

Technical Data Sheet

Calsil RTV PA 04 A+B

Brand Calsil
Market Machinery & Equipment
Product name Calsil RTV PA 04 A+B

1. Product Description

It's a pourable bi-component RTV-2 silicone rubber, vulcanizing at room temperature with a poly-addition process without shrinkage.

2. Key Properties

- Low viscosity
- 4 Shore A
- Biocompatible and non-toxic

3. Applications

Calsil RTV PA 04 is suitable for production of heels and prostheses.

Typical Properties (not for sales specifications, please contact us prior to writing sales specs)

Physical Properties	Units	Values
Chemical characterization		Addition cured RTV-2
Aspect part A		Fluid / translucent
Aspect part B		Fluid / translucent
Viscosity	mPa.s	1800
Odour		odourless

Curing Properties	Units	Values
Mix Ratio		100:100
Working time	Minutes	10
Setting time	Minutes	50 ÷ 70

Properties of the cross linked product	Units	Values
Hardness 24h	Shore A	4
Specific gravity	g/cm ³	1.05
Elongation	%	300 ÷ 400
Tensile strength	MPa	1.5
Tear strength	KN/m	4.0
Shrinkage after 24h	%	<0.1%

4. How to Use

Make sure that the substrate is perfectly clean and dry. Before using, shake well the bottles of part A and B. Weigh the same quantity of part A and part B. If the proportions are not exact, the curing times and the final properties can be different. Mix about thirty seconds until a homogeneous mixture is obtained, then pour the mixture on the model to duplicate.

To reduce air bubbles, we suggest a vacuum de-airing treatment before pouring the silicone rubber, compatible with the curing times.

Before casting, vacuum degassing (20-30 mm of mercury) is recommended.

Release the vacuum several times. To achieve this, the container should allow an expansion of the fluid at about 3-5 times the initial level. Avoid prolonged degassing too, so as not to volatilize certain components required for curing.

The curing speed is influenced by the temperature. We recommend to work in an isothermal place at 23 °C. Higher temperatures accelerate the curing times, lower temperatures reduce them.

The cured silicone can be demoulded after sixty minutes. In order to reach the best performance of the silicone rubber, we suggest waiting for 24 hours before using them

Other recommendations:

This product is dermatologically tested, Patch tests show that the product is non-irritating to human skin. It is recommended to operate in accordance with good industrial hygiene.

Some inhibitions to vulcanization process may occur when the silicone rubber get in contact with amines, plastilines, metal salts, sulphided, tin catalysts and poly-condensation silicone rubbers. To avoid any inhibition problems, we recommend a preliminary test for the compatibility of the silicone on the substrate.

5. Handling

This document does not contain safety precautions. Before handling this material, please read the Material Safety Data Sheet, check the label on the container, and conform to the safety, physical and hazard guidelines and precautions. The Material Safety Data Sheet is available from your nearest Caldic office.

6. Storage and Shelf Life

The product, when stored under appropriate conditions, is stable and usable for 12 months. Beyond this date, we no longer guarantee that the products meet sales specifications.

We suggest to keep the products in their original packaging, well-closed at a temperature between +7 °C and +27 °C, in well-aired places.

Do not reverse the caps and put always the counter-caps in their packaging.

7. Packaging

CALSIL® RTV PA 04 A (based) is available in drum kg 200, pail kg 20 and can kg 5.

CALSIL® RTV PA 04 B (catalyst) is available in drum kg 200, pail kg 20 and can kg 5.


8. Restrictions

This ingredient is solely proposed in industrial applications. It is not suitable to be used in cosmetic, medical, human injection, pharmaceutical or food applications

9. Limited Warranty PLEASE READ CAREFULLY

- The information herein is offered in good faith. It is believed to be accurate at the time of shipment.
- It should not be used as a substitute for the customer's test, the customer bears the responsibility to ensure that the product matches the intended application is safe and achieves the desired benefits.
- The product warranty is limited to the refund value of the purchase or the replacement only when it is demonstrated that the product is out of the agreed sales specifications.
- Calsil is a registered trademark of Caldic B.V. All rights reserved.

For more information, please contact our nearest office

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