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GT 1350

Silicone RTV

MoldMaking Rubber

1 November

DESCRIPTION

GT Products[®] 1350 is pourable two-component silicone rubber compound designed for making flexible molds.

GT Products[®] 1350 is recommended for repetitive production of intricate shapes cast in epoxy or urethane resins. It is also used for potting electronic components and protecting sensitive assemblies against thermal shock and vibration.

MIXING

Because fillers settle during storage, both GT Products[®] 1350 and catalyst 1350 should be thoroughly stirred before mixing together. Use separate tools for mixing the two components to avoid cross contamination. GT Products[®] 1350 base is mixed with catalyst 1350 in a 10 : 1 ratio by weight. Add the catalyst into the base to assure complete dispersion. Mixing may be done by hand with a spatula or by machine. When machine mixing avoid prolonged high speeds to prevent premature cure. Avoid stirring in an excessive amount of air. Complete mixing is indicated by a uniform red color.

TYPICAL PROPERTIES

	<u>Base</u>	<u>Catalyst</u>
Color	White	Red
Specific Gravity	1.27	1.0
Viscosity (cPs)	80,000	1,000
Mixed Viscosity		40,000
Pot Life (pour time)		1.5 hr.
After cure (24 hr @ 25°C)		
Tensile, psi:		650
Elongation, %		300
Durometer, Shore A		50
Specific Gravity:		1.25
Tear Strength, Die B, ppi		50
Useful Temperature		
Range, °C (°F)		-60 – 232 (-75 – 450)

DEGASSING

Air entrapped during mixing should be removed to prevent voids in the cured product. Dearth the mixed material under a vacuum of 25 mm (29 inches) of mercury. The mixture will expand to about four times its volume, crest and recede to about the original level as the bubbles break. Degassing is usually complete about two minutes after frothing subsides.

CURING

GT Products[®] 1350 will cure sufficiently in eight hours at room temperature (75°F) to be handled. It will reach 90% of ultimate cure in 24 hours at room temperature. For full cure an additional 1-2 days at room temperature or an elevated temperature cure is required.

Typical Cure Times

75°F	24	hr.
100°F	95	min.
200°F	5	min.

STORAGE and HANDLING

GT Products 1350 will remain useful for six months when stored in the original unopened containers at temperatures below 80°F (27°C).

COMPATIBILITY

GT Products[®] 1350 is an addition (platinum catalyst) cure system. It will cure in contact with most clean dry surfaces. Certain materials such as butyl and chlorinated rubbers, sulfur containing materials, amines and condensation (metal soap catalyst) RTV silicones can cause cure inhibition. This inhibition will manifest itself as a sticky interface with the substrate. Inhibition can often be minimized by warming the substrate to evaporate contaminants, neutralizing and rinsing, or by the use of a suitable barrier. A sample patch test is recommended.

NOTE

The above data is based on typical experience and should not be used for specification writing. Suitability of GT-Products[®] 1350 for a specific application should be determined under actual use conditions. No warranty, expressed or implied, is hereby made.

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