



# Silicones, Inc.

P.O. Box 363  
High Point, NC 27261  
Tel: 336-886-5018  
Fax: 336-886-7122  
www.silicones-inc.com

*RTV-2 Silicones Since 1974*

## Product Information

### XP-696

#### General Information

XP-696 silicone rubber is a two-component, addition reaction, platinum catalyzed system that cures at room temperature. It has a moderate durometer, high elongation, superb physical properties, excellent release and good chemical resistance. Quick demold time, 2 hours, and is less prone to inhibition from Objet and Modeling Board masters.

#### Typical Properties

##### Uncatalyzed Compound

<b>Color</b>	Base: Translucent	Activator: Red
<b>Mixing Ratio (B/A)</b>	By weight: 100 / 10	
<b>Viscosity (cps)</b>	Mixed: 25,000	
<b>Working Time</b>	:35 minutes +/- 5 minutes	
<b>Cure Time</b>	4-6 hours	
<b>Shelf Life</b>	6 months	

##### Vulcanized (cured) Properties (1 days @ 70° F / 50% relative humidity)

<b>Shore A Hardness (<math>\pm 4</math>)</b>	23
<b>Tear Resistance (ASTM D624)</b>	110 $\pm$ 20 ppi
<b>Tensile Strength (ASTM D412)</b>	450 $\pm$ 50 psi
<b>Elongation (ASTM D412)</b>	425 $\pm$ 50 %
<b>Service Temperature (<math>^{\circ}</math> F)</b>	- 60 to 500
<b>Shrinkage</b>	nil
<b>Specific Gravity</b>	1.08

Mix 10 parts by weight 696 Base with 1 part by weight 696 Activator in container that will hold approximately 3 to 4 times the volume being used. Stir thoroughly either by hand or by mechanical mixing. Immediately after mixing place the material in a vacuum chamber capable of 28 to 29 inches of mercury vacuum. The material will expand to double or triple its original volume and then collapse. Maintain vacuum for an additional 2 to 3 minutes and remove. Carefully pour the catalyzed silicone over the released pattern. Inhibition can occur in presence of some materials. If unfamiliar with inhibition, please seek technical support from our factory.

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