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## Set-Sil 8040

**Set-Sil 8040** is a condensation cure RTV-2 Silicone Rubber with a Shore A hardness of 40, making it well suited for the rigors of casting polyurethane foam parts. It has high tear and tensile strength with moderate elongation. This combination of high hardness and tear helps to eliminate any distortion due to expansion of the polyurethane foam. **Set-Sil 8040** is also excellent for casting non-rising urethanes, polyesters and epoxies where a free standing mold that can maintain a straight edge is desired.

**High Shore A Durometer** Allows for little or no distortion.

**High Tear and Tensile** These properties combined with moderate elongation allow for the production of parts that until now had to be made from more expensive, harder to use Platinum catalyzed addition cure products.

**Excellent Chemical Resistance** - **Set-Sil 8040** exhibits long mold life.

**Color Coded Catalyst** - The **Set-Sil 8040** Activator is blue and is used in a convenient 10:1 ratio by weight.

**Low Cost** - **Set-Sil 8040** has a low specific gravity (density) compared to many RTV's used for foam casting. This means your mold weighs less and costs less.

### SUGGESTED APPLICATIONS

**Set-Sil 8040** is recommended for casting any type of plastic or gypsum product where higher hardness will minimize mold distortion caused by expansion pressure (foam), weight (highly filled resins, gypsum or ceramics) or operator carelessness.

### TYPICAL PROPERTIES

<u>Uncatalyzed Compound</u>	<u>Base</u>	<u>Catalyst</u>
Color	Off White	Blue
Viscosity, cps	90,000-110,000	350
Specific Gravity	1.12	.99
Working Time, hours	1.5 to 2.5	
Cure Time, hours	16 to 18 for demold 24 hours for 30 Shore A	
Shelf Life, months	6	

**SEE BACK OF TECHNICAL DATA SHEET FOR WARRANTY.**

**Cured Rubber (7 days @ 77 deg. F. & 50% R.H.)**

Hardness, Shore A	40 ± 2
Tensile strength, psi (ASTM D412)	525 ± 50 psi
% Elongation (ASTM D412)	225 ± 30%
Tear Resistance, ppi (ASTM D624)	100 ± 15
% Shrinkage	0.2%

**MIXING INSTRUCTIONS**

Mix in a ratio of 10 parts Base to one part Activator by weight. Stir thoroughly either by hand or by mechanical mixing until a uniform color results. Deaerate in a vacuum chamber at a minimum of 28 inches of mercury vacuum until material rises to approximately double the volume, then collapses. Carefully pour over the pattern, and allow to cure for 16 to 18 hours.

**Warranty**

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