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Set-Sil 850 SILICONE RUBBER

Set-Sil 850 is a two component addition cure silicone rubber mold making material. It has a high durometer, superb physical properties, minimal shrinkage and extreme chemical resistance making it an excellent choice for prototyping, casting urethane foam and other plastics. **Set-Sil 850** cures at room temperature in 18-24 hours; however, the curing rate can be accelerated with Pt Accelerator at room temperature or with heat.

MIXING INSTRUCTIONS

Mix 10 parts by weight of **Set-Sil 850** Base with 1 part by weight of **Set-Sil 850** Activator in a container that will hold about three times the volume of the rubber being mixed. Stir thoroughly either by hand or by mechanical means until a uniform green color is achieved. Immediately after mixing, place the container in a vacuum chamber capable of 28 inches of mercury vacuum. The rubber will expand to double or triple its original volume as it is being deaired. After the rubber collapses, maintain the vacuum for an additional two minutes and then release. Carefully pour the catalyzed silicone rubber over the released pattern.

TYPICAL PROPERTIES

Color, Base	Tan
Color, Activator	Green
Base viscosity (cps)	120,000 to 140,000
Activator viscosity (cps)	1000 to 1500
Working Time (hrs)	1 to 2
Cure Time (hrs)	18 to 24
Specific Gravity, cured rubber	1.30
Shore A Hardness	
24 hours @ 70° F/50% R.H.	54 ± 4
+ 2 hours @ 250° F	58 ± 4
Tear Resistance (ppi)	70 ± 10
Tensile Strength (psi)	750 ± 50
Elongation (%)	200 ± 25
Shrinkage (%)	nil

Warranty

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