

XIAMETER[®] HS II Base and XIAMETER[®] RTV-3081 Curing Agent

High strength silicone moldmaking rubber

FEATURES

- Outstanding release properties
- High flowability and long working time
- Medium hardness
- High tear resistance
- High elasticity, for easy removal of complex replica parts
- Can be made thixotropic (non-flowable) for vertical surface replication
- Choice of curing agents for special applications

APPLICATIONS

- XIAMETER[®] HS II Base and XIAMETER[®] RTV-3081 Curing Agent is suited for the detailed reproduction of figures, art objects and similar items.

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local XIAMETER[®] sales representative prior to writing specifications on this product.

Base and Curing Agent mixture (20:1 by weight)

Color	Off-White
Relative density at 25°C (77°F) of cured rubber	1.21

XIAMETER [®] Curing Agents:	3081	3081-F	3081-VF	3081- R
	Standard	Fast	Very fast	Resin resistant
Working time of catalyzed mixture at 23°C (73.4°F), minutes, min.	90-120	30-45	8-10	90-120
Mixed viscosity, cps	20,000	22,100	36,400	20,000
Cured for 2 days at 23°C (73.4°F)				
Hardness, (Shore A)	24	23	25	19
Tensile strength, psi	682	667	595	667
Elongation at break, %	544	543	438	622
Tear strength, pli	148	137	143	148
Linear shrinkage, %	0.2-0.4	0.2-0.4	0.2-0.4	0.2-0.4
Curing time, hours, max	24	6	2	24

DESCRIPTION

XIAMETER HS II Base and XIAMETER RTV-3081 Curing Agent is a two-component material consisting of XIAMETER HS II Base which when mixed with a XIAMETER RTV-3081 Curing Agent cures at room temperature by a condensation reaction. A range of materials can be cast into the cured silicone mold: plaster, polyurethane and polyester resins are materials typically used.

HOW TO USE

Substrate preparation

The surface of the original should be clean and free of loose material. If necessary, and in particular with porous substrates, use a suitable release agent such as petroleum jelly or soap solution.

Mixing

Thoroughly stir XIAMETER HS II Base before use, as filler separation may occur upon prolonged storage.

Weigh 20 parts of XIAMETER HS II Base and 1 part of XIAMETER RTV-3081 Curing Agent in a clean container. Mix together until the curing agent 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 (95°F). Mix suitably small quantities to ensure thorough mixing of base and curing agent.

It is strongly recommended that entrapped air be removed in a vacuum chamber, allowing the mix to completely expand and then collapse. After a further 1-2 minutes under vacuum, the mix should be inspected and can be used if free of air bubbles. A volume increase of 3-5 times will occur on vacuum de-airing the mixture, so a suitably large container should be chosen.

Caution: prolonged vacuum will remove volatile components from the mix and may result in poor thick section cure and non-typical properties.

Note: If no vacuum de-airing equipment is available, air entrapment can be minimized by mixing a small quantity of XIAMETER HS II Base and a XIAMETER RTV-3081 Curing Agent, then using a brush, painting the original with a 1-2mm layer. Leave at room temperature until the surface is bubble free and the layer has begun to cure. Mix a further quantity of base and curing agent and proceed as follows to produce a final mold.

Pouring the mixture and curing

Pour the mixed XIAMETER HS II Base and XIAMETER RTV-3081 Curing Agent as soon as

possible onto the original, avoiding air entrapment. The catalyzed material will cure to a flexible rubber within 24 hours (or faster when XIAMETER® RTV-3081-F Curing Agent or XIAMETER® RTV-3081-VF Curing Agent are used) at room temperature (22-24°C/ 71.6-75.2°F) and the mold can then be separated from the material. If the working temperature is significantly lower, 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 of the mold will be reached within 7 days.

ADDITIONAL INFORMATION

Reproduction of vertical surfaces

If a skin mold is required of a vertical object or surface and cannot be made by normal pouring techniques, the catalyzed mixture can be made non-flowable by the addition of XIAMETER® OFX-1011 Fluid.

1. Prepare the original as described earlier.
2. Brush the original with a thin layer of catalyzed mixture. Repeat the operation when the first layer has started to cure, to achieve a coating thickness of >2mm. Leave to cure at room temperature until the material is tacky.
3. Prepare a new catalyzed mixture of XIAMETER HS II Base and add 0.5-1.0% by weight of XIAMETER OFX-1011 Fluid and mix thoroughly until a paste consistency is reached. De-airing of the mixture is not required.

4. Using a spatula, cover the coated original with the thixotropic coating until all undercuts are filled; leave to cure for 24 hours, or less if XIAMETER RTV-3081-F Curing Agent or XIAMETER RTV-3081-VF Curing Agent are used, at room temperature.
5. Construct a support mold using polyester resin or plaster and allow to set in contact with the silicone coating. Carefully remove the support mold. Peel the rubber off the original and place in the support mold.

Other curing agents

The standard curing agent for XIAMETER HS II Base is XIAMETER RTV-3081 Curing Agent. For special requirements Dow Corning offers a range of additional curing agents:

- XIAMETER RTV-3081-F Curing Agent for demolding after 6 hours.
- XIAMETER RTV-3081-VF Curing Agent for demolding after 2 hours.
- XIAMETER® RTV-3081-R Curing Agent for improved mold life with polyester casting resins.

XIAMETER- RTV-3081-F Curing Agent and XIAMETER RTV-3081-VF Curing Agent are fast curing agents and give a shorter working time.

Use at high temperatures

Some molds produced from condensation cure silicone rubbers can degrade when exposed to temperatures above 150°C (302°F) over a period of time or when totally confined in

storage at high ambient temperatures. This can result in softening and loss of elastic properties.

For more detailed information on the use of XIAMETER[®] brand additives, please contact your local XIAMETER[®] Technical Representative.

Resistance to casting materials

The chemical resistance of fully cured XIAMETER HS II Base is excellent, and similar to all condensation cure silicone elastomers. It should be noted however that ultimately, resins and other aggressive casting materials will attack silicone molds, changing physical properties, surface release and possibly mold dimensions. Molds should be checked periodically during long production runs.

Note:

XIAMETER HS II Base is an industrial product and must not be used in food molding, dental and human skin molding applications.

PRODUCT SAFETY INFORMATION

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND MATERIAL SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL, ENVIRONMENTAL, AND HEALTH HAZARD INFORMATION. THE MATERIAL SAFETY DATA SHEET IS AVAILABLE ON THE XIAMETER WEB SITE AT WWW.XIAMETER.COM.

STORAGE

Product should be stored at or below 32°C (89.6°F) in original, unopened containers. The most up-to-date shelf life information can be found on the XIAMETER Web site in the Product Detail page under Sales Specification.

LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses. Not intended for human injection

LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY

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