

XIAMETER[®] RTV-3487 Base

High strength silicone moldmaking rubber

FEATURES

- Outstanding release properties
- High flowability and long working time
- Very low hardness
- Medium tear resistance
- High elasticity, for easy removal of complex replica parts
- Can be made thixotropic (non-flowable) for vertical surface replication

APPLICATIONS

- XIAMETER[®] RTV-3487 Base is suited for the detailed reproduction of figures, art objects and similar items.

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local XIAMETER[®] sales representative prior to writing specifications on this product.

Test	Unit	Value
Base and Curing Agent mixture (100:5 by weight)		
Mixed viscosity	mPa.s	15,000
Color		White
Working time of catalyzed mixture at 23°C (73.4°F)	minutes	90-120
Curing time	hours	24
Cured for 7 days at 23°C (73.4°F)		
Hardness (Shore A)		8
Tensile strength	MPa	2.6
Elongation at break	%	650
Tear strength	kN/m	13
Relative density at 25°C (77°F)		1.15
Linear shrinkage	%	0.2-0.4

DESCRIPTION

XIAMETER RTV-3487 Base is a two-component material consisting of XIAMETER RTV-3487 Base, which, when mixed with XIAMETER[®] RTV-3087-S Curing Agent, cures at room temperature by a condensation reaction.

A range of materials can be cast into the cured silicone mold: plaster, polyurethane and polyester resins are materials typically used.

HOW TO USE

Surface 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.

Mixing

Thoroughly stir XIAMETER RTV-3487 Base before use as filler separation may occur upon prolonged storage.

Weigh 100 parts of XIAMETER RTV-3487 Base and 5 parts XIAMETER RTV-3087-S Curing in a clean container. 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 suitably 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 12 minutes under vacuum, the mix should be inspected and can be used if free of air bubbles. A volume increase of 3-5 times will occur on vacuum de-airing the mixture, so a suitably large container should be chosen.

Caution: prolonged vacuum will remove volatile components from the mix and may result in poor thick section cure and non-typical properties.

Note: If no vacuum de-airing equipment is available, air entrapment can be minimized 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 catalyst as soon as possible onto the original, avoiding air entrapment. The catalyzed material will cure to a flexible rubber within 24 hours at room temperature (22-24°C/ 71.6-75.2°F) according to the amount of catalyst used and the mold can then be removed. If the working temperature is significantly lower, the cure time will be longer. If the room temperature or humidity is very high, the working time of the catalyzed mixture will be reduced. The final mechanical properties of the mold will be reached within 7 days.

ADDITIONAL INFORMATION

Reproduction of Vertical Surfaces

If a skin mold is required of a vertical object or surface and cannot be made by normal pouring techniques, the catalyzed mixture can be made non flowable by the addition of XIAMETER® RTV-3011 Thixo Additive.

1. Prepare the original as described earlier.
2. Brush the original with a thin layer of catalyzed mixture. Repeat the operation when the first layer has started to cure, to achieve a coating thickness of >2mm. Leave to cure at room temperature until the material is tacky.
3. Prepare a new catalyzed mixture of XIAMETER RTV-3487 Base and add 3% by weight of XIAMETER RTV-3011 Thixo Additive and mix thoroughly until a paste consistency is reached. De-airing of the mixture is not required.
4. Using a spatula, cover the coated original with the thixotropic coating until all undercuts are filled; leave to cure for 24 hours at room temperature.
5. Construct a support mold using polyster resin or plaster and allow to set in contact with the silicone coating. Carefully remove the support mold. Peel the rubber off the original and place in the support mold.

Use at high temperatures

Some molds produced from condensation cure silicone rubbers can degrade when exposed to temperatures above 150°C (302°F) over a period of time or when totally confined in storage at high ambient temperatures. This can result in softening and loss of elastic properties. Please contact a Dow Corning distributor for further advice.

Resistance to casting materials

The chemical resistance of fully cured XIAMETER RTV-3487 Base is excellent, and similar to all condensation 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:

XIAMETER RTV-3487 Base is an industrial product and must not be used in food molding, dental and human skin molding applications.

PRODUCT SAFETY INFORMATION

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND MATERIAL SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL, ENVIRONMENTAL, AND HEALTH HAZARD INFORMATION. THE MATERIAL SAFETY DATA SHEET IS AVAILABLE ON THE XIAMETER WEB SITE AT WWW.XIAMETER.COM.

STORAGE

Product should be stored at or below 32°C (89.6°F) in original, unopened containers. The most up-to-date shelf life information can be found on the XIAMETER Web site in the Product Detail page under Sales Specification.

When stored below 20°C (68°F), XIAMETER RTV-3011 Thixo Additive may solidify. The product can be easily liquified by immersing the closed container in warm water.

LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses. Not intended for human injection. Not intended for food use.

LIMITED 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 our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

Dow Corning's sole warranty is that our products will meet the 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.

DOW CORNING DISCLAIMS LIABILITY FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES.