

# SILPAK, Inc

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## Tin Silicone RTV R-1348 A / R-1332 B Product Data Sheet

**R-1348 A/ R-1332 B—30 A Shore Tin Base** (Condensation Cure), two-component, room temperature cure (RTV) rubber designed for general purpose applications where a low shrink, durable rubber mold or part is required—30 A Shore. Its consistent curing characteristics, excellent shelf life, and outstanding physical properties make it a product that can easily meet a wide variety of applications. Use to cast foam, 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:

- User Friendly and Trouble Free Cure
- Excellent Physical Properties with High Tear Resistance
- Good Polyester and Urethane Resin Resistance.

### PHYSICAL PROPERTIES (TYPICAL VALUES) UNVULCANIZED

Color: Off-White A / Black B

Viscosity @ 77F: 32,000 cps mixed

Shelf Life: 6 months

### TYPICAL PROPERTIES OF CURED RUBBER

Specific Gravity: 1.14

Mix Ratio: 100A/ 10B

Hardness: 30 A Shore

Tensile Strength: 600 psi

Elongation: 425 %

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 5% catalyst (by weight) has a pot life of 45 minutes and is ready for demolding after 10-12 hours. R-1332 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. \*\*Mechanical properties are dependent on the catalyst level.

### Brush-On

Use R-1300<sup>TH</sup> B to create brush-on, low sag rubber bladders—20min Gel Time. PE-Mini Fibers powdered filler is also available for creating thick, spreadable paste-like consistencies.

### 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.