

Mold Max® XLS II

Silicone

Smooth-On, Inc

Message:

Mold Max® XLS® II is a Shore 30A tin-catalyzed silicone rubber that exhibits very low long-term shrinkage. XLS® II molds last longer than other silicones in production when casting chemically harsh resins such as epoxies and polyesters as well as urethane foams. Mix ratio is 100A:10B by weight. Pot life is 40 minutes and cure time is 24 hours at room temperature. Mold Max® XLS® II silicone will reproduce the finest detail and is suitable for a variety of industrial and art related applications including making production molds for, reproducing prototypes, furniture, sculpture and architectural elements. Mold Max® XLS® II can be thickened with THI-VEX® II additive for brush-on applications. Mold Max® XLS® II silicone can be used to cast a variety of materials including concrete, wax, gypsum, low melt alloys/metals, epoxy or polyester resins (without using a release agent) and urethane foams.

| General Information | | | |
|------------------------------|--------------------|--------------------|-------------|
| Features | Low Shrinkage | | |
| Appearance | Blue | | |
| Processing Method | Casting | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 1.22 | g/cm ³ | ASTM D1475 |
| Specific Volume | 0.820 | cm ³ /g | ASTM D1475 |
| Mixing Ratio | 100A:10B by weight | | |
| Operating Temperature | -54 to 204 | °C | |
| Molding Shrinkage - Flow | 0.10 | % | ASTM D2566 |
| Hardness | Nominal Value | Unit | Test Method |
| Durometer Hardness (Shore A) | 30 | | ASTM D2240 |
| Elastomers | Nominal Value | Unit | Test Method |
| Tensile Stress (100% Strain) | 0.655 | MPa | ASTM D412 |
| Tensile Strength (Break) | 3.79 | MPa | ASTM D412 |
| Tensile Elongation (Break) | 380 | % | ASTM D412 |
| Tear Strength ¹ | 19.3 | kN/m | ASTM D624 |
| Thermal | Nominal Value | Unit | Test Method |
| Thermal Conductivity | 0.035 | W/m/K | ASTM D1461 |
| Electrical | Nominal Value | Unit | Test Method |
| Volume Resistivity | 9.0E+15 | ohms · cm | ASTM D257 |
| Dielectric Strength | > 14 | kV/mm | ASTM D149 |
| Dielectric Constant (100 Hz) | 3.40 | | ASTM D150 |
| Dissipation Factor (100 Hz) | 2.0E-3 | | ASTM D150 |
| Thermoset | Nominal Value | Unit | Test Method |
| Pot Life (23°C) | 40 | min | ASTM D2471 |
| Thermoset Mix Viscosity | 30000 | cP | ASTM D2393 |
| Demold Time (23°C) | 1400 | min | |
| NOTE | | | |

1. Die B

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