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Room Temperature / Heat Cure Silicone

R-2364 A/B

Product Data Sheet

R-2364 A/B—65 A Shore Platinum Base (Addition Cure), two-component, room temperature curing (RTV) silicone rubber designed for tool hardness. R-2364 A/B has excellent high tear and tensile properties; typical applications would be relief type molds because of its firmness and molds with deep undercuts, which are tough to de-mold; 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. **R-2360 B is clear for custom color applications with Silicone Pigments.

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 / Blue B **R-2360 B-Clear

Viscosity @ 77F: 100,000 cps, mixed

Mixing Ratio, A/B: 100/10

Shelf Life: 6 months

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

Specific Gravity: 1.28

Hardness: 65 A Shore

Modulus @100%: 510 psi

Tensile Strength: 650 psi

Elongation %: 250

Tear Strength: 110 pli

Coefficient of Thermal Expansion (cm/cm/ °c): 8.4×10^{-4}

Conditions of Test: Post cure of 1 hour @ 400F after room temperature cure 24 hours

MIXING & CURING INSTRUCTIONS:

The base and curing agent are mixed just before using. Mix 100 parts base to 10 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.

*Note - If settling should occur at the bottom of your container do not mix material manually. Please call for further instructions.

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.