SILPAK R-2128, R-2138, R-2157 – BASES & ACTIVATORS

High Strength, Low Viscosity, Platinum Cured, Silicone Rubber

R-2128, R-2138 and R-2157 Bases & Activators are Platinum Cured (Addition Cure), two-component, room temperature curing (RTV) silicone rubbers designed for general mold making. These systems are low in viscosity and exhibit high Physical profiles. Use molds to cast polyester, urethane, epoxy, low melt metal (600F), thermoplastics (Polyvinyl), wax, soap, plaster, and any material where a release free casting is required.

Features

- Two-part, platinum-cured silicone rubber
- Room temperature curing (RTV)
- Release agents not required

Applications

- Casting Pressure Pads
- Use as an advanced composite tooling rubber

Use Molds to Cast:

- Polyester
- Urethane
- Epoxy
- Low melt metal (600F)
- Thermoplastics (Polyvinyl)
- Wax, Soap, Plaster

Physical and Handling Properties

Property	R-2128 A/B	R-2138 A/B	R-2157 A/B
Color, Base/Activator	Gray	Light Purple	Light Green
Mix Ratio, by weight	10A : 1B	10A : 1B	10A : 1B
Initial Mixed Viscosity, at 77°F, cP	6,000	10,000	20,000
Hardness, Shore A	25	42	50
Specific Gravity	1.24	1.29	1.32
Tensile Strength, psi	695	750	650
Elongation, %	350	350	300
Tear Strength(pli)	100	125	102

Values listed above are typical and not intended for use in specifications.

Mixing & Curing Instructions

Mix Base and Activator just before using. Mix 10 parts Base to 1 part Activator by weight. Automatic mixing equipment or manual mixing may be used to combine base and curing agent. Immediately after mixing, place the material in a vacuum chamber to remove entrapped air. As vacuum is drawn, the material will expand as much as four times its original volume. Remove from vacuum chamber and pour very gently, so as not to incorporate air into the material. Cure can be accelerated with mild heat, 150F @ 1 hour per inch thick. Note: This product was designed for high knotty tear and low viscosity, therefore, use an accurate gram scale to measure the activator and base by weight. Mix ratio is critical and should not be modified or there will be a detriment to cure properties.

Cure Inhibition

Certain materials will cause inhibition or neutralizing of the curing agent. These materials are sulfur and organo-metallic salt containing compounds found in organic rubbers and many condensation cure RTVs, chloride solvents and amines. Avoid using latex gloves, water-based clays and Tin/Condensation cured RTVs. Inhibition may easily be determined by brushing a small quantity of this material over the surface and allowing it to cure. If material remains tacky and gummy after the curing time, then the part's surface acts as an inhibitor. ****See Addition Cure Technical Data Sheet for inhibiting materials**

Proper Use and Safety

Read all instructions and safety data sheets prior to use. Consult safety data sheets for all recommended safety precautions.

Storage & Shelf Life

Base and Activator must be stored in their original, tightly closed containers to protect from moisture and foreign materials. Storage area should be maintained at temperatures between 60-90°F. Shelf life of materials when kept in unopened, sealed containers, at the recommended storage conditions, is six months.