WACKER SILICONES

ELASTOSIL®

Supplied by

AMBERCOMPOSITES

ELASTOSIL® M 3502

RTV-2 Silicone Rubber / Mold Making

Characteristics

Spreadable, non-sag, condensation-curing, two-component silicone rubber that vulcanizes at room temperature.

Special characteristics

- Medium hardness (Shore A: approx. 26)
- Very soft, pasty consistency for ease of application
- Excellent non-slump performance (will not sag or run off vertical surfaces)
- Excellent tear strength
- Short curing time for quick demolding
- Outstanding chemical resistance to attack by polyester and polyurethane resins. Mold life is significantly extended.

Application

ELASTOSIL® M 3502 is a high-performance mold making compound, which is particularly suitable for the reproduction of models with pronounced undercuts. Due to its non-sag consistency, it is a perfect material for making skin molds.

Best suited for all common reproduction materials, ELASTOSIL® M 3502 offers particularly long mold life when processing polyester and polyurethane resins.

Processing

When stored for a prolonged period ELASTOSIL® M 3502 may have a somewhat thicker consistency than usual.

Stirring it thoroughly **before** adding the catalyst will produce the optimum consistency for processing.

If molds for processing epoxy or **polyurethane resins** are to be made, ELASTOSIL® M 3502 is cured by adding 5 wt % Catalyst T 21 for long pot lives and curing times, or 5 wt % Catalyst T 26 for short pot lives and curing times.

For molds used to process other reproduction materials such as **polyester resins**, plaster, concrete, synthetic stone, wax or low-melting alloys, 5 wt % Catalyst T 51 for long pot lives and curing times, or 5 wt % Catalyst T 56 for short pot lives and curing times should be used.

For still shorter pot lives and curing times, 2 - 3 wt % Catalyst T 10 may be used.

Product data (uncured)

Property	Test method	Unit	Value
Color			White
Density at 23 °C		[g/cm³]	1.25
Consistency			Soft, pasty, non-sag

Product data (catalyzed with 5 wt % Catalyst T 51)

Property	Test method	Unit	Value
Non-sag performance	Layer thickness	[mm]	≤ 10

Product data (cured)

Property	Test method	Unit	Value
Density at 23 °C in water	ISO 2781	[g/cm³]	1.24
Hardness Shore A	ISO 868		26
Tensile strength	ISO 37	[N/mm²]	4.5
Elongation at break	ISO 37	[%]	450
Tear strength	ASTM D 624 B	[N/mm]	> 23
Linear shrinkage		[%]	< 0.4

With 5 wt % Catalyst T 51, after 4 days at 23 °C / 50 % rel. humidity.

These figures are only intended as a guide and should not be used in preparing specifications.

Catalyst	Pot life, [min]	Curing time (tack-free) [h]
5 % T 21	50-80	8-10
5 % T 26	20-40	5-7
5 % T 51	50-80	8-10
5 % T 56	20-40	5-7
2 % T 10	10-20	2-3

The pot life is the period of time at 23 °C / 50 % rel. humidity during which the catalyzed mix remains spreadable.

Comprehensive instructions are given in our leaflet "WACKER RTV-2 Silicone Rubber - Processing."

Detailed information on other mold-making compounds in the ELASTOSIL® M range is contained in our brochure “ELASTOSIL® M. Mold-Making Compounds For Maximum Precision”.

Storage

ELASTOSIL® M 3502 should be stored between 5 °C and 30 °C in the tightly closed original container. The 'Best use before end' date of each batch appears on the product label.

Catalysts T 10, T 21, T 26, T 51 and T 56 should be stored in the sealed original bottles between 5 °C and 25 °C.

Storage beyond the date specified on the label does not necessarily mean that the product is no longer usable. In this case however, the properties required for the intended use must be checked for quality assurance reasons.

Safety information

Being a condensation-curing silicone rubber, ELASTOSIL® M 3502 contains only constituents that over many years have proved to be neither toxic nor aggressive. Special handling precautions are therefore not required, i.e., only the general industrial hygiene regulations apply.

Catalysts T 10, T 21, T 26, T 51 and T 56 contain organotin compounds, are flammable (flash point 50 °C) and may cause irritation in contact with the eyes and skin. Appropriate protective measures are required.

Detailed safety information is contained in each Material Safety Data Sheet, which can be obtained from our sales offices.

Additional information

Please visit our website www.wacker.com

The management system has been certified according to DIN EN ISO 9001 and DIN EN ISO 14001

Version 7.00 from 14-01-08 replaces Version 6.00 from 11-04-07

For technical, quality, or product safety questions, please contact:

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