

SILASTIC® M RTV Silicone Rubber

FEATURES

- Outstanding release properties
- If required the product cure can be heat accelerated
- High hardness
- Medium tear resistance
- Very low shrinkage and good dimensional stability
- Can be used for high temperature casting applications
- High inhibition resistance

High durometer, medium tear resistance silicone moldmaking rubber

APPLICATIONS

- SILASTIC M RTV Silicone Rubber is suited for the reproduction of prototyping, architectural and furniture components, especially for use with polyurethanes and other casting plastics.

TYPICAL PROPERTIES

Specification writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales representative prior to writing specifications on this product.

Property	Unit	Value
Base		
Viscosity	mPa.s	130,000
Color		Beige
Curing Agent		
Color		Regal Blue
Base and Curing Agent mixture (100:10 by weight)		
Viscosity	mPa.s	90,000
Working time	minutes	60
Cured for 24 hours at 25°C (77°F)		
Hardness (Shore A)		59
Tensile strength	MPa	4.5
Elongation at break	%	250
Tear strength	kN/m	16
Relative density at 25°C (77°F)		1.29
Linear shrinkage	%	<0.1

DESCRIPTION

SILASTIC M RTV Silicone Rubber is a two-component material consisting of a SILASTIC M RTV Base, which when mixed with the SILASTIC M RTV Curing Agent cures at room temperature by an addition reaction. A range of materials can be cast into the cured silicone mold: polyurethane, polyester and other reactive resins are materials typically used.

HOW TO USE

Substrate preparation

The surface of the original should be clean and free of loose material. If

necessary, and in particular with porous substrates, use a suitable release agent such as petroleum jelly or soap solution.

In all cases, it is advisable to check before casting that no discoloration or adhesion occurs between the product and the original or mold frame.

Mixing

SILASTIC M RTV Curing Agent contains a pigment which acts as an indicator for proper measuring and mixing. Thoroughly shake/stir the curing agent before use so that any sedimented pigment is redispersed.

SILASTIC(R) M RTV SILICONE RUBBER CURING AGENT

1. IDENTIFICATION OF THE SUBSTANCE AND OF THE COMPANY

Trade name	:	SILASTIC(R) M RTV SILICONE RUBBER CURING AGENT		
Company	:	Dow Corning S.A. Parc Industriel - Zone C B-7180 Seneffe Belgium		
Service	:	Dow Corning Central Europe	Tel: +49 6112371	
			Fax: +49 611237609	
		Dow Corning Northern Europe	Tel: +44 1676528000	
			Fax: +44 1676528001	
		Dow Corning Southern Europe	Tel: +33 472841360	
			Fax: +33 472841379	
Emergency Phone Number	:	Dow Corning (Barry U.K. 24h)	Tel: +44 1446732350	
		Dow Corning (Wiesbaden 24h)	Tel: +49 61122158	
		Dow Corning (Seneffe 24h)	Tel: +32 64 888240	

2. COMPOSITION / INFORMATION ON INGREDIENTS

Chemical characterization: Liquid Silicone Rubber

Hazardous Ingredients:

Name	CAS-No.	EINECS/ ELINCS No.	Conc. (% w/w)	Classification
Tetramethyltetravinylcyclotetrasiloxane	2554-06-5	Exempt or not available	2.0	R53
Pigment Blue 15	147-14-8	205-685-1	1.0	

3. HAZARDS IDENTIFICATION

Not hazardous according to Council Directive 1999/45/EC and its subsequent amendments.

Some hydrogen gas may be released. Hydrogen is flammable and can form explosive mixtures with air.

4. FIRST AID MEASURES

On contact with eyes	:	No first aid should be needed.
On skin contact	:	No first aid should be needed.
If inhaled	:	No first aid should be needed.
On ingestion	:	No first aid should be needed.

