

Basis	Condensation curing silicone casting compounds Silicone rubber Curing agent
Colour	light grey

Applications

- Flexible parts
- Casting mould for gypsum
- Casting mould for wax
- Casting mould for plastic
- Casting mould for ceramic materials
- Casting of flexible gaskets
- Cast-in of electric parts
- Art casting

Properties

- condensation curing
- well castable
- low viscosity
- in-mould releasing

Processing data

Product		Mixture Silicone thin liquid	Silicone rubber	Curing agent
Colour		light grey	white	blue
Mixing ratio	p. b. w.		100	2
Viscosity at 25°C	mPas	6000 ± 1000	7000 ± 1000	14 ± 5
Density at 20°C	g / cm ³	1,12 ± 0,03	1,13 ± 0,02	1,02 ± 0,02
Pot life 200 g / 20°C	min.	80 - 90	-	-
Curing time at RT	hrs.	20 - 24	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength at breakage	ISO 37	%	230 ± 30
Tensile strength / test piece type 2	ISO 37	MPa	2,7 ± 0,5
Tear resistance	ASTM D 624 B	%	12 ± 3
Shore hardness	DIN 53505	Shore A	28 ± 3
Linear shrinkage	internal	%	ca. 0,5

Sales units (packages)

Units	Base	Silicone rubber	0,980 kg / 4,900 kg / 14,700 kg
	Curing agent	Curing agent	0,020 kg / 0,100 kg / 0,300 kg

Processing instructions

For an absolute bubble-free vulcanisate the mixed silicone has to be vented in the vacuum before casting (max. 5 minutes at 10-20 mbar).

Stir thoroughly before use.

With an interlace addition of 4 % removal from the mould is possible after approx. 2-3 hours.

The optimal properties, with regard to shrinking and mechanical strength, are achieved with an interlace addition of 2 %. A mixing of both silicone types among themselves is possible in every mixing ratio.

By addition of approx. 1% of our „Thixo-Additives“ the resulted silicone can be applied by brush resp. spatula.

In General

ebalta silicone casting compounds are self dissociating, condensation-interlacing two-component silicone rubber suitable for production of elastic castings with good mechanical properties. There are two different silicone rubber products available.

The silicone compound „high-solid“ consists of a medium-viscose , pearl- white silicone rubber and possesses very good mechanical properties. Thickening with synthetic silica makes the silicone easily spreadable. For spreading we recommend an interlace addition of 3 %.

The silicone compound „thin“ consists of a low viscous, pearl-white silicone rubber and has very good flow properties. The self-dissociating casting compounds can be cast in any requested thickness. They are used where mechanically stressed parts and moulds with dimensionally stability are required or where high heat resistance is wanted.

Storing

At room temperature (18 – 25°C) and closed original containers storage life is 6 months.

Partly used containers have to be closed always and the material has to be used up as soon as possible.

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste.

Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.

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