



Technical Date Sheet food grade silicone

DESCRIPTION

Medical RTV2 is a two-part silicone rubber that is addition cure or platinum cure type. Its common use is mold making. mixing ratio is 1 to 1 and room temperature cure and also can be cured under the heat. This product is a food grade with United States FDA certification.

PROPERTIES

- * Good fluidity and operability, easy to demold
- * Aging resistance
- * High temperature resistance (220°C-250°C)
- * Environmentally, food-grade, FDA Certification
- * Good tensile and tear strength
- * Easy bubble releasing
- * Low shrinkage
- * No deformation

Application Areas/Suggested Uses

- * Molds for concrete stone
- * GRC
- * Polyurethane products
- * Wax
- * Candles
- * Rapid prototyping
- * Tire molds
- * Chocolate
- * Candies and similar products



Mixed Physical Properties:

Color		Transparent
Pot life (mins)	at 25°C	30-40
Curing time		3-5hrs (under 25°C) 20-30 mins(under 60°C)
Tensile strength (MPA)		> 6
Tear strength		>28
Shrinkage rate		< 0.1 %
Viscosity (mPa.s)	at 25°C	3200±500
Hardness (Shore)	at 25°C	25±2
Mix ration(per)	by weight	1:1
Elongation		> 680%

Processing/How to use General Information

Step 1: prepare the original molds

Prepare a perfect mold and clean it thoroughly.

*Notes: Make sure your original molds and operating tools are cleaned to avoid problems during the process.

Step 2: Take 100 G part A and 100 G part B and mix them evenly.

*Notes: Mixing the two parts is very critical, please follow these steps strictly:

1.Measure the two parts exactly by a digital scale. Making mistakes in weighting, cause many problems.

2.both parts should be equal. Otherwise, the silicon rubber will be partly solidified, resulting silicone rubber to go to waste.

Step 3: Vacuum pumping

Without any exceptions, this step takes less than 10 minutes. Otherwise, it will cause cross linking reaction, and no more further steps will be available.

Step 4: Pouring the cast or Brush operation

*Notes: 1. For simple pattern products, we suggest pouring operation method, which will be very easy to operate and demold. Pourable silicone requires low viscosity which will be easy to flow smoothly



and easy to de-air.

2. For delicate pattern products we suggest using the brushing operation way, which can copy the pattern exactly. Brush able silicone require high viscosity which won't be easy to flow away and will be easy to brush.

3. We suggest to set the silicone mold for another 12 hours after demolding before you put it into a large production. Warm Tips:

As addition cure silicone is a kind of platinum cure system, which will be easy to cause uncured problem, so please kindly follow the following tips:

- * Do not mix with liquid condensation silicone rubber or even the tool which used for such materials.
- * Do not mix with organic materials containing N, S, P organics and ionic compound like Sn, As, Hg, Ph. (Do not smoke when you use this addition silicone rubber)
- * Do not add any pigment, powder or any other additives to the silicone rubber without testing to prevent uncured problem.

Package

1:1 mix ratio: 20KG/drum + 20KG/drum with vacuum packing;

Shelf time

200KG/drum + 20KG/drum with vacuum packing

Twelve (12) months if stored in dry and cool place by original package under 2°C