

Additive Manufacturing LLC

Addition Cure RTV R - 2384 A/B Product Data Sheet

INTRODUCTION:

R-2384 A/B is a two-part silicone rubber designed for tool hardness—75A Shore, physical properties and chemical resistance. Applications include mold making, embedding, electrical applications, thermal expanding tools and relief type molds because of its firmness.

PHYSICAL PROPERTIES (TYPICAL VALUES):

Uncured Compound	Cured Compound	24 hrs. @ 77F (25C)
Color: "A" Tan/"B" Blue		
Viscosity @ R.T.: mixed 120,000 cps	Specific Gravity:	1.38
Mixing Ratio A/B: 100/10	Shore A Hardness:	75
Shelf Life: 6 months	Elongation %:	150
Tensile Strength (PSI): 600	Tear Strength (PSI):	65

**CONDITIONS OF TEST: Post cure of 1 hour @ 400F after 24 hour room temperature cure.

MIXING INSTRUCTIONS:

The base and curing agent are mixed just before using. Mix 100 parts base to 10 part curing agent by weight. Automatic mixing equipment or manual mixing may be used to combine base and curing agent. Immediately after mixing, place the material in a vacuum chamber to remove trapped air. As the vacuum is drawn, the material will expand as much as four times its original volume. Remove from vacuum chamber and pour material. **Note:** If settling should occur at the bottom of your container do not mix into material manually. Please call for further instructions.

CAUTION: Oven curing may cause bonding of rubber to substrate. If accelerated curing is desired, user must first test substrate prior to scale-up.

INHIBITION:

Certain materials will cause inhibition or neutralizing of the curing agent: sulfur and organo-metallic salt containing compounds found in organic rubbers, and many condensation cure RTV, chloride solvents, and amines-epoxy. Inhibition may easily be determined by brushing a small quantity of material over a localized area of the part to be reproduced. If the material remains gummy or uncured after the curing time, then the part's surface is acting as an inhibitor. **See Addition Cure Technical Data Sheet for inhibiting

CURING CHART

TEMPERATURE	POT LIFE	CURE TIME
100 F	30 MIN	2 HOURS
150 F	10 MIN	30 MIN
300 F	----	5 MIN

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.