

# FEINGOSIL PC 6320

## Condensation-cured RTV-2 silicone rubber

FEINGOSIL PC 6320 is a pourable bi-component RTV-2 silicone rubber vulcanizing at room temperature with a poly-condensation process.

- Easy to use, high detail reproduction
- Recommended for limited reproductions (not in series) of simple moulds
- Particularly recommended for aluminium foundries working in the footwear field

General properties		
Aspect	Viscous fluid	
Chemical characterization	Condensation-cured RTV-2	
Colour/Odour	Beige/Odourless	
Solubility	Not mixable in water, dispersible in most of solvents	
Density (g/cm <sup>3</sup> )	1.31	
Viscosity (mPa·s)	8000	
Curing properties	Catalyst 1840	Catalyst 1860
Specificity	Winter version	Summer version
Mix ratio	100 : 5	100 : 5
Working time (Minutes)	5 ÷ 10	10 ÷ 15
Setting time (Minutes)	30 ÷ 40	50 ÷ 60
Properties of the cross linked product	Catalyst 1840	Catalyst 1860
Hardness 24 h (Shore A)	20	20
Tear strength (KN/m)	3.0	3.0
Tensile strength (MPa)	1.8	1.8
Elongation (%)	200 ÷ 300	200 ÷ 300
Shrinkage (After 24 h)	< 0.5 %	< 0.5 %

The information here provided is not sale specification. Test have done at 23°C and 50% of RH.

## How to use and advice

Before use, 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.

After you have homogenized the silicone rubber, weigh the required quantity, add 5% of catalyst and mix by hand and by a low speed mechanical mixer. To reduce air bubbles, we suggest a vacuum de-airing treatment before pouring the silicone rubber, compatible with the curing times. A vacuum degassing of 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 higher relative humidity levels will reduce working time and setting time. As opposed to this, lower temperatures and lower relative humidity levels will increase working time 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 lower than 35°C to avoid big shrinkages. At 23°C and 50% relative humidity, the demoulding happens after 40 minutes (CATALYST 1840) or after 60 minutes (CATALYST 1860). The definitive properties will be reached after 24 hours.

CAUTION: For this kind of silicone rubber the THIXO PC agent is not effective.

## Packaging

Pack size	Base	Catalyst
Big	200 Kg	5 Kg
Standard	20 Kg	1 Kg
Small	5 Kg	0.25 Kg

## Storage and shelf life

The product, when stored under appropriate conditions, is stable and usable for 12 months. Beyond this date, Feinchimica no longer guarantees that the product meet sales specifications. The expiration date is indicated on the product label. We suggest to keep the product in its original packaging, well-closed at a temperature between +5°C and +30°C, in well-aired places. Mix it with a clean shaker before use. This operation is necessary to homogenize the mixture.



## Safety information

This product 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.

## Additional notes

The information contained in this sheet is based on knowledge available at the time of compilation. It isn't a substitute of the necessary preliminary tests that guarantee that the product is suitable for a specific use. Users must check to have the latest version of this document. FEINCHIMICA doesn't assume any responsibility for incorrect, improper or non-compliant use of the product.

This new data sheet replaces all previously ones.

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