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RTV-2 Silicones Since 1974

Product Information

XP-536 Silicone Rubber

Description

XP-536 is a *transparent*, two-component, addition reaction, platinum catalyzed silicone rubber. It is designed to remain water-clear even after extended exposure to the sun.

Although XP-536 has very good physical properties for an unfilled system, it is not designed as a mold-making rubber; rather, it is used as the article. XP-536 is available in two different hardnesses: **Version 22** has a Shore A of ~35, and **Version 23** has a Shore A of ~22.

Applications

XP-536 was developed to make sculptured articles and for special effects applications that demand clarity.

Mixing Instructions

Mix 100 parts by weight of **XP-536 Base** with 10 parts by weight of **XP-536 Activator** in a container that will hold approximately 4 to 5 times the volume being used. (*Note: You cannot interchange the different versions - yellowing may result. You must mix Version 22 Base with Version 22 Activator, and Version 23 Base with Version 23 Activator.*) Mix thoroughly either by hand or by mechanical mixing. After mixing, place the material in a vacuum chamber capable of 28 to 29 inches of mercury vacuum. The material will expand to approximately quadruple its original volume and then collapse. Maintain the vacuum for an additional 2 to 3 minutes and then remove.

Curing

XP-536 has a long working time and a rather lengthy cure time. *It will completely cure in 3 days at 70°F; however, a more practical curing schedule is 16 hours at 70°F, followed by 2 hours at 90°F.*

Higher temperatures will dramatically accelerate the cure rate.

Average cure times for one-quarter inch thick samples are listed below:

Temperatur	70°F	200°F	250°F	300°F	350°F	400°F
Cure Time	~3 days	1 to 2 hours	< 1 hour	10 to 12 mins.	3 to 5 mins	~20 secs

Typical Properties

	Version 22	Version 23
Color of Base	Transparent	Transparent
Color of Activator	Transparent	Transparent
Viscosity, cps	50,000 \pm 10,000	12,000 \pm 2,000
Mixed Viscosity, cps	25,000 \pm 10,000	6,000 \pm 2,000
Specific gravity	1.02	1.02
Shore A hardness	33 \pm 2	22 \pm 2
Tear strength, ppi	40 \pm 10	40 \pm 10
Shrinkage, %	Nil	Nil
Shelf Life(months)	6	6

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