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Set-Sil 8000

Set-Sil 8000 is an extremely high tear, high tensile strength, two-component, tin catalyzed RTV silicone rubber. It is designed for casting polyurethane foam, polyester and epoxy parts. **Set-Sil 8000** is a good electrical insulator where high mechanical stresses are involved. It is a superior product with the following advantages over other RTV silicones:

Extremely high tear strength - **Set-Sil 8000** is especially good for molds with deep undercuts and for those molds which require flexing for part removal.

Low shrinkage - **Set-Sil 8000** offers exceptional reproduction capability. It is particularly valuable in the production of many-sided molds where exact registrations are required.

Excellent chemical resistance - **Set-Sil 8000** exhibits extremely long mold life due to unique processing techniques that were developed to meet the rigors of polyester and polyurethane casting.

Excellent shelf aging - **Set-Sil 8000** retains its dimensional stability and resists embrittlement on aging.

Low Viscosity - The low viscosity of **Set-Sil 8000** allows for easy mixing and de-airing, ensuring smooth, even flow.

Color-coded catalyst - The blue **Set-Sil 8000** activator ensures homogeneous mixing and eliminates mold loss resulting from inadequate stirring.

Long pot life - **Set-Sil 8000** gives good overnight cure despite having a working time of two hours. In addition, it is relatively insensitive to temperature and humidity fluctuations.

Variable cure rate - Several activators are available for special or unusual applications.

Insensitive to inhibition - **Set-Sil 8000** is not inhibited by most common mold-making substrates, eliminating the need to use mold sealers.

Good dielectric properties - **Set-Sil 8000** provides excellent electrical insulating characteristics over a wide temperature range and is especially suitable for applications where mechanical stresses are involved.

Low cost - **Set-Sil 8000** has a low specific gravity which means less of it is required than RTVs with a higher specific gravity. When the long mold life is combined with the low specific gravity, **Set-Sil 8000** is a cost effective, high performance RTV silicone rubber.

APPLICATIONS

Set-Sil 8000 is recommended for casting polyesters and polyurethanes. It is also excellent for casting waxes, gypsum, concrete, epoxies and other plastics.

SEE BACK OF TECHNICAL DATA SHEET FOR WARRANTY.

TYPICAL PROPERTIES

<u>Uncatalyzed Properties</u>	<u>Base</u>	<u>Activator</u>
Color	White	Blue
Viscosity (cps)	50,000-70,000	300-400
Specific Gravity	1.10	.99
Working Time (hours)	1.5 to 2.5	
Cure Time (hours)	16 to 18	
Shelf Life (hours)	6	

Cured Rubber (7 days @ 70° F & 50% R.H.)

Hardness, Shore A	32 ± 4
Tensile Strength (psi)	525 ± 25
Elongation (%)	300 ± 25
Tear, Resistance (ppi)	120 ± 10
Shrinkage (%)	0.1
Specific Gravity	1.09
Dielectric Strength (volts/mil)	500
Dielectric Constant @ 100Hz	3.3
Dissipation Factor @ 100Hz	0.019
Volume Resistivity (ohms/cm)	1 x 10 ¹⁵

MIXING INSTRUCTIONS

Mix 100 parts by weight of **Set-Sil 8000** base with 10 parts by weight of **Set-Sil 8000** activator in a container that will hold approximately three times the volume being used. Stir thoroughly either by hand or by mechanical mixing until a uniform light blue color results. Immediately after mixing, place the material in a vacuum chamber capable of 28 inches of mercury vacuum. The material will expand to double or triple its original volume and then collapse. Maintain vacuum for an additional minute and release. Carefully pour the catalyzed silicone rubber over the released pattern and cure for 16 to 18 hours.

Warranty

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