

# Technical Data Sheet

## Calsil RTV PA 28 A&B RED

<b>Brand</b>	Calsil
<b>Market</b>	Machinery & Equipment
<b>Product name</b>	Calsil RTV PA 28 A&B RED

### 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

- High mechanical properties
- Low viscosity
- Flexible and resistant moulds
- High details reproduction

### 3. Applications

Calsil RTV PA 28 A&B RED is specially design for the reproduction of wax, plaster and resins models. It's also used in the pad printing field.

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

Physical Properties	Units	Values
Chemical characterization		Addition cured RTV-2
Appearance part A		Fluid / White
Appearance part B		Fluid / Red
Viscosity	mPa.s	8000
Odour		odourless
Solubility		Not mixable in water, dispersible in most of solvents
Curing Properties	Units	Values
Mix Ratio		100 : 100
Working time	Minutes	60
Setting time	Hours	4
Properties of the cross linked product:	Units	Values
Hardness 24H	Shore A	30
Specific gravity	g/cm <sup>3</sup>	1.14
Elongation	%	400 ÷ 500
Tensile strength	MPa	5.0
Tear strength	KN/m	20
Shrinkage (after 24h)	%	<0.1

## 4. How to Use

Make sure that the model to duplicate is clean and dry. Before using shake well the part A and the part B. Weight the same quantity of part A and B. If the proportions are not exact, the curing times and the final properties can be different. Mix about a minute until a homogeneous colour 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 silicon 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 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 4 hours. In order to reach the best performance of the moulds, we suggest to wait for 24 hours before using them.

### **USE OF THIXOTROPIC AGENT:**

After you have homogenized the silicone rubber, add 3% of Thixotropic Agent and mix in a suitable container for 3-5 minutes. You get a very viscous mass, which can be applied in vertical. With a brush or a spatula, spread the thixotropic silicone rubber to form a layer of 5-10 mm. If necessary, repeat after 1-2 hours (before the silicone rubber is completely cured) to obtain a mould with good strength. (20-40 mm).

Other recommendations:

Some inhibitions to vulcanization process may occur when the silicone rubber gets in contact with amines, plastilines, metal salts, sulphide, 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 material to duplicate.

## 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<sup>®</sup> RTV PA 28 A is available in pail 20kg and can 5kg.

CALSIL<sup>®</sup> RTV PA 28 B RED is available in pail 20kg and can 5kg.

## 8. Restrictions

This ingredient is solely proposed in the above listed applications.

It is not suitable to be used in 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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