

SILPAK, Inc

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

Room Temperature / Heat Cure Silicone

R-2264 A/B

Product Data Sheet

R-2264 A/B—50 A Shore Platinum Base (Addition Cure), two-component, room temperature curing (RTV) silicone rubber designed for mold-making, embedding, electrical applications, and thermal expanding tools. The controlled coefficient of thermal expansion makes R-2264 A/B ideal for casting pressure pads and for advanced composite tooling rubber applications. 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: 70,000 cps, mixed
Mixing Ratio, A/B: 100/10
Shelf Life: 6 months

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

Specific Gravity: 1.25
Hardness: 50 A Shore (+/-5)
Tensile Strength: 555 psi
Elongation %: 300
Tear Strength: 80 pli

ELECTRICAL PROPERTIES:

Dielectric Strength: 600 Volts/mil
Volume Resistivity: 5x10 ohms/cm
Dielectric Constant, at 100KHz: 3.0

Thermal Conductivity BTU-FT F: 8.11×10^{-4}
Coefficient of Thermal Expansion cm/ cm / °C: 9×10^{-4}

MIXING INSTRUCTIONS:

The base and curing agent are mixed just before using. 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 material will expand as much as four times its original volume. Remove from vacuum chamber and pour.

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 – 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

CAUTION: Oven curing may cause bonding of rubber to substrate. If accelerated curing is desired, user must first test substrate prior to accelerating cure.

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.