Technical data sheet

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SILASTIC RTV-3487/XIAMATER RTV-3087-S

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Tewipack Uhl GmbH
Industriestraße 15
D-75382 Althengstett

Telephone:
+49(0)7051/9297-0
Fax:
+49(0)7051/9297-99

E-Mail:
info@tewipack.de
Website:
www.tewipack.de

Managing director:
Alexander Uhl,
Michael Uhl
HRB 330424
Amtsgericht
Stuttgart

Bank details:
Sparkasse
Pforzheim
Calw
BLZ 666 500
85
Konto 17 787

Commerzbank
Sindelfingen
BLZ 603 400 71
Konto 8 001 166

Vereinigte
Volksbank AG
Böblingen
BLZ 603 900 00
Konto 80 089
003

Postbank
Stuttgart
BLZ 600 100
70
Konto 146
294 708

Technical Data Sheet

SILASTIC™ RTV-3487 Mold-Making Base
XIAMETER™ RTV-3087-S Mold-Making Curing Agent

High strength silicone moldmaking rubber

Features & Benefits

- Outstanding release properties
- High flowability and long working time
- Very low hardness
- Medium tear resistance
- High elasticity, for easy removal of complex replica parts
- Can be made thixotropic (non-flowable) for vertical surface replication

Applications

- SILASTIC™ RTV-3487 Mold-Making Base is suited for the detailed reproduction of figures, art objects and similar items.

Typical Properties

Specification Writers: These values are not intended for use in preparing specifications.

Property	Unit	Result
Base and curing agent mixture (100:5 by weight)		
Mixed viscosity	mPa.s	15,000
Color		White
Working time of catalyzed mixture at 23°C (73.4°F)	minutes	90–120
Curing time	hours	24
Cured for 7 days at 23°C (73.4°F)		
Hardness (Shore A)		8
Tensile strength	MPa	2.6
Elongation at break	%	650
Tear strength	kN/m	13
Relative density at 25°C (77°F)		1.15
Linear shrinkage	%	0.2–0.4

Description

SILASTIC™ RTV-3487 Base is a two-part material consisting of SILASTIC™ RTV-3487 Base, which, when mixed with XIAMETER™ RTV-3087-S Mold-Making Curing Agent, cures at room temperature by a condensation reaction.

A range of materials can be cast into the cured silicone mold: plaster, polyurethane and polyester resins are materials typically used.

Form No. 95-822-01-0320 S2D

How to Use

Surface 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.

Mixing
Thoroughly stir SILASTIC™ RTV-3487 Base before use as filler separation may occur upon prolonged storage.

Weigh 100 parts of SILASTIC™ RTV-3487 Base and 5 parts XIAMETER™ RTV-3087-S Curing Agent in a clean container. Mix together until the curing agent is completely dispersed in the base. Hand or mechanical mixing can be used, but do not mix for an extended period of time or allow the temperature to exceed 35°C (95°F). Mix suitably small quantities to ensure thorough mixing of the base and curing agent.

It is strongly recommended that entrapped air be removed in a vacuum chamber, allowing the mix to completely expand and then collapse. After a further 12 minutes under vacuum, the mix should be inspected and can be used if free of air bubbles. A volume increase of 3–5 times will occur on vacuum de-airing the mixture, so a suitably large container should be chosen.

Caution: prolonged vacuum will remove volatile components from the mix and may result in poor thick section cure and non-typical properties.

Note: If no vacuum de-airing equipment is available, air entrapment can be minimized by mixing a small quantity of base and curing agent, then using a brush, painting the original with a 1–2 mm layer. Leave at room temperature until the surface is bubble free and the layer has begun to cure. Mix a further quantity of base and curing agent and proceed as follows to produce a final mold.