SILASTIC(R) M RTV SILICONE RUBBER CURING AGENT**5. FIRE FIGHTING MEASURES**

- Suitable extinguishing media** : Carbon dioxide, foam or dry powder. Water can be used to cool fire exposed containers.
- Unsuitable extinguishing media** : None known.
- Hazards during fire fighting** : None known.
- Special protective equipment/procedures** : A self-contained respirator and protective clothing should be worn. Keep containers cool with water spray until well after the fire is out. Determine the need to evacuate or isolate the area according to your local emergency plan. Applying foam will also release significant amounts of flammable hydrogen gas that can be trapped under the foam blanket.
- Hazardous Combustion Products** : Silica. Carbon oxides and traces of incompletely burned carbon compounds. Formaldehyde. Hydrogen.

6. ACCIDENTAL RELEASE MEASURES

- Personal precautions** : Wear proper protective equipment.
- Precautions to protect the environment** : Prevent from spreading or entering into drains, ditches or rivers by using sand, earth or other appropriate barriers.
- Methods for cleaning up** : Determine the need to evacuate or isolate the area according to your local emergency plan. Very large spills should be contained by bunding, etc... procedures. Mop, wipe or soak up with absorbent material and place in a vented container. The spilled product produces an extremely slippery surface.

7. HANDLING AND STORAGE

- Advice on safe handling** : Avoid eye contact. Local ventilation is recommended. General ventilation is required.
- Advice on storage** : This product slowly evolves hydrogen on storage. Keep only in a vented container in a well ventilated area. Keep container closed and store away from water or moisture.
- Specific uses** : Refer to technical data sheet available on request.
- Unsuitable packaging materials** : Do not store in or use glass containers.

8. EXPOSURE CONTROLS / PERSONAL PROTECTION

Engineering Controls : Ventilation : Refer to Section 7

Exposure controls for hazardous components

Name	CAS-No.	Exposure Limits
2 of 6		

SILASTIC(R) M RTV SILICONE RUBBER CURING AGENT

Pigment Blue 15 147-14-8 5 mg/m³ (OEL, 8h TWA) respirable dust; 10mg/m³ (OEL, 8h TWA) total inhalable dust.

Personal protection equipment

- Respiratory protection** : Suitable respiratory protection should be worn if the product is used in large quantities, confined spaces or in other circumstances where the OEL may be approached or exceeded.
- Hand protection** : Gloves are not normally required.
- Eye protection** : Safety glasses should be worn.
- Skin protection** : Protective equipment is not normally necessary.
- Hygiene measures** : Exercise good industrial hygiene practice. Wash after handling, especially before eating, drinking or smoking.
- Environmental exposure controls** : Refer to section 6 and 12.
- Additional information** : These precautions are for room temperature handling. Use at elevated temperature or aerosol/spray applications may require added precautions. For further information regarding the use of silicones in consumer aerosol applications, please refer to the guidance document regarding the use of silicone-based materials in consumer aerosol applications that has been developed by the silicone industry (www.SEHSC.com) or contact the Dow Corning customer service group.

9. PHYSICAL AND CHEMICAL PROPERTIES**Appearance**

Form: Liquid **Colour:** Blue **Odour:** None

Other data

- Boiling point/range** : > 65 °C
- Flash point** : > 100 °C (Closed Cup)
- Explosive properties** : No
Some hydrogen gas may be released. Hydrogen is flammable and can form explosive mixtures with air.
- Specific Gravity** : 1.0
- Viscosity** : 5500 cSt at 25°C.
- Oxidizing properties** : No

The above information is not intended for use in preparing product specifications. Contact Dow Corning before writing specifications.

10. STABILITY AND REACTIVITY

SILASTIC(R) M RTV SILICONE RUBBER CURING AGENT

Stability	:	Stable under normal usage conditions.
Conditions to avoid	:	None established.
Materials to avoid	:	Hydrogen is liberated on contact with water, alcohols, acidic or basic materials, many metals or metallic compounds and can form explosive mixtures in air.
Hazardous decomposition products	:	See section 11.

