



# Technical Data Sheet

**Brand** Calsil  
**Market** Machinery & Equipment  
**Product name** Calsil RTV PA 30FG

## 1. Product Description

It's a pourable 2-part addition cure silicone elastomer system specially formulated for use in the food and confectionary industries.

## 2. Key Properties

- **FDA CFR 177.2600** compliant for fatty and aqueous foods
- Very low shrinkage
- High dimensional stability
- Easily degassed
- FDA Compliance: Approved for food use, all components present in the fully cured product are listed in CFR 21 , 175.300,"Resinous and polymeric coatings" and CFR 21 , 177.2600,"Rubber articles intended for repeated use". The fully cured rubber satisfies the requirements of CFR21, 175.300 and 177.2600, sub paragraphs (e) and (f) for applications involving both aqueous and fatty foods.

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

Properties	Units	Values
Appearance		Viscous liquid
Colour A part		Pale grey
Colour B part		White
Colour Mixed		White
Viscosity (Brookfield)	mPa.s	17000
Catalysed viscosity (Brookfield)	mPa.s	15000
Pot life	Minutes	60
De-mould time	Hours	4
Approved for use with food		Yes
Properties – cured elastomer	Units	Values
Tensile strength	mPa	4.40
Elongation at break	%	600
Tear Strength	kN/m	27
Hardness	Shore A	30
Specific gravity		1.25
Min. Service Temperature	°C	-50
Max. service Temperature	°C	200

### 3. How to use

Mix both the A and B parts gently to ensure homogeneity. Place the required amount of A and B parts by weight at the ration of 10:1 (A to B) in a clean plastic or metal container of approximately 3 times their volume, and mix until the mixture is uniform. Degas by intermittent evacuation, the larger volume of the mixing vessel helps prevent overflow during this operation. In case of automatic dispensing with static mixing head, the two components should be degassed before processing. Recommended vacuum conditions are 850- 1000 mbar intermittently over 5-10 minutes. Cast the mixture either by gravity or pressure injection.

#### **Curing Conditions**

The following table offers a guide to the rate of cure of Calsil® RTV PA 30FG at various temperatures, mixing of the components between 15 and 25°C is recommended to ensure adequate pot life for degassing and handling. The pot life can be extended to several hours by chilling the components.

Temperature, °C	Max Cure Time	De-mould Time
25	24 hrs	4 hrs
100	0.5 hrs	1 hr

#### **Inhibition of Cure**

Great care must be taken when handling and mixing all addition cured silicone elastomer systems, that all the mixing tools (vessels and spatulas) are clean and constructed in materials which do not interfere with the curing mechanism. The cure of the rubber can be inhibited by the presence of compounds of nitrogen, sulphur, phosphorus and arsenic; organotin catalysts and PVC stabilizers; epoxy resin catalysts and even contact with materials containing.

### 4. 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.

### 5. Storage and Shelf Life

This product should be store in its original unopened containers at a temperature below 30°C. It can be used within the 12 months following its production date.

### 6. Packaging

Available in 5,5 kg and 20 kg.

### 7. Restrictions

This ingredient is solely proposed in the above listed applications, in contact with skin or hair. It is not suitable to be used in medical, human injection, pharmaceutical or food applications.


### 8. 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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