SILPAK, Inc

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

High Strength, Low Viscosity Platinum RTV
R-2138 A/B
Product Data Sheet

R-2138 A/B—42 A Shore Platinum Base (Addition Cure), two-component, room temperature curing (RTV) silicone rubber with excellent physical properties designed for mold making, embedding, electrical applications and thermal expanding tools. This system's low viscosity allows for easier mixing and de-airing while providing high tear strength and elongation properties. Create production molds or parts with extreme accuracy and dimensional stability with extended library shelf life of cured rubber. Use molds to cast polyester, urethane, epoxy, low melt metal (600F), 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)

PHYSICAL PROPERTIES (TYPICAL VALUES) UNVULCANIZED

Color:	Tan A / Purple B
Viscosity @ 77F:	10,000 cps, mixed
Mixing Ratio, A/B:	100/10 by Weight**
Shelf Life:	6 months

TYPICAL PROPERTIES OF CURED RUBBER @ 24 Hrs 77F (25C)

Specific Gravity:	1.29
Hardness:	42 A Shore
Tensile Strength:	750 psi
Elongation %:	350
Tear Strength:	125 pli

MIXING & CURING INSTRUCTIONS: ** (Scale is required for Accurate Measurement)
Mix 10 parts base to 1 part-curing agent by weight. Automatic mixing equipment or manual mixing may be used to combine base and curing agent. Immediately after mixing, place the material in a vacuum chamber to remove trapped air. As the vacuum is drawn, the materials will expand as much as four times its original volume. Remove from vacuum chamber and pour very gently, so as not to incorporate air back into the material. Cure can be accelerated with mild heat, 150F @ 1 hour per inch thick. Note: *This product was designed for high knotty tear and low viscosity, and off ratios will create a rubber with poor cured properties. Part A should be stirred before using.*

INHIBITION:
Certain materials will cause inhibition or neutralizing of the curing agent. These materials are sulpher and organo-metallic salt containing compounds found in organic rubbers and many condensation cure RTV, chloride solvents – aimnes. Avoid using latex gloves, water based clays and Tin/Condensation cured RTVs. Inhibition may easily be determined by brushing a small quantity of this material over the surface and allowing it to cure. If material remains tacky and gummy after the curing time, then the part's surface is acting as an inhibitor. **See Addition Cure Technical Data Sheet for inhibiting materials

CURING CHART

TEMPERATURE	POT LIFE	CURE TIME
100 F	30 MIN	2 HOURS
150 F	10 MIN	30 MIN
300 F	------	5 MIN