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RTV-2 Silicones Since 1974

Product Information

XP-540 Silicone Rubber

Description

XP-540 silicone rubber is a translucent two-component, addition reaction, platinum catalyzed system that cures at room temperature. It is a higher durometer version of **P-44**. It has superb physical properties, excellent release and good chemical resistance.

Applications

XP-540 is used to make molds where visual inspection is required. The combination of physical integrity and hardness make it an excellent choice for prototyping. Due to its flexibility and ease in releasing, it performs well with expandable foam systems, maintaining its shape and detail for multiple castings.

Curing

Vulcanization of the **XP-540** takes place in 18 to 24 hours after mixing at normal room temperatures (70°F to 75°F). Heat can be used to accelerate the cure rate. Care must be taken to ensure that the master doesn't gas or give off vapors at the temperature used, since this can cause severe distortion of the mold surface. Some woods give off moisture and gas at relatively low temperatures causing failure in the mold making attempt.

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

Temperature	70°F	90°F	125°F	150°F	200°F	250°F	300°F
Cure Time	18 to 24 hours	3.5 hours	1.5 hours	45 minutes	25 minutes	15 minutes	10 minutes

Typical Properties

Color of Base	Translucent	Tear strength, ppi	100 ± 20
Color of Activator	Clear	Tensile strength, psi	550 ± 50
Viscosity, base, cps	90,000 ± 10,000	Elongation, %	250 ± 25
Viscosity, mixed, cps	50,000 ± 10,000	Shrinkage, %	Nil
Specific gravity	1.08	Shelf Life(months)	6
Working time, hours	1 to 2		
Shore A hardness	52 ± 3		

The information contained in this product information sheet is based on sources believed to be accurate. It is offered in good faith, but without guarantee since the conditions of use are beyond our control. All risks of use are assumed by the user.