R-2364 A/B

Room Temperature / Heat Cure Silicone
Product Data Sheet

INTRODUCTION:
R-2364 A/B is two-part silicone rubber designed for tool hardness, physical properties and chemical resistance. R-2364 A/B has excellent high tear and tensile properties; typical applications would be relief type molds because of its firmness and molds with deep undercuts, which are tough to de-mold.

PHYSICIAL PROPERTIES (TYPICAL VALUES):

Uncured Compound	Cured Compound
Color: "A" Tan/"B" Blue	24 hrs. @ 77F (25C)
Viscosity @ R.T.: mixed 100,000 cps	Specific Gravity: 1.28
Mixing Ratio A/B: 100/10	Shore A Hardness: 65
Shelf Life: 6 months	Elongation % 250
Tensile Strength (PSI): 650	Tear Strength (PSI): 110

Coefficient of Thermal Expansion (cm/cm/ ºc) 8.4×10^{-4}

Conditions of test:
Post cure of 1 hour @ 400F after room temperature cure 24 hours.

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.
*Note - If settling should occur at the bottom of your container do not mix material manually. Please call for further instructions.

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 these materials 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 substances.

CURING CHART

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