

RTV-2 XP-614

Silicone Rubber, RTV-2

Silicones, Inc.

Message:

XP-614 is a fast curing, two-component addition cure silicone rubber mold making material that has a minimum working time of 40 minutes, yet can be demolded in only 3 to 4 hours. This allows the mold maker to produce both sides of a two part mold in one 8 hour shift. Parts can also be produced in the same day from a one piece mold. XP-614 also has a high durometer, minimal shrinkage and excellent chemical resistance, making it a superior choice for prototyping and casting solid polyurethane resins.

General Information			
Features	Fast Cure		
	Good Chemical Resistance		
	Low Shrinkage		
Uses	Mold Making		
	Molds/Dies/Tools		
	Prototyping		
Forms	Gel		
Processing Method	Casting		
Physical	Nominal Value	Unit	
Specific Gravity ¹	1.24	g/cm ³	
Thermoset	Nominal Value	Unit	Test Method
Thermoset Mix Viscosity	35000 to 45000	cP	ASTM D2393
Uncured Properties	Nominal Value	Unit	Test Method
Color			
-- ²	Black		
-- ³	Grey		
-- ⁴	Tan		
Viscosity			
-- ⁵	0.80 to 1.2	Pa · s	
-- ⁶	45 to 55	Pa · s	
Curing Time	4.0	hr	
Pot Life	> 40	min	
Cured Properties	Nominal Value	Unit	Test Method
Shore Hardness			
Shore A ⁷	> 34		
Shore A ⁸	50 to 60		
Shore A ⁹	55 to 65		
Tensile Strength	3.79 to 4.48	MPa	
Tensile Elongation at Break	150 to 200	%	

Tear Strength	6.13 to 9.63	kN/m
NOTE		
1.	Cured	
2.	Activator	
3.	Mixed	
4.	Base	
5.	Activator	
6.	Base	
7.	4 Hours	
8.	18 Hours	
9.	7 Days	

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