

# SILPAK, Inc

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## Clear RTV Rubber R-2240 A/B Product Data Sheet

**R-2240 A/B—40 A Shore** *Clear* Platinum Base (Addition Cure), two-component, room temperature curing (RTV) silicone rubber. The controlled coefficient of thermal expansion makes ideal for casting pressure pads or to be used as an advanced composite tooling rubber. R-2240 A/B RTV is great for mold tooling where precise parting lines need to be cut or to use as a visual aid for injecting resin. Use for mold making, embedding, electrical applications, thermal expanding tools, and clear part fabrication. 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. *Add Silicone Pigments for tinting applications.*

**Available Sizes:** Pint Kit (1 lb) & Qrt Kit (2 lb) Gal Kit (9 lb) & 5 Gal Kit (44 lbs) 55 Gallon Drum (495 lbs)

### Accessories

- **Colorants:** Silicone Pigments
- **Thickener:** Thix# 2 for Brushable applications
- **Softener:** F-100 Fluid

### PHYSICAL PROPERTIES (TYPICAL VALUES) UNVULCANIZED

Color: Clear A / Clear B  
Viscosity @ 77F: 40,000 cps, mixed  
Mixing Ratio, A/B: 100/10  
Shelf Life: 6 months

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

Specific Gravity: 1.08  
Hardness: 40 A Shore  
Tensile Strength: 640 psi  
Elongation %: 320  
Tear Strength: 100 pli

Thermal Conductivity BTU-FT F.: 1.5<sup>2</sup>

Coefficient of Thermal Expansion (in/in/F): 8.5 x 10<sup>-5</sup>

### 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. Since material is clear, a double mix—mixing in one container then transferring to another and re-mixing—is recommended to ensure a thorough mix. 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. Pressure casting (50-60psi) until cured has proven well in eliminating air bubbles. 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.

### 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. 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.**

## CURING CHART

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

## STORAGE 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.