

# SILPAK, Inc

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## High Flex Silicone RTV R-1318 A/B Product Data Sheet

**R-1318 A/B—15 A Shore** Tin Base (Condensation Cure), two-component, room temperature cure (RTV) rubber designed with high elongation and flexibility properties for making molds of parts with undercuts. It is also used as a general purpose, high strength rubber used for soft rubber parts. 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:** Pint Kit (1 lb) & Quart Kit (2 lb) Gal Kit (9 lb) & 5 Gal Kit (44 lbs) 55 Gallon Drum (495 lbs)

### Product Features:

- Produces mold with High Elongation and Flexibility for Heavy Undercuts
- Excellent Physical Properties with High Tear Resistance.
- Produces mold with a Long Working Life.

### PHYSICAL PROPERTIES (TYPICAL VALUES) UNVULCANIZED

Color: Off-white- A / Green-B

Viscosity @ 77F: 26,000 cps mixed

Shelf Life: 6 months in a closed container

### TYPICAL PROPERTIES OF CURED RUBBER

Specific Gravity: 1.13

Hardness: 15 A Shore

Tensile Strength: 400 psi

Elongation at Break %: 550

Tear Resistance: 100 pli

### MIXING & CURING INSTRUCTIONS:

Process part A by adding the curing agent B. **Part B should be shaken prior to use.** 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. R-1318 B has a trace of pigment for good dispersion. De-airing (degassing) material is always recommended. Immediately after mixing, place the material in a vacuum chamber to remove trapped air and allow enough room for expansion as vacuum is drawn, as much as four times its original volume. Remove from vacuum chamber and pour very gently into cavity so as not to re-incorporate air into the material. 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

Use **Thix 5170 Additive** to create brush-on, low sag, rubber bladders. Material will thicken shortly after mixing. **PE-Mini Fibers** powdered filler is also available for creating thick, spreadable paste-like consistencies.

### Fast Cure

To quick cure, add **Rapid Set Additive** at time of mix at 4 to 16 drops per pound of RTV for 1 to 6 hour cure time. **Note:** The addition of Rapid Set accelerator will shorten storage shelf life rubber.

### STORAGE/SHELF LIFE:

A and B components must be stored in their original, unopened containers at temperatures between 60-90F. Shelf life of materials when kept in unopened, sealed containers, at the recommended storage conditions, is 6 months.

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.