11. TOXICOLOGICAL INFORMATION

On contact with eyes	:	May cause temporary discomfort.
On skin contact	:	No adverse effects are normally expected.
If inhaled	:	No adverse effects are normally expected.
On ingestion	:	No adverse effects are normally expected.
Other Health Hazard Information	:	Product may emit formaldehyde vapours at temperatures above 150°C in the presence of air. Formaldehyde vapour is harmful by inhalation and irritating to eyes and respiratory system at breathing concentration less than one part per million (1 ppm). This product contains (a) powder(s) hazardous by inhalation. This is not relevant to the current physical form of the product, which is not in a respirable form.

¹ Based on product test data.

² Based on test data from similar products.

12. ECOLOGICAL INFORMATION**Environmental fate and distribution**

Siloxanes are removed from water by sedimentation or binding to sewage sludge. In soil, siloxanes are degraded.

Ecotoxicity effects

No adverse effects on aquatic organisms.

Bioaccumulation : No bioaccumulation potential.

Fate and effects in waste water treatment plants

Removed > 90% by binding onto sewage sludge. No adverse effects on bacteria. The siloxanes in this product do not contribute to the BOD.

Additional environmental information

Additional environmental information on the silicone component is available on request.

SILASTIC(R) M RTV SILICONE RUBBER CURING AGENT**13. DISPOSAL CONSIDERATIONS**

Product disposal : Dispose of in accordance with local regulations.

Packaging disposal : Dispose of in accordance with local regulations.

14. TRANSPORT INFORMATION**Road / Rail (ADR/RID)**

Not subject to ADR/RID.

Sea transport (IMDG)

Not subject to IMDG code.

Air transport (IATA)

NOT IATA REGULATED. (VENTED PACKAGES FORBIDDEN FOR AIR TRANSPORT)

15. REGULATORY INFORMATION**Labelling according to EEC Directive**

S-phrases : S9 Keep container in a well-ventilated place.
S12 Do not keep the container sealed.
S16 Keep away from sources of ignition - No smoking.
S51 Use only in well-ventilated areas.

National legislation / regulations

Ozone depleting chemicals : No ozone depleting chemicals are present or used in manufacture.

Status

EINECS : All ingredients listed or exempt.

TSCA : All chemical substances in this material are included on or exempted from listing on the TSCA Inventory of Chemical Substances.

SILASTIC(R) M RTV SILICONE RUBBER CURING AGENT**16. OTHER INFORMATION**

This product safety data sheet was prepared in compliance with Commission Directive 91/155/EEC, 67/548/EEC and 1999/45/EC as well as their relevant amendments, on the approximation of laws, regulations and administrative provisions relative to the classification, packaging and labelling of dangerous substances and preparations.

It is the responsibility of persons in receipt of this Product Safety Data Sheet to ensure that the information contained herein is properly read and understood by all people who may use, handle, dispose or in any way come in contact with the product. If the recipient subsequently produces a formulation containing the Dow Corning product, it is the recipient's sole responsibility to ensure the transfer of all relevant information from the Dow Corning Product Safety Data Sheet to their own Product Safety Data Sheet in compliance with Commission Directive 1999/45/EC.

All information and instructions provided in this Safety Data Sheet (SDS) are based on the current state of scientific and technical knowledge at the date indicated on the present SDS. Dow Corning shall not be held responsible for any defect in the product covered by this SDS, should the existence of such defect not be detectable considering the current state of scientific and technical knowledge.

As stated above, this Safety Data Sheet has been prepared in compliance with applicable European law. If you purchase this material outside Europe, where compliance laws may differ, you should receive from your local Dow Corning supplier a SDS applicable to the country in which the product is sold and intended to be used. Please note that the appearance and content of the SDS may vary - even for the same product - between different countries, reflecting the different compliance requirements. Should you have any question, please refer to your local Dow Corning supplier.

