

JIT SILICONES +

Moldmaking Rubber 45W

100% SILICONE

- Primary Use:
 - Reproductions & Molding
 - General Purpose moldmaking, medium durometer, low viscosity, easy to work with, fills tiny crevices. Vacuum de-airing not required
- Addition Cure System
- White Color



Standard Package Sizes & Part Numbers:

Base Rubber/Size	Catalyst/Size	NOTE
70098/453g	70098S/45g 70098F/45g	10:1 mix ratio 10:1 mix ratio
70099/4kg	70099S/409g 70099F/45g	10:1 mix ratio 10:1 mix ratio
70100/18.1kg	70100S/1.8kg *70100F/45g (*4 required)	10:1 mix ratio 10:1 mix ratio
70102/181kg	70102S/18.1kg	10:1 mix ratio

JIT Silicones +

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Available from:

Moldmaking Rubber - 45W

rev. 08-2016

Technical Data

JIT **Moldmaking Rubber 45W** is a two-component material that cures to a rubbery solid once mixed with the Catalyst in the appropriate ratio. This material is designed to perform at temperatures from -75°F (-60°C) to 350°F (177°C), & intermittently to 400°F (204°C).

HOW TO USE:

1. Open both containers -- **thoroughly stir the base as filler separation may occur upon prolonged standing.** Weigh the base and appropriate catalyst into a clean container, mix together until the catalyst is completely dispersed in the base.

Hand or mechanical mixing can be used, but do not mix for an extended period of time or allow the temperature to exceed 35°C. Keep in mind working time based on catalyst & ratio being used. **Please note that precise weight needs to be used to ensure proper cure. A calibrated digital scale is suggested.**

2. Pouring the mixture: Pour the mixed base and catalyst as soon as possible onto the original, avoiding air entrapment. The catalyzed material will cure to a flexible rubber and the mold can then be removed (see table of typical properties for details). If the working temperature is significantly lower than 23°C (73.4°F), the cure time will be longer. If the room temperature or humidity is very high, the working time of the catalyzed mixture will be reduced. The final mechanical properties will be reached within 7 days.

Typical Properties - As Supplied

Test	Unit	Result	Method
Color		White	visual
Spec Gravity		1.14	CTM
Viscosity	poise	130	CTM

Cure Characteristics

Base Rubber/Catalyst	Base/Catalyst mix ratio by weight	Approximate working time	Approximate demold time
45W/Slow Catalyst	10:1	2hrs	7hrs
45W/Slow Catalyst	20:1	3hrs	12hrs
45W/Fast Catalyst	10:1	10minutes	30minutes
45W/Fast Catalyst	20:1	40minutes	80minutes

Typical Properties - As Cured

Test	Unit	Result	Method
Durometer, Shore A	points	45	ASTM D2240
Tensile at Break	psi	395	ASTM D412
Elongation at Break	%	170	ASTM D412
Dielectric Constant	@25C, 100Hz	3.26	ASTM D150
Dielectric Strength	Volts/mil	456	ASTM D149
Dissipation Factor	@25C, 100Hz	0.0056	ASTM D150
Volume Resistivity	ohm-cm	5.68E+14	ASTM D257

Usable Life & Storage

When stored at or below 32°C (89.6°F), the base has a minimum usable life of 18 months from date of production, the catalyst has a 12 month shelf life.

Handling Precautions - See SDS Sheet

Limited Warranty - Please Read Carefully

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