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Brush-On Silicone RTV
R-1348 A / R-1324TH B
Product Data Sheet

R-1348 A/ R-1324TH B Tin Base (Condensation Cure), two-component, room temperature cure (RTV) rubber designed primarily for making high strength, brush-on molds quickly. The Catalyst (Part B) has a built in fast setting, 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 ¾ inch, with a demold time of 6-8 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) Fast Cure 6-8 hours for quick multi-part mold fabrication
2) Excellent Physical Properties with High Tear Resistance
3) Low Viscosity and greater flow control for Brush-On molds
4) Produces mold with Long Working Life

PHYSICAL PROPERTIES OF UNVULCANIZED MATERIAL

Color: Off-White / Catalyst Blue
Viscosity @ 77F: Thick Creamy Paste, mixed
Shelf Life: 6 months

TYPICAL PROPERTIES OF CURED RUBBER

Specific Gravity:	1.14
Mix Ratio:	100A/ 10B
Hardness:	30 A Shore
Tensile Strength:	525 psi
Elongation %:	450
Tear Resistance:	110 pli

MIXING & CURING INSTRUCTIONS:

R-1348 A is processed by adding the curing agent R-1324TH B. The addition of 10% catalyst (by weight) has a pot life of 45 minutes and is ready for demolding after 8 to 10 hours. R-1324TH B has a trace of pigment for good dispersion. After the mold has been removed from the master, it should be left for 24 hours in order to develop its maximum mechanical strength.

STEP 1 *Detail Coat*

Use *R-1324TH B* to apply the 1st coat (Detail Coat)—Mix small batches, just enough material to apply and cover the entire object—wait 20-25 minutes before applying. Make sure a containment/dam surrounds object to hold pooling material. Start at the highest point and allow material to ooze over objects surface—using a stiff brush, dab into highly detailed areas. Allow coat to tack up—90 minutes—before applying additional coats. *Minimum of 2 Detail Coats should be applied prior to building up the mold's wall thickness

STEP 2 *Building Mold's Wall Thickness*

Use *R-1324TH B* to build up the mold's wall thickness. After mixing, allow it to thicken before applying—5 to 10 minutes. Allow 45-60 minutes between recoating. Build wall thickness to a minimum of 3/8" to 1/2" an inch. Mold could be completed within several hours. *R-1324TH B* has a Gel Time of 40 minutes. 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.

Faster Cure

Add R-1324TH B @ 12% for a 3-4 hour demold time (15% for 2-2.5 hour de-mold time) or use *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.