Pouring the Mixture and Curing
Pour the mixed base and catalyst as soon as possible onto the original, avoiding air entrapment. The catalyzed material will cure to a flexible rubber within 24 hours at room temperature (22–24°C/ 71.6–75.2°F) according to the amount of catalyst used and the mold can then be removed. If the working temperature is significantly lower, the cure time will be longer. If the room temperature or humidity is very high, the working time of the catalyzed mixture will be reduced. The final mechanical properties of the mold will be reached within 7 days.

Additional Information

Reproduction of Vertical Surfaces
If a skin mold is required of a vertical object or surface and cannot be made by normal pouring techniques, the catalyzed mixture can be made non flowable by the addition of XIAMETER™ RTV-3011 Thixo Additive.

1. Prepare the original as described earlier.
2. Brush the original with a thin layer of catalyzed mixture. Repeat the operation when the first layer has started to cure, to achieve a coating thickness of > 2 mm. Leave to cure at room temperature until the material is tacky.
3. Prepare a new catalyzed mixture of SILASTIC™ RTV-3487 Base and add 3% by weight of XIAMETER™ RTV-3011 Thixo Additive and mix thoroughly until a paste consistency is reached. De-airing of the mixture is not required.

Additional Information (Cont.)

Reproduction of Vertical Surfaces (Cont.)

4. Using a spatula, cover the coated original with the thixotropic coating until all undercuts are filled; leave to cure for 24 hours at room temperature.
5. Construct a support mold using polyster resin or plaster and allow to set in contact with the silicone coating. Carefully remove the support mold. Peel the rubber off the original and place in the support mold.

Use at High Temperatures

Some molds produced from condensation cure silicone rubbers can degrade when exposed to temperatures above 150°C (302°F) over a period of time or when totally confined in storage at high ambient temperatures. This can result in softening and loss of elastic properties. Please contact a distributor for further advice.

Resistance to Casting Materials

The chemical resistance of fully cured SILASTIC™ RTV-3487 Base is excellent, and similar to all condensation cure silicone elastomers. It should be noted however that ultimately, resins and other aggressive casting materials will attack silicone molds, changing physical properties, surface release and possibly mold dimensions. Molds should be checked periodically during long production runs.

Note: SILASTIC™ RTV-3487 Base is an industrial product and must not be used in food molding, dental and human skin molding applications.

Handling Precautions

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE ON THE DOW WEBSITE AT DOW.COM, OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.

Usable Life and Storage

Product should be stored at or below 32°C (89.6°F) in original, unopened containers.

When stored below 20°C (68°F), XIAMETER™ RTV-3011 Thixo Additive may solidify. The product can be easily liquefied by immersing the closed container in warm water.

Limitations

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

Not intended for human injection. Not intended for food use.

Health and Environmental Information

To support customers in their product safety needs, Dow has an extensive Product Stewardship organization and a team of product safety and regulatory compliance specialists available in each area.

For further information, please see our website, dow.com or consult your local Dow representative.

Disposal Considerations

Dispose in accordance with all local, state (provincial) and federal regulations. Empty containers may contain hazardous residues. This material and its container must be disposed in a safe and legal manner.

It is the user's responsibility to verify that treatment and disposal procedures comply with local, state (provincial) and federal regulations. Contact your Dow Technical Representative for more information.

Product Stewardship

Dow has a fundamental concern for all who make, distribute, and use its products, and for the environment in which we live. This concern is the basis for our product stewardship philosophy by which we assess the safety, health, and environmental information on our products and then take appropriate steps to protect employee and public health and our environment. The success of our product stewardship program rests with each and every individual involved with Dow products - from the initial concept and research, to manufacture, use, sale, disposal, and recycle of each product.

Customer Notice

Dow strongly encourages its customers to review both their manufacturing processes and their applications of Dow products from the standpoint of human health and environmental quality to ensure that Dow products are not used in ways for which they are not intended or tested. Dow personnel are available to answer your questions and to provide reasonable technical support. Dow product literature, including safety data sheets, should be consulted prior to use of Dow products. Current safety data sheets are available from Dow.

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