R53 May cause long-term adverse effects in the aquatic environment.,

SILASTIC(R) M RTV SILICONE RUBBER BASE

1. IDENTIFICATION OF THE SUBSTANCE AND OF THE COMPANY

Trade name	:	SILASTIC(R) M RTV SILICONE RUBBER BASE		
Company	:	Dow Corning S.A. Parc Industriel - Zone C B-7180 Seneffe Belgium		
Service	:	Dow Corning Central Europe	Tel: +49 6112371	Fax: +49 611237609
		Dow Corning Northern Europe	Tel: +44 1676528000	Fax: +44 1676528001
		Dow Corning Southern Europe	Tel: +33 472841360	Fax: +33 472841379
Emergency Phone Number	:	Dow Corning (Barry U.K. 24h)	Tel: +44 1446732350	
		Dow Corning (Wiesbaden 24h)	Tel: +49 61122158	
		Dow Corning (Seneffe 24h)	Tel: +32 64 888240	

2. COMPOSITION / INFORMATION ON INGREDIENTS

Chemical characterization: Liquid Silicone Rubber

Hazardous Ingredients:

Name	CAS-No.	EINECS/ ELINCS No.	Conc. (% w/w)	Classification
Quartz	14808-60-7	238-878-4	36.0	Xn R48/20 R68/20

3. HAZARDS IDENTIFICATION

Not hazardous according to Council Directive 1999/45/EC and its subsequent amendments.

4. FIRST AID MEASURES

On contact with eyes	:	No first aid should be needed.
On skin contact	:	No first aid should be needed.
If inhaled	:	No first aid should be needed.
On ingestion	:	No first aid should be needed.

5. FIRE FIGHTING MEASURES

SILASTIC(R) M RTV SILICONE RUBBER BASE

Suitable extinguishing media	:	Carbon dioxide, foam, dry powder or fine water spray. Water can be used to cool fire exposed containers.
Unsuitable extinguishing media	:	None known.
Hazards during fire fighting	:	None known.
Special protective equipment/procedures	:	A self-contained respirator and protective clothing should be worn. Keep containers cool with water spray until well after the fire is out. Determine the need to evacuate or isolate the area according to your local emergency plan.
Hazardous Combustion Products	:	Silica. Carbon oxides and traces of incompletely burned carbon compounds. Formaldehyde. Quartz.

6. ACCIDENTAL RELEASE MEASURES

Personal precautions	:	Wear proper protective equipment.
Precautions to protect the environment	:	Prevent from spreading or entering into drains, ditches or rivers by using sand, earth or other appropriate barriers.
Methods for cleaning up	:	Determine the need to evacuate or isolate the area according to your local emergency plan. Very large spills should be contained by bunding, etc... procedures. Mop, wipe or soak up with absorbent material and place in a container with a lid. The spilled product produces an extremely slippery surface.

7. HANDLING AND STORAGE

Advice on safe handling	:	Avoid eye contact. General ventilation is recommended.
Advice on storage	:	Do not store with oxidizing agents.
Specific uses	:	Refer to technical data sheet available on request.
Unsuitable packaging materials	:	None known.

8. EXPOSURE CONTROLS / PERSONAL PROTECTION

Engineering Controls : Ventilation : Refer to Section 7

Exposure controls for hazardous components

Name	CAS-No.	Exposure Limits
Quartz	14808-60-7	0.3 mg/m ³ TWA Respirable dust

Personal protection equipment

SILASTIC(R) M RTV SILICONE RUBBER BASE

Respiratory protection	:	A suitable respirator must be worn if the product is used in any circumstances where an aerosol or mist may be generated, such as during spraying or similar activities
Hand protection	:	Gloves are not normally required.
Eye protection	:	Safety glasses should be worn.
Skin protection	:	Protective equipment is not normally necessary.
Hygiene measures	:	Exercise good industrial hygiene practice. Wash after handling, especially before eating, drinking or smoking.
Environmental exposure controls	:	Refer to section 6 and 12.
Additional information	:	These precautions are for room temperature handling. Use at elevated temperature or aerosol/spray applications may require added precautions. For further information regarding the use of silicones in consumer aerosol applications, please refer to the guidance document regarding the use of silicone-based materials in consumer aerosol applications that has been developed by the silicone industry (www.SEHSC.com) or contact the Dow Corning customer service group.

