

# SILPAK R-1348 A / R-1332 B

## Tin Silicone RTV

**R-1348 A/ R-1332 B—35 A Shore** is a Tin Base (Condensation Cure), two-component, room temperature cure (RTV) rubber designed for general purpose applications where a low shrink, durable rubber mold or part is required—35 A Shore.

### Features

- Excellent physical properties with high tear resistance
- User friendly and trouble-free cure
- Good Polyester and Urethane Resin resistance

### Applications

Consistent curing characteristics, excellent shelf life, and outstanding physical properties make this a product that can easily meet a wide variety of applications, including any material where a release free casting is required.

- Foam
- Urethane
- Low melt metal (350F)
- Polyester
- Epoxy
- Thermoplastics (Polyvinyl)
- Wax
- Soap
- Plaster

### Physical Properties (Typical Values)

#### Unvulcanized

| Property             | Value                 |
|----------------------|-----------------------|
| Color                | Off-White A / Black B |
| Viscosity @77°F, cps | 32,000, mixed         |
| Shelf Life           | 6 months              |

#### Cured Rubber

| Property              | Value      |
|-----------------------|------------|
| Specific Gravity      | 1.14       |
| Hardness              | 35 A Shore |
| Tear Resistance, pli  | 110        |
| Mix Ratio             | 100A / 10B |
| Tensile Strength, psi | 500        |
| Elongation 5          | 420        |

## Mixing and Curing

Process part A by adding the curing agent B. **Part B should be shaken prior to use.** The addition of 10% catalyst (by weight) has a pot life of 45 minutes and is ready for demolding after 10-12 hours. R-1332 B has a trace of pigment for good dispersion. De-airing (degassing) material is always recommended. Immediately after mixing, place the material in a vacuum chamber to remove trapped air and allow enough room for expansion as vacuum is drawn, as much as four times its original volume. Remove from vacuum chamber and pour very gently into cavity so as not to re-incorporate air into the material. After the mold has been removed from the master, it should be left for 24 hours in order to develop its maximum mechanical strength. \*\*Mechanical properties are dependent on the catalyst level.

### Brush-On

Use **R-1300<sup>TH</sup> B** to create brush-on, low sag rubber bladders—20min Gel Time. **PE-Mini Fibers** powdered filler is also available for creating thick, spreadable paste-like consistencies.

## Storage and Shelf Life

A and B components must be stored in their original, unopened containers at temperatures between 60-90°F. Shelf life of materials when kept in unopened, sealed containers, at the recommended storage conditions, is 6 months.

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