

GT 2240

Silicone RTV

MoldMaking Rubber

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DESCRIPTION

GT Products[®]2240 is a pourable two-component silicone rubber compound designed for making flexible molds.

GT Products[®]2240 has a low durometer, and is easily stretched off of parts. GT Products[®]2240 features a low viscosity.

GT Products[®]2240 is recommended for repetitive production of intricate shapes cast in epoxy or urethane resins. It is also used for potting electronic components protecting sensitive assemblies against thermal shock and vibration. It is also used as an optical coupling adhesive.

MIXING

GT Products[®]2240 base is mixed with catalyst 2240 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. Care must be taken to avoid contaminating unused base with the mixed material or with mixing tools that have been in contact with the catalyst.

TYPICAL PROPERTIES

Color: Base Catalyst
 Off White Light Blue

Specific Gravity Mixed: 1.12

GT2240: 24 hour RTV

Tensile Strength = 750 psi
Tear Strength = 140 pli
Hardness = 40 Shore A
Elongation = 350%
Mixed Viscosity = 85,000 cps
Pot Life = 60 – 75 min

GT2240: Heated Cure

Tensile Strength = 850 psi
Tear Strength = 150 pli
Hardness = 45 Shore A
Elongation = 350%
Mixed Viscosity = 85,000 cps
Pot Life = 60 – 75 min

Notes:

- Brookfield Viscosity was measured with spindle #6 at 5 rpm.
- Heated cure was 1 hour at 300°F. Results were the same whether the slabs were heat press cured or rtv then post cured.
- Results were the same for 24 hour rtv, 3 day rtv, and 5 day rtv.

DEGASSING

Air entrapped during mixing should be removed to prevent voids in the cured product. De-air 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[®] 2240 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 2240 will remain useful for six months when stored in the original unopened containers at temperatures below 80°F (27°C).

COMPATIBILITY

GT Products[®] 2240 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[®] 2240 for a specific application should be determined under actual use conditions. No warranty, expressed or implied, is hereby made.

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