



SILPAK R-2234 A/B, R-2264 A/B, R-2364 A/B

Platinum Base, RTV and Heat Cured, Silicone Rubber

Silpak R-2234 A/B, R-2264 A/B, R-2364 A/B Platinum Base (Addition Cure), two-component, room temperature curing (RTV) silicones rubbers designed for mold making, embedding, electrical applications, and thermal expanding tools. The controlled coefficient of thermal expansion makes these RTVs ideal for casting pressure pads and for use as an advanced composite tooling rubber. Use molds to cast polyester, urethane, epoxy, thermoplastics (Polyvinyl), wax, soap, plaster, and any material where a release free casting is required.

Features

- Two-part, platinum-cured silicone rubber
- Controlled coefficient of thermal expansion
- 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
 - Thermoplastics (Polyvinyl)
 - Wax, Soap, Plaster

Physical and Handling Properties

Property	R-2234 A/B	R-2264 A/B	R-2364 A/B
Color, Mixed	Blue	Blue	Blue
Mix Ratio, by weight	10A : 1B	10A : 1B	10A : 1B
Initial Mixed Viscosity, at 77°F, cP	32,000	70,000	90,000
Thermal Conductivity BTU-FT	5.2×10^{-4}	8.11×10^{-4}	8×10^{-4}
Hardness, Shore A	37 (+/-2)	50	65
Specific Gravity	1.08	1.25	1.28
Tensile Strength, psi	525	550	650
Elongation, %	440	300	250
Tear Strength(pli)	90	80	110
Coefficient of Thermal Expansion (cm/cm/c)	3.18×10^{-4}	3×10^{-4}	3×10^{-4}

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

Mixing & Curing Instructions

Mix Part A and Part B just before using. Mix 10 parts A to 1 part B 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 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 RTV, chloride solvents – 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**

Curing Chart

Temperature	Pot Life	Cure Time
100°F	30 min	2 hours
150°F	10 min	30 min
300°F	-----	5 min

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

Part A and B 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. Containers should not be opened until ready or use. Once opened, storage life can be extended with the use of purging gas, such as nitrogen.

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