



FEINGOSIL 120

TECHNICAL DATA SHEET N°174

REVISION DATE 01.07.2016

REVISION: 6.0 (EN)

PROPERTIES:

ASPECT	: Viscous fluid
CHEMICAL CHARACTERIZATION	: Condensation-cured RTV-2
COLOUR/ODOUR	: White/Odourless
SOLUBILITY	: Not mixable in water, dispersible in most of solvents
SPECIFIC GRAVITY	: 1.16 g/cm ³
VISCOSITY	: 32000 mPa·s

CURING PROPERTIES:

PROPERTIES	CAT. E	CAT. PES	CAT. E6	CAT. THIXO
Specificity	Standard	Polyester	Quick	Thixotropic
Mix ratio	100:5	100:5	100:5	100:5
Working time	60' ÷ 90'	60' ÷ 90'	30' ÷ 45'	60' ÷ 90'
Setting time	16 ÷ 24 h	16 ÷ 24 h	4 ÷ 6 h	16 ÷ 24 h

PROPERTIES OF THE CROSS LINKED PRODUCT:

PROPERTIES	CAT. E	CAT. PES	CAT. E6	CAT. THIXO
Hardness 24 h (Shore A)	16	16	18	16
Hardness 3 days (Shore A)	20	20	21	20
Tear strength (KN/m)	20.0	21.0	20.0	19.0
Tensile strength (MPa)	3.2	3.3	3.2	3.2
Elongation (%)	400 ÷ 500	400 ÷ 500	400 ÷ 500	400 ÷ 500
Shrinkage	< 0.7 %	< 0.7 %	< 0.7 %	< 0.7 %

The data given are typical values which are not intended for use in preparing specifications. The information given here is based on our present state of knowledge and is published without obligation on our part. Test has done at 23°C and 50% of RH.

This new data sheet replaces all previously printed documentation.



FEINGOSIL 120

TECHNICAL DATA SHEET N°174

REVISION DATE 01.07.2016

REVISION: 6.0 (EN)

PROPERTIES:

FEINGOSIL 120 is a pourable bi-component RTV-2 silicone rubber vulcanizing at room temperature with a poly-condensation process. It gives a perfect replica of the original item. Highly resistant in all circumstances and thermo-stable. For its high tensile strength, it's recommended for reproduction of elastic moulds (even with lots of undercut) in the artistic foundries, decorative objects, etc. Excellent performance for reproduction in wax, plaster, resin models.

HOW TO USE:

After you have homogenized the silicone rubber, weigh the required quantity, add 5% catalyst and mix by hand and by a mechanical mixer. To reduce air bubbles, we suggest a vacuum de-airing treatment before pouring the silicone rubber, compatible with the curing times.

Before casting, vacuum degassing (20-30 mm of mercury) is recommended. Release the vacuum several times. To achieve this, the container should allow an expansion of the fluid at about 3-5 times the initial level. Avoid prolonged degassing too, so as not to volatilize certain components required for curing.

Vulcanization is influenced by temperature and moisture. The best curing conditions are at 23°C and 50% relative humidity. The use of products at higher temperatures and/or relative humidity levels will reduce pot life and setting time. As opposed to this, lower temperatures and lower relative humidity levels will increase pot life and setting time. If the amount of catalyst is increased from 5% to 6-7%, the curing will accelerate, but shrinkages will increase too.

It is recommended not to use the product at temperatures lower than 20°C. In these conditions, the final product performance will be difficult to achieve. We suggest to work at temperatures less than 35-40°C to avoid big shrinkages.

At 23°C and 50% relative humidity, the demoulding happens after 16-24 h. We suggest to wait for 24 h before using the moulds. The definitive properties will be reached after 3 days.

USE OF THIXOTROPIC AGENT:

After you have homogenized the silicone rubber, add 5% CATALYST THIXO and mix in a suitable container for 3-5 minutes. You get a very viscous mass, which can be applied in vertical. With a brush or a spatula, spread the thixotropic silicone rubber to form a layer of 5-10 mm. If necessary, repeat after 4-6 hours (before the silicone rubber is completely cured) to obtain a mould with good strength (20-40 mm).



FEINGOSIL 120

TECHNICAL DATA SHEET N°174

REVISION DATE 01.07.2016

REVISION: 6.0 (EN)

OTHER RECOMMENDATIONS:

We recommend to clean the sample to copy from dust and dirt. If the sample is made of glass or ceramic, it is possible that the silicone rubber sticks to the model. To avoid it, we recommend to use the releasing agent: RELEASING AGENT M.

PACKAGING:

- ✓ Base : Drum 200 Kg
- ✓ Catalyst : Can 5 Kg
- ✓ Base : Pail 20 Kg
- ✓ Catalyst : Bottle 1 Kg
- ✓ Base : Pail 5 Kg
- ✓ Catalyst : Bottle 250 g

STORAGE AND SHELF LIFE:

The product, when stored under appropriate conditions, is stable and usable for **twelve months**. Beyond this date, Feinchimica no longer guarantees that the products meet sales specifications. We suggest to keep the products in their original packaging, well-closed at a temperature between +7°C and +27°C, in well-aired places. Mixing it with a clean shaker before use.

SAFETY INFORMATION:

FEINGOSIL 120 doesn't contain toxic or corrosive compounds. It doesn't require special safety measures during handling. Follow normal safety precautions taken in the case of contact with chemicals. See, however, the safety data sheet of Base and Catalyst before use.