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RTV-2 Silicones Since 1974

Product Information

XP-614 SILICONE RUBBER

DESCRIPTION

XP-614 is a fast curing, two-component addition cure silicone rubber mold making material that has a minimum working time of 40 minutes, yet can be demolded in only 3 to 4 hours. This allows the mold maker to produce both sides of a two part mold in one 8 hour shift. Parts can also be produced in the same day from a one piece mold. XP-614 also has a high durometer, minimal shrinkage and excellent chemical resistance, making it a superior choice for prototyping and casting solid polyurethane resins.

MIXING INSTRUCTIONS

Mix 10 parts by weight of XP-614 Base with 1 part by weight of XP-614 Activator in a container that will hold about three times the volume of the rubber being mixed. Stir thoroughly either by hand or by mechanical means until a uniform color is achieved. Immediately after mixing, place the container in a vacuum chamber capable of 28 inches of mercury vacuum. The rubber will expand to double or triple its original volume as it is being deaired. After the rubber collapses, maintain the vacuum for an additional two minutes and then release. Carefully pour the catalyzed silicone rubber over the released pattern (MR-15 is recommended as a release.)

TYPICAL PROPERTIES

Color, Base	Tan
Color, Activator	Black
Mixed Color	Gray
Base viscosity (cps)	45,000 to 55,000
Activator viscosity (cps)	800 to 1200
Mixed Viscosity (cps)	35,000 to 45,000
Working Time (minutes)	40 (minimum)
Demold Time (hrs)	4
Specific Gravity, cured rubber	1.24
Shore A Hardness	
4 hours	34 (minimum)
18 hours	55 ± 5
7 days	60 ± 5
Tear Resistance (ppi)	45 ± 10
Tensile Strength (psi)	600 ± 50
Elongation (%)	175 ± 25
Shrinkage (%)	nil

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.