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High Strength General Purpose Silicone RTV

R-1328 A/B

Product Data Sheet

R-1328 A/B—25 A Shore Tin Base (Condensation Cure), two-component, room temperature cure (RTV) rubber designed primarily as general purpose, high strength rubber for making molds and flexible 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:

- 1) Excellent Physical Properties with High Tear Resistance.
- 2) Produces mold with a Long Working Life.
- 3) Low Viscosity for ease of pouring
- 4) Multiple Catalyst Available: **R-1324 B—Blue, *Faster Cure*** **R-1300TH B—Red, *Brushable Catalyst***

PHYSICAL PROPERTIES (TYPICAL VALUES) UNVULCANIZED

Color: Off-white A / Green B

Viscosity @ 25C: 26,000 cps mixed

Shelf Life: 6 months in a closed container

TYPICAL PROPERTIES OF CURED RUBBER

Specific Gravity:	1.14
Hardness:	25 shore
Tensile Strength:	550 psi
Elongation at Break %:	520
Tear Resistance:	110 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 45-60 minutes and is ready for de-molding after 15 to 24 hours. R-1328 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 Molds

For brush-on molds, use **R-1300th B Red Catalyst** or **PE-ESS-5F Mini Fibers** in place of the pour catalyst. The first coat (Detail/Print Coat) should be applied using the **R-1324 B Blue Catalyst—this catalyst sets up quicker in thin sections.** 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. **Note:** Also available is **Thix 5170 Additive** to create brush-on, low sag, rubber bladders.

Faster Cure

To quick cure, 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.

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.