

Mold Max® 60

Silicone

Smooth-On, Inc

Message:

Mold Max® 60 is a Shore 60A tin catalyzed silicone rubber formulated for applications requiring high heat resistance (up to 560°F/294°C). It features a low mixed viscosity and cured rubber exhibits very low linear shrinkage. Parts A & B are mixed 100A & 3B by weight. Pot life is 40 minutes and cure time is 24 hours. Applications include making foundry patterns, flat pattern reproductions and casting low-melt metal alloys such as tin and pewter. PLEASE NOTE: THI-VEX® Silicone Thickener is NOT recommended for use with Mold Max® 60.

General Information			
Features	High Heat Resistance		
	Low Shrinkage		
	Low Viscosity		
Uses	Patterns		
Appearance	Red		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D1475
Specific Volume	0.690	cm ³ /g	
Mixing Ratio	100A:3B by weight		
Operating Temperature	-54 to 293	°C	
Molding Shrinkage - Flow	0.15	%	ASTM D2566
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	60		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	2.28	MPa	ASTM D412
Tensile Strength (Break)	2.74	MPa	ASTM D412
Tensile Elongation (Break)	130	%	ASTM D412
Tear Strength ¹	11.0	kN/m	ASTM D624
Thermal	Nominal Value	Unit	Test Method
Thermal Conductivity	0.050	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	9.0E+14	ohms · cm	ASTM D257
Dielectric Strength	> 20	kV/mm	ASTM D149
Dielectric Constant (100 Hz)	3.40		ASTM D150
Dissipation Factor (100 Hz)	0.020		ASTM D150
Thermoset	Nominal Value	Unit	Test Method
Pot Life (23°C)	40	min	ASTM D2471
Thermoset Mix Viscosity	20000	cP	ASTM D2393
Demold Time ² (23°C)	1400	min	

NOTE

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| 1. | Die B |
| 2. | Cure Time |

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