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Food Grade RTV R-2237 SL A/B Product Data Sheet

R-2237SL A/B Platinum Base (Addition Cure), two-component, room temperature curing (RTV) silicone rubber with an extended work time (Gel Time 1.5 Hours) designed for mold making. This system is ideal for making molds used for food contact as well as standard casting applications. Molds are used for casting soap, wax, chocolate, candies or other food products. R-2237SL A/B has been tested to meet the requirements of FDA Extraction Test: CFR 177.2600, Code of Federal Regulations www.access.gpo.gov/nara/cfr-table-search.html *Contact Technical Support for further information.*

Available Sizes: Pint Kit (1 lb) & Qt Kit (2 lb) Gal Kit (9 lb) & 5 Gal Kit (44 lbs)

PHYSICAL PROPERTIES (TYPICAL VALUES):

Uncured Compound

Color: "A" White; "B" Green
Viscosity @ R.T.: 60,000 cps
Mixing Ratio A/B: 10/1
Shelf Life: 6 months

Gel Time: 1.5 hours
Cure Time: 16-24 Hours

Cured Compound

24 hrs. @ 77F (25C)
Specific Gravity: 1.08
Durometer: 35 +/-5
Elongation %: 300
Tensile Strength (psi): 700
Tear Strength (pli): 80
Thermal Conductivity: btu/ft °F: 8.0×10^{-2}

MIXING & CURING INSTRUCTIONS:

The base (A) and curing agent (B) are mixed just before using. **Part B should be shaken prior to use.** Carefully weigh Part A and Part B by appropriate Mix Ratio. Automatic mixing equipment or manual mixing may be used to combine base and curing agent. 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 (or part) has been removed from the master, it should be left for 24 hours in order to develop its maximum mechanical strength. If, after overnight cure, surface is tacky, add mild heat to finish cure (150F for 30 minutes).

INHIBITION:

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

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.