

RTV134 Silicone

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RTV134

Operation Manual

PROCESSING RECOMMENDATIONS

PREPARATION... Safety

Use in a properly ventilated area ("room size" ventilation). To minimize contamination risk. Wear vinyl gloves only. Latex gloves will inhibit the cure of the rubber. Store and use material at room temperature (73°F/23°C). Storing material at warmer temperatures will also reduce the usable shelf life of unused material. These products have a limited shelf life and should be used as soon as possible once opened.

SUBSTRATE PREPARATION

The surface of the original should be clean and free of loose material. If necessary, and in particular with porous substrates, use a suitable release agent such as petroleum jelly or soap solution.

MEASURING & MIXING...

Before you begin, pre-mix Part B thoroughly to re-disperse pigments that may have settled. Using a gram scale, dispense required amounts of parts A and B into a mixing container and mix for 3 minutes. Scrape the sides and bottom of the container several times. After mixing parts A and B, vacuum degassing is strongly recommended to eliminate any entrapped air in pourable rubber. Vacuum material for 2-3 minutes, making sure that you leave enough room in container for product expansion.

POURING, CURING & PERFORMANCE ...

Pouring - For best results, pour your mixture in a single spot at the lowest point of the containment field. Let the rubber seek its level up and over the model. A uniform flow will help minimize entrapped air. The liquid rubber should level off at least 1/2" (1.3 cm) over the highest point of the model surface.

Curing - Allow the mold to cure overnight (at least 16 hrs) at room temperature (73°F/23°C) before demolding. Post curing the mold an additional 4 hours at 150°F (65°C) will eliminate any residual moisture and alcohol that is a byproduct of the condensation reaction that can inhibit the cure of some urethane resins and rubbers. Allow mold to cool to room temperature before using. Do not cure rubber where temperature is less than 65°F/18°C.

Mold Performance & Storage - The physical life of the mold depends on how you use it (materials cast, frequency, etc.). Casting abrasive materials such as concrete can quickly erode mold detail, while casting non-abrasive materials (wax) will not affect mold detail. Before storing, the mold should be cleaned with a soap solution and

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wiped fully dry. Two part (or more) molds should be assembled. Molds should be stored on a level surface in a cool, dry environment.

FOR YOUR INFORMATION

Silicone thickener, Thickening condensation cure silicone, For Brush-on Application –

IS-TinTHI is made especially for thickening Inno Silica's condensation cure silicone for vertical surface application (making brush-on molds). Different viscosities can be attained by varying the amount of TinTHI.

Note: Apply a thin coat of rubber. Wait for rubber to become "tacky" before applying next coat. Final mold thickness should be at least 3/8" (1 cm). Allow rubber to cure overnight before applying support shell.

Silicone thinner, Thinning Condensation cure Silicones –

Silicone Thinner is a non-reactive silicone fluid that will lower the mixed viscosity of tin cure (condensation) silicone rubber products.

Silicone Thinner offers the following advantages:

- 1, A lower mixed viscosity (A+B) means that the rubber will de-air faster when vacuuming;
- 2, Mixed rubber (A+B) will flow better over intricate model detail;
- 3, Silicone Thinner will lower the ultimate shore hardness (durometer) of cured silicone rubber;
- 4, Pot life (working time) is increased in proportion to the amount of Silicone Thinner used.

A disadvantage is that ultimate tear and tensile are reduced in proportion to the amount of Silicone Thinner added, It is not recommended to exceed 10% by weight of total system (A+B).