9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance

Form: Viscous Liquid **Colour:** Beige **Odour:** Not available

Other data

Boiling point/range	:	> 100 °C
Flash point	:	> 100 °C (Closed Cup)
Explosive properties	:	No
Specific Gravity	:	1.29
Viscosity	:	130000 cSt at 25°C.
Oxidizing properties	:	No

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10. STABILITY AND REACTIVITY

Stability	:	Stable under normal usage conditions.
Conditions to avoid	:	None established.
Materials to avoid	:	Can react with strong oxidising agents.

SILASTIC(R) M RTV SILICONE RUBBER BASE

Hazardous decomposition products : See section 11.

11. TOXICOLOGICAL INFORMATION

On contact with eyes : May cause temporary discomfort.

On skin contact : No adverse effects are normally expected.

If inhaled : No adverse effects are normally expected.

On ingestion : No adverse effects are normally expected.

Other Health Hazard Information : Product may emit formaldehyde vapours at temperatures above 150°C in the presence of air. Formaldehyde vapour is harmful by inhalation and irritating to eyes and respiratory system at breathing concentration less than one part per million (1 ppm). Human health hazards associated with quartz (silica, crystalline respirable dust) and other fibrogenic dusts arise following inhalational exposure to respirable particles. Quartz in the present formulation (uncured or cured) is not available in a respirable form.

¹ Based on product test data.

² Based on test data from similar products.

12. ECOLOGICAL INFORMATION**Environmental fate and distribution**

Siloxanes are removed from water by sedimentation or binding to sewage sludge. In soil, siloxanes are degraded.

Ecotoxicity effects

No adverse effects on aquatic organisms.

Bioaccumulation : No bioaccumulation potential.

Fate and effects in waste water treatment plants

Removed > 90% by binding onto sewage sludge. No adverse effects on bacteria. The siloxanes in this product do not contribute to the BOD.

Additional environmental information

Additional environmental information on the silicone component is available on request.

13. DISPOSAL CONSIDERATIONS

Product disposal : Dispose of in accordance with local regulations.

Packaging disposal : Dispose of in accordance with local regulations.

SILASTIC(R) M RTV SILICONE RUBBER BASE**14. TRANSPORT INFORMATION****Road / Rail (ADR/RID)**

Not subject to ADR/RID.

Sea transport (IMDG)

Not subject to IMDG code.

Air transport (IATA)

Not subject to IATA regulations.

15. REGULATORY INFORMATION**Labelling according to EEC Directive**

No special packaging or labelling requirements.

National legislation / regulations**Ozone depleting chemicals** : No ozone depleting chemicals are present or used in manufacture.**Status****EINECS** : All ingredients listed or exempt.**TSCA** : All chemical substances in this material are included on or exempted from listing on the TSCA Inventory of Chemical Substances.

SILASTIC(R) M RTV SILICONE RUBBER BASE**16. OTHER INFORMATION**

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R48/20 Harmful: danger of serious damage to health by prolonged exposure through inhalation., **R68/20** Harmful: possible risk of irreversible effects through inhalation.

Weigh 100 parts of SILASTIC M RTV Base and 10 parts of SILASTIC M RTV Curing Agent (see handling precautions) in a clean container, then mix together until the curing agent is completely dispersed in the base. Hand or mechanical mixing can be used, but do not mix for an extended period of time or allow the temperature to exceed 35°C (95°F). Mix sufficiently small quantities to ensure thorough mixing of the base and curing agent.

