

# SILPAK, Inc

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## Fast Curing Silicone RTV

### R-1328 A / 1324 B

#### Product Data Sheet

**R-1328 A / R-1324 B—28 A Shore** Tin Base (Condensation Cure), two-component, room temperature cure (RTV) rubber designed primarily for faster demold—6 to 8 hours. It is used as a general purpose, high strength rubber for making multi-part molds, flexible rubber parts, and for print coat (detail coat) applications when making brush-on molds. Molds are used to cast polyester, urethane, epoxy, low melt metal (350F), thermoplastics (Polyvinyl), wax, soap, plaster, and any material where a release free casting is required.

**Available Sizes:** Pint Kit (1 lb) & Quart Kit (2 lb) Gal Kit (9 lb) & 5 Gal Kit (44 lbs) 55 Gallon Drum (495 lbs)

#### Product Features:

- 1) Excellent Physical Properties with High Tear Resistance
- 2) Low Viscosity and greater flow control for Brush-On molds
- 3) Produces mold with a Long Working Life
- 4) Fast Cure 6-8 hours for quick multi-part mold fabrication

#### PHYSICAL PROPERTIES (TYPICAL VALUES) UNVULCANIZED

Color: Off-white A / Blue B

Viscosity @ 25C: 25,000 cps mixed

Shelf Life: 6 months in closed container

#### TYPICAL PROPERTIES OF CURED RUBBER

Specific Gravity: 1.18  
Hardness: 28-30 A Shore  
Tensile Strength: 550 psi  
Elongation at Break %: 500  
Tear Resistance: 110 pli

#### MIXING & CURING INSTRUCTIONS:

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 40 minutes and is ready for demolding after 15 to 24 hours. R-1324 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.

#### Brush-On

Use **R-1300™ B** to create brush-on, low sag rubber bladders—35min Gel Time. **PE-Mini Fibers** powdered filler is also available for creating thick, spreadable paste-like consistencies.

#### Faster Cure

To speed cure, add R-1324 B @ 12% for a 3-4 hour demold time (15% for 2-2.5 hour demold time) or use **Rapid Set** at 10 drops/lb for a 1 hour cure. **Note:** Curing a mold quickly with extra catalyst or rapid set will decrease over all storage shelf life of molds and affect mold rubber properties.

#### STORAGE/SHELF LIFE:

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

THE INFORMATION AND DATA CONTAINED HEREIN ARE BASED ON INFORMATION WE BELIEVE RELIABLE. EACH USER OF THE MATERIAL SHOULD THOROUGHLY TEST ANY APPLICATION AND INDEPENDENTLY CONCLUDE SATISFACTORY PERFORMANCE BEFORE COMMERCIALIZING. SUGGESTIONS OF USES SHOULD NOT BE TAKEN AS INDUCEMENTS TO INFRINGE ON ANY PARTICULAR PATENT.