premium Grade Silicone with a unique chemical additive to provide unsurpassed urethane and epoxy resin resistance. Ideal for short run production where many parts are produced from a single mold. Its transparent appearance allows for the perfect pour every time saving time and money.

### TYPICAL PROPERTIES

	Typical Value			
	KE-1310ST			
<b>Before Cure:</b>				
<b>Appearance</b>	Clear, Translucent			
<b>Viscosity (23°C, cps.)</b>	90,000			
<b>Catalyst</b>	<b>CAT-1310</b>	<b>CAT-1300L-2</b>	<b>CAT-1300L-4</b>	<b>CAT-1300L-5</b>
<b>Mix Ratio</b>	100/10			
<b>Mixed Viscosity (23°C, cps.)</b>	75,000			
<b>Mixed Specific Gravity</b>	1.07			
<b>Pot Life (23°C, hrs)</b>	1.5	16	2	2
<b>After Cure:</b>				
<b>Hardness (Shore A)</b>	40	40	20	28
<b>Elongation (%)</b>	340	340	600	500
<b>Tensile Strength (psi)</b>	850	850	650	650
<b>Tear Strength (ppi)</b>	125	125	70	110

*\*Data provided as typical data, not for specification purposes.*

## **SHELF LIFE**

The shelf life for KE-1310ST when stored at room temperature in its original, unopened containers is six months from date of shipment.

## **CURE**

For optimal properties, the following heat cure schedules are recommended for KE-1310ST:

60 min at 100°C

120 min at 50°C

30 min at 150°C

## **COMPATIBILITY**

KE-1310ST is an addition curing silicone elastomer. Certain chemicals, curing agents, plasticizers and materials can inhibit cure. The most common are:

- Organo-tin and other organo-metallic compounds
- Silicone rubber containing organo-tin catalyst
- Sulfur, polysulfides, polysulfones and other sulfur containing materials
- Amines, Urethanes, and amine containing materials
- Unsaturated hydrocarbon plasticizers
- High acid content PVC

Should a substrate or material be a possible cause of inhibition, it is best to test a small sample for compatibility with the elastomer. The presence of liquid at the interface of the substrate and the elastomer is a good sign of inhibition.

---

**Specifications:** *The information and data contained herein are believed to be accurate and reliable; however, it is the user's responsibility to determine suitability of use. Since Shin-Etsu Silicones cannot know all of the uses to which its products may be put or the conditions of use, it makes no warranties concerning the fitness or suitability of its products for a particular use or purpose.*

*You should thoroughly test any proposed use of our products and independently conclude satisfactory performance in your application. Likewise, if the manner in which our products are used requires governmental approval or clearance, the customer must obtain it.*

*Shin-Etsu Silicones warrants only that its products will meet its specifications. There is no warranty of merchantability of fitness for use, nor any other expressed or implied warranties. The user's exclusive remedy and Shin-Etsu Silicones' sole liability is limited to refund of the purchase price or replacement of any product shown to be otherwise than as warranted. Shin-Etsu Silicones will not be liable for incidental or consequential damages of any kind.*

*Suggestions of uses should not be taken as inducements to infringe any patents.*