



RTV Mould making series silicone

High strength Fast Curing Silicone
Mould making rubber RTV

Features

- Good flow ability and long working time
- Medium hardness
- High tear and tensile strength
- Easy de-mould from complex replica parts
- Acid and alkali-resistance
- Low linear shrinkage

Applications

Base and Curing Agent Mixture (100:1.5 by weight) in 20 C testing

Examples:

0.5Kg Silicone – 7.5 g Catalyst

1Kg Silicone - 15 g Catalyst

5 Kg Silicone - 75 g Catalyst

Item	Characteristically before curing				Curing	
	Silicone	Catalyst	Silicone + Catalyst		Pot life at 20°C mins	De-moulding Time at 20°C hours
	Appearance	Appearance	Ratio	Viscosity cps		
RTV2015	Off-white	Clear	100:1.5	20000	20	6
RTV2020	Off-white	Clear	100:1.5	22000	20	6
RTV2025	Off-white	Clear	100:1.5	27000	20	6
	Characteristically after curing 24 hours					
	Hardness	Tear strength (N/mm)	Tensile Strength(Mpa)	Elongation break (%)	Linear Shrinkage	
RTV2015	15±1	32±2	28±2	600	≤0.2%	
RTV2020	20±1	36±2	30±2	550	≤0.2%	
RTV2025	25±1	39±2	32±2	500	≤0.2%	

Description

RTV mould making rubber is a two-component material, consisting of Part A base silicone and Part B CA30 curing agent cures at room temperature by a condensation reaction. These materials can be cast into the cured silicone to mould plaster, polyurethane, PU, GRC, cement, resin, polyester, wax etc..

How to make the silicone mould?

- The surface of the original should be clean and free of loose material. If your products with thin flower patterns, and especially with porous substrates, please use a suitable mould release agent such as soap water, detergent, vaseline or petroleum jellies.
- Please weight the silicone and Catalyst CA30 curing agent in a clean container as guided by our mixing table. Thoroughly stir the silicone before use, as filler separation may occur upon prolonged storage. Mix the silicone and catalyst evenly until the CA30 completely dispersed in the base.
- Hand or mechanical mixing can be used, but do not for an extended period of time or allow the temperature to exceed 35C (95F). Mix suitably small quantities to ensure thorough mixing of the silicone and curing agent.

It is strongly recommended that entrapped air be removed in a vacuum chamber, allowing the mix to completely expand and then collapse. After a further 1-2 mins under vacuum, the mix should be inspected and can be used if free of air bubbles. A volume increase of 3—5 times will occur on vacuum de-airing the mixture. So a suitably large container should be chosen.

Pouring the mixture and curing

- Pour the mixed silicone and catalyst as soon as possible onto the original, avoiding air entrapment. The catalyzed material will cure to a flexible rubber within 6 hours (**or faster by different mixing ratio or room temperature**), we advise you de-mould after 24 hours, it will improve the replicate times of silicone mould.

Storage

- When stored at or below 30 C (85F) in the original unopened containers, Both the Silicone and Catalyst have a usable life of 10 months. From the date of production. After 10 months stock, pls use the Stir to mixing the Part A silicone for some mins, then the silicone can be used again, no influence for other performance.

Please Note:

This Silicone is an industrial product and must not be used in food moulding, dental human skin moulding applications.