It is strongly recommended that entrapped air be removed in a vacuum chamber, allowing the mix to completely expand and then collapse. After a further 1-2 minutes under vacuum, the mix should be inspected and if free of air bubbles, can then be used. A volume increase of 2-3 times will occur on vacuum de-airing the mixture, so a suitably large container should be chosen.

Note: If no vacuum de-airing equipment is available, air entrapment can be minimised by mixing a small quantity of base and curing agent, then using a brush, painting the original with a 1-2mm layer. Leave at room temperature until the surface is bubble-free and the layer has begun to cure. Mix a further quantity of base and curing agent and proceed as follows to produce a final mold.

Pouring the mixture and curing

Pour the mixed base and curing agent as soon as possible onto the original, avoiding air entrapment. The catalyzed material will cure to a flexible rubber within 16 hours at room temperature (22-24°C or 71.6-75.2°F) and the mold can then be removed. If the working temperature is significantly lower, the cure time will be longer. Heat accelerating the cure is possible, but this will produce some apparent shrinkage of the mold, due to differences in volume contraction on cooling between the silicone rubber and the original. The higher the curing temperature, the greater the likely differences in dimensions.

ADDITIONAL INFORMATION

Inhibition of cure

All addition-cured silicone elastomers are susceptible to cure inhibition when in contact with certain materials and chemicals. Inhibition has occurred if the elastomer is only partially cured after 24 hours, or has a sticky surface in contact with another material. Amines and sulphur containing materials are strong inhibitors, as are organo tin salts used in condensation cure silicone elastomers. Wet or moist surfaces can cause gas bubbles to be formed during cure in the silicone adjacent to the substrate surface. It is strongly recommended that mixing containers, mold construction materials, originals and release agents be checked for any inhibition effect before use.

Use at high temperatures

Molds produced from SILASTIC M RTV have a long life at elevated temperatures. However, continuous use above 200°C (392°F) will result in loss of elasticity over a period of time. Use above 250°C (482°F) is not recommended. When heated, a mold made of SILASTIC M RTV will expand producing a small change in copy dimensions.

Resistance to casting materials

The chemical resistance of fully cured SILASTIC M RTV is excellent, and similar to all addition-cure silicone elastomers. It should be noted however that ultimately, resins and other aggressive casting materials will attack silicone molds, changing physical properties, surface release and possibly mold dimensions. Molds should be checked periodically during long production runs.

Note:

SILASTIC M RTV Base/Curing Agent is an industrial product and must not be used in food molding, dental and human skin molding applications.

HANDLING PRECAUTIONS

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED.

BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE FROM YOUR LOCAL DOW CORNING SALES REPRESENTATIVE.

USABLE LIFE AND STORAGE

When stored at or below 25°C (77°F) in the original unopened containers, SILASTIC M RTV Base and SILASTIC M RTV Curing Agent have a usable life of 12 months from the date of production.

SILASTIC M RTV Base and SILASTIC M RTV Curing Agent can be sensitive to moisture and contamination. Ensure that containers are tightly closed after use.

PACKAGING

SILASTIC M RTV Base and SILASTIC M RTV Curing Agent are available in 5.5kg and 22kg kits.

LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

HEALTH AND ENVIRONMENTAL INFORMATION

To support customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Health, Environment and Regulatory Affairs specialists available in each area.

For further information, please consult your local Dow Corning representative.

WARRANTY INFORMATION - PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this

information should not be used in substitution for customer's tests to ensure that Dow Corning's products are safe, effective, and fully satisfactory for the intended end use. Dow Corning's sole warranty is that the product will meet the Dow Corning sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. Dow Corning specifically disclaims any other express or implied warranty of fitness for a particular purpose or merchantability. Unless Dow Corning provides you with a specific, duly signed endorsement of fitness for use, Dow Corning disclaims liability for any incidental or consequential damages. Suggestions of use shall not be taken as inducements to infringe any patent.

