

Tin Cure Moldmaking Silicone Rubber

1. Description

Tin cure mold making silicone rubber is a kind of liquid RTV (room temperature vulcanization) silicone rubber with two parts, part A is the silicone rubber base, part B is the curing agent. It is the flexible mold making material with different hardness from 15 shore A to 40 shore A.

2. Features

- ☆ Excellent fluidity, easy to operate
- ☆ Good tear and tensile strength
- ☆ Excellent resistance to weather, temperature, acid and alkali
- ☆ Not oily, low shrinkage
- ☆ Durable and high duplication times

3. Applications

for concrete/stone/cement/brick mold making
for plaster/gypsum/GRC/GRFC mold making
for resin/PU/bronze mold making
for casting/sculpture/figurines/statues/art mold making
for architecture/decor/furniture mold making
for wax/candle/soaps mold making
for tyre mold making

4. Parameter

Model NO.	XB-715	XB-720	XB-725	XB-730	XB-735	XB-740
Mixing Ratio (by weight)	100:3	100:3	100:3	100:3	100:3	100:3
Appearance	White	White	White	White	White	White
Hardness (Shore A)	15±2	20±2	25±2	30±2	35±2	40±2
Mixed viscosity (mPa·s)	13000±500	15000±500	16000±500	20000±500	20000±500	18000±500
Working Time (23°C/75°F)	30~40 mins	30~40 mins	30~40 mins	30~40 mins	30~40 mins	30~40 mins
Curing Time (23°C/75°F)	3~5 hrs	3~5 hrs	3~5 hrs	3~5 hrs	3~5 hrs	3~5 hrs
Tensile strength, Mpa	≥3.8	≥3.8	≥4.2	≥4.0	≥4.0	≥3.9
Tear strength, KN/m	≥19.8	≥21.5	≥28.5	≥25.2	≥19.5	≥19.5
Shrinkage, %	<0.2	<0.2	<0.2	<0.2	<0.2	<0.2
Elongation at break,%	≥500	≥500	≥550	≥480	≥480	≥300

5. Operation

Step 1 Handle the original mold

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Choose a intact original mold, then polish and smooth it to make it clean and dry. After that, fixed the original mold in a square frame made by 4 pieces of smooth wooden/glass/carton board. Brushing the release agent evenly on the surface of original mold and wooden board.

Step 2 Reclaiming

Weight part A & part B according to the mix ratio recommended exactly, eg, take 100g part A and 2g part B

Step 3 Stirring evenly

Mix and stir part A and part B evenly, otherwise the silicone rubber will be partly solidified and we don't get a nice silicone mold. Even if we got the finished mold, the demould times or the shelf life of the mold would be impacted.

Step 4 Vacuum pumping and pouring

After mixing evenly, put the mixture into the vacuum machine to release the air bubbles for 3~5mins. Then pour the mixed silicone rubber into the square frame from a corner, making the silicone rubber fill into the frame smoothly.

In this step, don't vacuum the mixture too long, saying over ten minutes, otherwise it will cause cross linking reaction then cured, and no more further steps will be available.

Generally, the less the bubble is, the better the performance of the mold would be. But It is also ok if no vacuum machine. We can release the bubbles by longer the operation time or use a brush to deal with it.

Step 5 Demoulding

After 3-5 hours later, it can be demoulded, theoretically speaking. But It's will be better to wait for 24hours to demould it and another 24hours to put the mold on production for the compete curing and reaction would maximize the performance.

6. Notice

- 1) Read the material safety data sheet(MSDS) before use.
- 2) Keep Out Of Reach Of Children.
- 3) Use only with adequate ventilation and avoid contact with eyes and skin. In case of eye and skin contact flush thoroughly with water. If irritation persists gets medical attention.

7. Package

- 1) Small size packages: 5kg/jar, 10kg/jar
- 2) General size packages: 20kg/pail, 25kg/pail, 200kg/pail

8. Transportation and Storage

- 1) Silicone rubber is non-toxic, odorless, non-flammable, noncorrosive harm, can press the non-dangerous goods and shipping

2) Shelf life would be twelve(12) months when stored under dry and cool place by original package under 25 °C well preserved.