



Brand Calsil
Market Machinery and Equipment
Product name RTV SH1

1. Product Description

Calsil® RTV SH1 is a pourable bi-component RTV-2 silicone rubber, vulcanizing at room temperature with a poly-condensation process.

2. Key Properties

- It gives a perfect replica of the original item
- Highly resistant in all circumstances and thermo-stable
- High fluidity, fast curing and low tear strength

3. Applications

It is particularly recommended for aluminum foundries working in the footwear field. (it's recommended for limited reproductions – not in series – of simple moulds, without undercut.

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

Properties	Units	Values
Appearance		Viscous liquid
Colour		Beige
Odour		odourless
Solubility		Not mixable in water, dispersible in most of solvents
Specific gravity	g/cm ³	1.32 ± 0.02
Viscosity	mPa.s	7000 ÷ 12000

Curing Properties	Units	Values
Mix ratio		100:5
Working time	Minutes	10 ÷ 15
Setting time	Minutes	45 ÷ 60

Properties of the cross linked product:	Units	Values
Hardness 24h	Shore A	13 ± 2
Elongation	%	200 ÷ 300
Tensile strength	Mpa	1.2 ± 0.3
Tear strength	KN/m	2.5 ± 0.5
Shrinkage (after 24h)	%	0.5 ± 0.2

4. How to use

After you have homogenized the silicone rubber, weigh the required quantity, add 5% catalyst Calsil CAT N5 and mix by hand and by a mechanical mixer. To reduce air bubbles, we suggest a vacuum de-airing 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 minutes. 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. Vulcanization is influenced by temperature and moisture.

The best curing conditions are at 23°C and 50% relative humidity. The use of products at higher temperature to this, lower temperatures and lower relative humidity levels will increase pot life and setting time. If the amount of catalyst is increased from 5% to 6-7%, the curing will accelerate, but shrinkages will increase too.

It is recommended not to use the product at temperatures lower than 20°C. In these conditions, the final product performance will be difficult to achieve. We suggest to work at temperatures less than 35-40°C to avoid big shrinkages. At 23°C and 50% relative humidity, the demoulding happens after 60 minutes. The definitive properties will be reached after 24 hours.

- Other recommendations:

we recommend to clean the sample to copy from dust and dirt. If the sample is made of glass or ceramic, it's possible that the silicone rubber sticks to the model. To avoid it, we recommend to use the release agent: CALSIL® R-AG1.

For this kind of RTV-2 the thixotropic agent is not effective.

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. 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. Mixing it with a clean shaker before use

7. Packaging

CALSIL® RTV SH1 is available in drum kg 200 and pail kg 20.

CALSIL® CAT. N5 is available in can kg. 5 and bottle kg.

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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