SILPAK, Inc

470 E. BONITA AVE. POMONA, CA 91767
PH (909) 625-0056 WWW.SILPAK.COM FX (909) 625-0082

COLD MOLDING RUBBER

R-1324 FC A/B

Product Data Sheet

R-1324 FC A/B Tin Base (Condensation Cure), two-component, room temperature curing (RTV) rubber designed for making molds on frozen parts—highly useful tool for taxidermists. Once mixed, rubber is poured directly over frozen part and allowed to cure—either in the freezer or at room temperature. Once cured, use temporary 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.
Note: *Cured rubber storage shelf life is limited due to the rapid setting properties.*
Available Sizes: Pint Kit (1 lb) & Quart Kit (2 lb) Gal Kit (9 lb) & 5 Gal Kit (44 lbs)

Product Features:

- Ability to Cure Over Frozen Objects
- Excellent Physical Properties with High Tear resistance.
- Low Viscosity for Ease of Pouring

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PHYSICAL PROPERTIES (TYPICAL VALUES) UNVULCANIZED
Color: Off-white A / Blue B
Viscosity @ 25C: 30,000 cps mixed A & B
Shelf Life: 6 months in a closed container

TYPICAL PROPERTIES OF THE CURED RUBBER

Specific Gravity:	1.18
Hardness:	15 A SHORE
Tensile Strength:	340 psi
Elongation at Break %:	570
Tear Resistance:	111

Gel Time: *10 Minutes @ 75F Room Temperature
De-Mold Time: *3 Hours @ 75F Room Temperature

MIXING & CURING INSTRUCTIONS:
R-1324 FC A is processed by adding Curing Agent R-1324 FC B. The addition of 10% catalyst (by weight) has a Gel Time of 10 Minutes. De-molding will vary by Ambient Curing Temperatures: In Freezer—Next Day; At Room Temperature—3 Hours.

Blend both A and B components thoroughly together for several minutes until color is uniform and ***immediately pour over*** Frozen Part. Vacuum Degassing the mixed material may not be viable due to the limited Gel Time. Using light air pressure from hair dryer or air hose can help to manually press out bubbles. At this point, material can be placed in the freezer and allowed to cure or it can be allowed to finish cure at room temperature.

After the mold has been removed from the master, it should be left for 24 hours in order to develop its maximum mechanical strength.

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.