

# SILPAK, Inc

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

## Extended Work Time Platinum RTV R-2234 SL A/B Product Data Sheet

**R-2234 SL A/B—35 A Shore Platinum Base** (Addition Cure), two-component, room temperature curing (RTV) silicone rubber designed with extended work time (Gel)—2 hours. The controlled coefficient of thermal expansion makes R-2234 SL A/B ideal for casting pressure pads and advanced composite tooling rubber. Designed for mold-making, embedding, electrical applications, and thermal expanding tools. 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: White A / Blue B  
Viscosity @ 77F: 32,000 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: 1.08  
Hardness: 35 A Shore (+/-5)  
Tensile Strength: 525 psi  
Elongation %: 440  
Tear Strength: 90 pli

Thermal Conductivity BTU-FT F:  $8.0 \times 10^{-4}$

Coefficient of Thermal Expansion cc /cc / °C:  $11 \times 10^{-4}$

### MIXING & CURING INSTRUCTIONS:

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.

### INHIBITION:

Certain materials will cause inhibition or neutralizing of the curing agent. These materials are sulphur and organo-metallic salt containing compounds found in organic rubbers and many condensation cure RTV, chloride solvents – amines. 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

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.