

ANCHOR SEAL

10/13/09

Product # XP-643 RTV Silicone Molding Rubber

Features:

Platinum, addition cure
Excellent physical properties
High elongation
Moderate hardness
No shrinkage

Applications:

RTV molds
Fabricating epoxy
Polyurethane parts
Prototype parts

Mixing & Curing Instructions:

Mix Ratio: 100 Base to 10 Activator by wt.

Cure Schedule: 16-24 hours @ 77°F. or
1.5 hrs. @ 125°F. or 45 min. @ 150°F. or
25 min. @ 200°F. or 15 min. @ 200°F.

Properties @ 77°F, Uncured:

Pot Life, hours..... 1
Viscosity, B:A mixed, CPS..... 25,000
Shelf life, factory sealed cans, minimum, months..... 6

Physical Properties @77°F, Cured:

Color..... opaque light blue
Durometer, (Hardness) Shore A 40-44
Specific Gravity, cured, grams/cc..... 1.13
Tensile Strength, ASTM D-412, PSI..... 725
Tensile Elongation, ASTM D-412, % 700
Shrinkage..... nil
Service Temperature, °F..... -60 to 600
Tear Strength, ASTM D624, Die B, ppi..... 140

Electrical Properties @ 77°F, Cured:

Dielectric Strength, ASTM D149, volts/mil..... N/A
Dielectric Constant, ASTM D150, 1 KHz N/A
Dissipation Factor, ASTM D150, 1 KHz..... N/A
Volume Resistivity, ASTM D257, ohm-cm N/A

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IMPORTANT INFORMATION: READ BEFORE USING PRODUCT

Directions for Use: Because of differences in density, *pigments and fillers, when present, may separate* from the liquid components during storage. To insure product homogeneity and maximum performance, check the containers for settling. Loosen any settled pigments from the bottom of the container and ***thoroughly mix contents prior to use.*** Use a mixing stick or power mix at slow speed with a drill press and dispersion blade.

Measuring: Carefully weigh Part B and Part A components with an accurate scale. If measuring volumetrically, use precise metering pumps, graduated/pre-marked containers or pre-measured kits. Place the correct proportions of Part B and Part A into a straight-sided container. **Note:** Altering the mix ratio from what is specified on the data sheet is not recommended. Cured properties could be adversely affected.

Mixing: Mix thoroughly with a flat-ended stick or a slow speed drill press with a dispersion blade. Scrape the sides and bottom occasionally to assure a thorough blend. Do not whip excessive air into the mixture. To guard against partially cured sections, never apply material *scraped* from the sides of the original mixing container. For best results, transfer the mixture into a second container and stir it again before application. This will help insure consistent properties and maximum performance.

De-airing: Some applications require a totally air-free product. If a vacuum pump and chamber are used, evacuate the material for 10-15 minutes @ 28-29 inches of mercury. Allow sufficient space above the liquid for expansion, about four times the liquid volume. Curing under pressure, 60 psi, will compress most bubbles and promote a bubble free casting.

Curing: Platinum based, addition cure silicone rubber is sensitive to inhibition caused by chemical contamination. The product will not cure against an alkaline surface or a surface contaminated by a tin based RTV or tobacco products.

Handling Cautions: Review the Material Safety Data Sheet before using this product.

Warning: For Industrial Use Only. All chemicals must be handled with care. Avoid breathing fumes and mists, they could cause respiratory discomfort or damage. Work in a well-ventilated area. Avoid all contact with the skin. If contact occurs, wash affected area thoroughly with soap and water. Repeated skin contact may cause dermatitis in susceptible individuals. Wear protective clothing and gloves. Irritation may result if this product is splashed into the eyes. Always wear eye protection. If eye contact occurs, flood eyes with clear water for 15 minutes and immediately seek medical attention. Always maintain good industrial hygiene when using this product.

Notice To Buyer: All information contained herein is believed to be accurate. However, it is the responsibility of the end user to determine the suitability of this product in his particular application. As the use of this product by others is beyond our control no warranty whether expressed or implied is made by Anchor-Seal, Inc. or any of its representatives as to this product's merchantability or fitness for a particular purpose. Under no circumstances shall Anchor-Seal, Inc. be liable for incidental, consequential or other damages for any reason. The sole liability of Anchor-Seal, Inc. shall be to refund the purchase price or replace materials deemed to be defective by us.