

# SILPAK, Inc

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## Brush-On Silicone RTV R-1328 A / R-1300<sup>TH</sup> B Product Data Sheet

**R-1328 A/ R-1300<sup>TH</sup> B** Tin Base (Condensation Cure), two-component, room temperature cure (RTV) rubber designed primarily for making high strength, brush-on molds. The Catalyst (Part B) has a built in thickener (thixotropic) for creating a creamy, thick material that can be applied to surface of model without sagging. Multiple coats are applied within several hours to build a mold skin thickness between 3/8 and 3/4 inch, with overnight cure—15-24 hours. Molds are used 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:

- 1) Excellent Physical Properties with High Tear Resistance
- 2) Creamy Viscosity and greater flow control for Brush-On molds
- 3) Produces mold with Long Working Life

### PHYSICAL PROPERTIES (TYPICAL VALUES) UNVULCANIZED

Color: Off-White A / Red B

Viscosity @ 77F, Mixed: Thick Creamy Paste

Shelf Life: 6 months in a closed container

### TYPICAL PROPERTIES OF CURED RUBBER

Specific Gravity: 1.14

Hardness: 20-22 A Shore

Tensile Strength: 425 psi

Elongation at Break : 350 %

Tear Resistance: 80 pli

**\*\*Gel Time: 35 min** (Please pre-test if using R-1300 TH B with different Base—A side of system)

### MIXING & CURING INSTRUCTIONS:

R-1328 A is processed by adding the curing agent R-1300 TH B. The addition of 10% catalyst (by weight) has a pot life of 35 minutes and is ready for de-molding after 15 to 24 hours. R-1300 TH B has thixotropic & pigment for good dispersion and should be **shaken each time** before mixing. First coat is applied thin to capture detail—use light air pressure from hair dryer to relieve surface bubbles. Remainder of coatings can be mixed and applied 45 – 60 minutes later. **Build Mold Wall Thickness to a minimum of 3/8 to 3/4 inch thick.** A mold can be completed within two hours of work time. Mixtures can be mixed and de-aired prior to use and allowed to age (which builds viscosity) for subsequent layers. Do not apply print/detail coat and let stand overnight to cure—mold rubber should be applied in successive layers over several hours. Mother Mold can be applied next day after rubber bladder has completely cured, using plaster (*Castshell*), fiberglass (*SLR-22*) or urethane plastic (*Trowel On 60*) to support the thin rubber mold bladder. (**Note: *Highly Detailed Masters, use R-1324 B Catalyst for the Detail Coat, applying at least 2 coats—90 minutes between layers, before building up Mold's wall thickness with R-1300TH B.***)

### Faster Cure

**Rapid Set** at 10 drops/lb for a 1 hour cure. **Note:** Curing a mold quickly with extra catalyst or rapid set will decrease over all storage shelf life of molds and affect mold rubber properties.

### 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.