

Silicone-System HP-SI41GB
 - Condensation Curing / Shore A 20 -

The Silicone-System HP-SI41GB is a medium-viscosity combination of resin and hardener with working time (pot life) about 40 minutes.

Features & Benefits:

- medium viscous mould making
- high tear strength
- working time 40 minutes
- smooth cast without air bubbles
- free of organotin accelerators

- excellent for duplicating from original
- application with high dimensional accuracy
- creation of flexible moulds
- particularly suitable for mineral casting resins
- suitable for PUR fast casting resins
- conditionally suitable for epoxy resins

Product Properties:

Mixing ratios (by weight)	100 parts resin / 3 parts hardener	
Mixed viscosity	medium viscous	(details below)
Working time (pot life)	40 minutes	(100g at 20°C)
Time of the Vulcanization	16 - 24 h	(at 20°C)
Working temperature (recommended)	20-23 °C	

Product Specifications:

Viscosity A	18000	cps	DIN 16945
Viscosity B	10	cps	DIN 16945

Data of unreinforced resin:

Density	1.1	g/cm ³
Hardness (Shore A)	20	
Tensile strength	3	N/mm ²
Elongation at break	> 300	%
Shrinkage	< 1	%
Glass transition temperature Tg MAX	100	°C
Tin content	Tin free	
Colour (mixed)	white	

Safety instructions:

The safety instructions are to be taken as being of greatest importance. Do not allow children to handle. Prevent inhalation of the fumes and contact with the bare skin. Wear approved protective gloves and goggles. If ingested do not eat, drink or smoke. During the hardening process, energy can be released in the form of heat, hence a cooling/heat exchanging should be provided in order to prevent hot spots. Only mix the components in the recommended proportions in accordance with the instructions.

Application Instructions:

We recommend tests be performed for trials and suitability for the particular type of application. The system should only be used in the optimum temperature conditions. The relative air humidity should not be above 70%. In respect of the safety instructions the Silicone and hardener should be mixed in a suitable mixing vessel in accordance with characteristics given in the data sheet. Deviating from the mixing recommendations can lead to incomplete hardening and through that loss of performance.

Ensure that the edges are well mixed using a stirring stick or a propeller type mixer. Localized signs of hardening indicate insufficient stirring and mixing of the components. Mixing of larger amounts (more than 100g) and higher temperatures (higher than 20°C) reduces the pot life time.

After entire mixing of resin and hardener, it is possible to add dry filling agents.

Further it is possible to degas the system by vacuum at 30 – 50 mbar.

- Vacuum may increase the volume!

The contact with following materials can delay or have a negative influence on the curing:

- sulfur-containing chlorine and butyl rubbers
- metal- salts catalyzed LSR or RTV types
- stabilizers and plasticizers
- solvents (alcohols, esters, ketone)
- some plasticine (children knead)

Cleaning work tools:

Unhardened product remains can be removed from tools by means of acetone or Thinner XB. Tools should be given a good airing after being cleaned with these solvents, in order to prevent the solvent from being retained until the tool is used again in a process. Hardened remains can only be removed by departing.

Storage:

Threaded container tops should be kept free of material remains. Do not exchange tops/lids.

With optimal storage conditions, shelf-life should be beyond 12 months.

Disposal:

Do not dispose of through the sewerage system, on areas of open water, or in the soil. Non-hardened remains of the product should be disposed of as hazardous waste. The hardened product waste should be treated as building rubbish or household rubbish.

Further Information:

Further application information can be obtained from our internet site, by selecting product info on the homepage. Please do not hesitate to contact us by telephone if you have further queries.

Information presented herein has been compiled from sources considered to be dependable and is accurate and reliable to the best of our knowledge and belief but is not guaranteed to be so. It is the user's responsibility to determine for himself the suitability of any material for a specific purpose and to adopt such safety precautions as may be necessary. We make no warranty as to the results to be obtained in using any material and, since conditions of use are not under our control, we must necessarily disclaim all liability with respect to the use of any material supplied by us.

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