



53 C Otis Street
West Babylon, NY 11704
Tel. 631-920-5079 Fax. 631-920-0503
E-mail SalesSET@optonline.net
www.SET-mfg.com

Set-Sil 860 SILICONE RUBBER

Set-Sil 860 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 860** 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 860** Base with 1 part by weight of **Set-Sil 860** 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 blue 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	Blue
Base viscosity (cps)	130,000-150,000
Activator viscosity (cps)	7500 - 8500
Working Time (hrs)	1 to 2
Cure Time (hrs)	18 to 24
Specific Gravity, cured rubber	1.24
Shore A Hardness	
24 hours @ 70° F/50% R.H.	62 ± 3
+ 2 hours @ 250° F	68 ± 3
Tear Resistance (ppi)	70 ± 10
Tensile Strength (psi)	900 ± 50
Elongation (%)	200 ± 25
Shrinkage (%)	nil

Warranty

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Silicone & Epoxy Technology

Phone: 631-920-5079 Fax: 631-920-0503
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