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Low Cost Silicone RTV ECONOSIL – 25 A/B Product Data Sheet

ECONOSIL-25 A/B Tin Base (Condensation Cure), two-component, room temperature cure (RTV) rubber designed as a low cost mold material with good physical properties primarily for making short-run production molds. Use molds to cast polyester, urethane, epoxy, low melt metal (350F), thermoplastics (Polyvinyl), wax, soap, plaster, and any material where a release free casting is required. **Available Sizes:** Gal Kit (9 lb) 5 Gal Kit (44 lbs) 55 Gallon Drum (495 lbs)

Product Features:

- 1) Good Physical Properties
- 2) Low Viscosity for ease of pouring
- 3) Low Cost Moldmaking Material
- 4) Brush-On (Thixotropic) Catalyst Available *R-1300TH B*

PHYSICAL PROPERTIES (TYPICAL VALUES) UNVULCANIZED

Color: Off-white-A / Blue-B

Viscosity @ 77F 50,000 cps mixed

Shelf Life: 6 months in a closed container

TYPICAL PROPERTIES OF CURED RUBBER

Color:	Blue
Specific Gravity:	1.15
Hardness:	25 Shore A
Tensile Strength:	450 psi
Elongation at Break:	300%
Tear:	100 ppi

MIXING & CURING INSTRUCTIONS:

Adding the curing agent Econosil-25 B processes Econosil-25 A. The addition of 10% catalyst (by weight) has a pot life of 40 minutes and is ready for de-molding after 15 to 24 hours. After the mold has been removed from the master, it should be left for 24 hours in order to develop its maximum mechanical strength.

Brush On Molds

For brush-on molds, use *R-1300THB* Catalyst or *PE-ESS-5F* Mini Fibers in place of the pour catalyst. The first coat (Detail/Print Coat) should be applied using the normal catalyst. Mix a small batch and paint on the first layer, ensuring that the entire model is covered—Material will drip and pool around the base of model so a dam made of clay or cardboard should be made to contain material. Once material has gelled—60 to 75 minutes later—the brush on coat can be applied. Continue to build mold wall thickness by applying one coat after another, about an hour apart. This may take several coatings but the goal is to achieve a mold wall thickness of 3/8 to 1/2 inch. It is recommended when building a brush-on mold to complete it within a short period of time (within 24 hours) to avoid any adhesion problems between layers. Keep mold covered to avoid dust settlement that could affect the adhesion between coatings. Hot summer weather could shorten work time. Once rubber mold has been completed and is fully cured, the process of building a support mold made of plaster (*Castshell*), fiberglass (*SLR-22*) or urethane plastic (*Trowel On 60*) to hold the thin rubber mold bladder is undertaken.

Faster Cure

To quick cure Econosil-25 RTV system, add drops of **Rapid Set** at appropriate ratio for a 1-4 hour demold time. Or, use additional catalyst at ratios of 12-15%. **Note:** The addition of Rapid Set or extra Catalyst will shorten storage shelf life of rubber.

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.