



Technical Date Sheet

HY-625 RTV-2 Mold Making Silicone Rubber

Description

HY-625 is a kind of room temperature vulcanized silicone rubber in condensation type. It's generally named as two part silicone rubber , Part A is a flowable liquid, part B is the curing agent or catalyst . It's mainly used for mold making .

Application

HY-625 silicone rubber is used for making molds of concrete stone,GRC, gypsum decoration , plaster ornaments, fiberglass products, polyester decoration, unsaturated resin crafts, polyresin crafts, polyurethane, bronze, wax, candle, and similar products .

HY-625 Silicone rubber is with good fluidity and moderate hardness which is suitable for middle size product with pattern by pouring operation, especially popular for manufacturer of resin crafts and gypsum decoration . Besides ,additive is available for brushing operation.It's one of our best selling silicone !

Technical Parameters

Model	Color	Mixing ratio (%)	Pot life (mins, under 25°C)	Curing time (hrs,under 25°C)	Hardness (Shore A)	Tensile-strength (MPa)	Tear-strength (kN/m)	Viscosity (After A/B mixed ,mPa. s)	Shrinkage rate (%)	Elongation (%)
HY-625	White	2-5	30-40	4-5	25±2	4.8±0.5	29±2	25000±5000	≤0.3%	400%

Characteristics

- * An exceptional fluidity and good operability, easy to demold
- * Moderate hardness
- * High tensile and tear strength
- * Good flexibility
- * Cure at room temperature
- * Outstanding bubble releasing
- * High duplication times

Operation instructions

Step 1: prepare the original molds

Make sure your original molds perfect. fix it on a board. And fix the original mold on a board , then used four piece of board to enclose the original molds .

Step 2: Take 100 G parts A and add 3G parts B and mix them evenly.

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*** Notes:** Mold making silicon rubber is a kind of flowing liquid ,it contains two parts. Part A is a kind of flowing white liquid and part B is the curing agent or catalyst .Pls follow the step strictly:

1.Weigh the two part exactly by electronic weight..

If not , for example add two much catalyst , the operation time will be too fast to operate ,which will cause inconvenience to operate .

2.Mix part A and part B evenly.

Otherwise the silicon rubber will be partly solidified and this will give birth to difficulties in your final operation. What's more, the finished molds will meet a short life. All of these will cause a waste of silicon rubber.

Step 3: Vacuum pumping

Without exception, this step takes less than 10 minutes. Otherwise, it will cause cross linking reaction, and no more further steps will be available.

Step 4: Pouring casting or Brush operation

*** Notes:**1. For simple pattern products we suggest use pouring operation way , which will be very easy to operate and demould. Pourable silicone require light viscosity which will be easy to flow smoothly and easy to de-air .

2.For delicate pattern products we suggest use brushing operation way , which can copy the pattern exactly .

Brushable silicone require high viscosity which won't be easy to flow away and easy to brush .

3. We sugges to set the silicone mold for another 12 hours after demould before put into large production .

Package

25KG/drum vacuum packing for part A +1kg/ bottle catalyst for part B

200KG/drum packing for part A +1kg/ bottle catalyst for part B

Shelf life

1. Twelve(12) months when stored under dry and cool place by original package under 25°C