

TECHNICAL DATA SHEET

Product Name

Aldax CraftSil

Product Description

Pourable, condensation-curing, two component silicone rubber that cures at room temperature and features:

- Good Flow
- Low Shore A Hardness (approx 25)
- High Tear Strength
- Great extensibility and elasticity
- Excellent long term stability of the mechanical properties of the cured rubber
- High resistance to casting resins, particularly polyester

Typical Applications

Due to the excellent mechanical properties of the cured rubber as well as its high resistance to casting resin, CraftSil is especially suitable for reproducing models with pronounced undercuts in casting resins.

Other materials, such as wax and plaster, may be cast without any problems in moulds made from CraftSil

Physical Properties

Product Data / Uncured

Colour			White
Density @ 23°C		[g/cm ³]	1.17
Viscosity @ 23°C, after stirring With 5% wt Catalyst T35	Brookfield	[mPa s]	45 000
Viscosity @ 23°C	Brookfield	[mPa s]	40 000

Product Data / Cured – with 5% wt T35, after 7 days @ 23°C / 50% relative humidity

Density at 23°C, in water	ISO 2781	[g/cm ³]	1.16
Hardness, Shore A	ISO 867		25
Tensile Strength	ISO 37	[N/mm ²]	5.0
Elongation at Break	ISO 37	[%]	350
Tear Strength	ASTM D 624, B	[N/mm ²]	> 20
Linear Shrinkage		[%]	0.5
Coefficient of Linear Expansion	0-150°C	[m/m K]	2.0 x 10(-4)

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Handling Properties

Processing

With 5% wt Catalyst T35	90 [min] Pot life	15-20 [hr] Curing Time (tack free)
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The pot life figure indicates the time at 23°C / 50% RH required for the catalysed mix to attain a viscosity of 100 000 mPa s and still be just pourable.

Handling Properties 2

Craftsilcuring times can be adjusted by the addition and variation of T47 Catalyst. The figures given are an indication only and testing should always be performed prior to pouring your mould. Note that the increase in T47 will greatly reduce pot life and curing times. Accelerated catalysts will also reduce the life expectancy of the mould.

Catalyst T47 is not supplied with the standard kit.

Processing

Catalyst	Parts by Weight	Pot Life [min]	Curing Time [hr]
T35	5%	90	15-20
T35 (90) : T47 (10)	5%	20-40	6-8
T35 (80) : T47 (20)	5%	10-20	2-4
T47	5%	3-10	1-2

() = this is a blended mix of the T35 and T47 Catalysts

Storage

Craftsil has a shelf life of at least 12 months in the sealed container between 5°C and 30°C. If the material is kept beyond 12 months it is not necessarily unusable, but a test should be performed on the product to check suitability to the application.

Issue Date

12th July 2011

Revision Number

4

Disclaimer

The data presented in this leaflet are in accordance with the present state of our knowledge, and does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the product for a particular purpose.