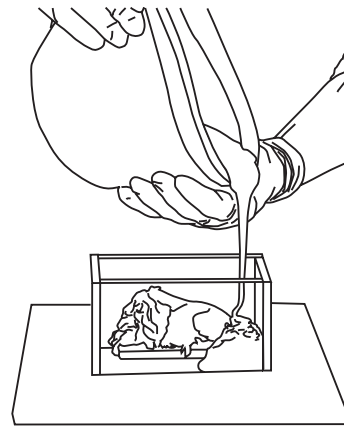


# PRODUCT BULLETIN **7B**

## TAP SILICONE RTV SYSTEM

The most versatile moldmaking system available

### How to use TAP Silicone RTV System



#### WARNING

TAP Silicone RTV System contains only constituents that over many years have proved to be neither toxic nor aggressive. Catalyst may cause irritation upon eye contact. Follow all instructions for safe use. KEEP OUT OF REACH OF CHILDREN.

Keep Side A and Side B containers tightly closed when not in use to prevent reaction with moisture in air. TAP Silicone RTV System (Side A) shelf life is 6 months in original unopened containers when stored at 75° F. TAP Silicone RTV Catalyst (Side B – Blue) shelf life is 6 months in original unopened containers when stored at 75° F.

MSDS available at [tapplastics.com](http://tapplastics.com)

#### WARRANTY

TAP Products are manufactured to quality specifications, however they should be tested to determine their suitability for your application. Since we have no control over working conditions or methods, our liability does not exceed the value or replacement of this product. TAP Resin products are guaranteed for six months from date of purchase or nine months from code date on container.

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#### Why use TAP SILICONE RTV SYSTEM?

- Suitable for making: poured block molds, multipart molds and brush-on molds
- 28 Shore A – flexible – good dimensional stability
- Good elongation and tear strength
- Low linear shrinkage
- Excellent long term retention of rubber properties
- Color contrast to visually ensure thorough mixing
- Thinner Additive for detailed skin coats
- Thixotropic Additive for brush on molds
- Cast parts that can be painted immediately
- Fast catalyst for mold cure of 4-6 hours

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**TAP Silicone RTV System** is a complete mold making system that can be used to make virtually any type of mold. **TAP Silicone RTV** is a two component, tin catalyzed, room temperature cured silicone rubber. It is designed as a 28 Shore A mold rubber – meaning it is flexible, has good dimensional stability, and good elongation and tear strength. It has very low shrinkage, excellent long-term retention of rubber properties and accurate detail reproduction. It is excellent for casting cement, vinyl, wax, plaster, low-melt metals, urethane resins, epoxy resins and polyester resins. It is a safe product to use when directions are followed fully.

#### SYSTEM COMPONENTS

**Side A (Base Component)** is an off-white liquid with medium viscosity of 29,000 cps. Since this is a tin or condensation cure system, inhibition is not common. The clay TAP carries will not affect the cure. Testing should always be done if there is any uncertainty.

**Side B (Blue Catalyst)** has a 4-6 hour de-mold time, allowing two-part molds to be completed in one day with no loss in mold properties. Mixing ratio is 10 parts side A to 1 part side B by weight, or 9-to-1 by volume. Catalyst should be shaken prior to measuring.

**Silicone Thinner** is a clear silicone fluid that can be added to reduce the viscosity of Silicone RTV. Ideal for creating a bubble free skin coat prior to adding a thick coat. Use no more than 10 parts of thinner to 100 parts of silicone by weight. The thinner will increase working time and decrease final hardness and tear strength.

**Thixotropic Additive** increases the viscosity of silicone from a slow flowing liquid up to a 'peanut butter' consistency paste. Recommended mix ratio is .5%-5% by weight, depending on the viscosity desired. Adding more than 5% will degrade the mold quality. The additive allows the silicone to be brushed on vertical surfaces and to be used for glove molds. The Thixotropic Additive does not change cure time.

#### PHYSICAL PROPERTIES

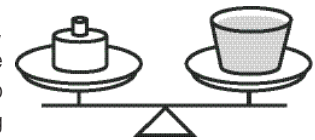
Mixed Ratio 10 parts Side A to 1 part Side B by weight or 9-to-1 by volume.

<b>Specific Gravity</b>	1.16
<b>Color (mixed)</b>	Blue
<b>Hardness</b>	Shore A 25-30
<b>Working Time</b>	30 to 40 minutes
<b>De-mold</b>	4 to 6 hours
<b>Viscosity (mixed)</b>	24,000 cps
<b>Tensile Strength</b>	600 psi
<b>Tear Resistance</b>	125 ppi
<b>Linear Shrinkage</b>	4 days <.4%
<b>Coverage</b>	approx 23 cu. in./lb. or 12.5 fl. oz/lb.
<b>Temperature Range</b>	-50° to 150°C (-58 to 302)°F

#### MIXING

**Accurate measuring** (fig. 1) is essential. Inaccurate measuring causes changes in the physical properties of the cured material. While a 10% ratio by weight of catalyst is ideal, the silicone will tolerate an 8-13% range.

**Thorough mixing** is also essential. Mix components by hand or with mixer (electric drill fitted with paint paddle attachment or similar) until color is uniform (no white or streaks). The most common cause of incomplete cure and mold failure is improper mixing. If you are using a TAP measuring container, look through the side and bottom of the cup to make sure mixing has removed all white streaks from the container.



#### RELEASES

One of the great advantages of Silicone RTV is that it seldom needs a mold release. This not only eliminates steps in the mold making process, it also means parts are paintable directly from the mold without further

