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SILICONE ASSYST W22 WITH HARDENER

FEATURES

★ Two-part liquid silicone and hardener.
It is cured within 6-9 hours at room temperature 25 °C.
★ An exceptional fluidity and good handling, easy to remove.
Good tensile and tear strength, low shrinkage.
★ Suitable for casting methods for making small shapes.

USE:

Silicone rubber for PU / poly resin products, unsaturated resin products, plaster products, candles and plaster crafts, toys, soap moulds, sculptures, mould making, etc.

TYPICAL CHARACTERISTICS:

Appearance	white
Mixing ratio (%)	3 - 4%
Operating time (min 25°C)	60
Curing time (hours 25°C)	6 - 9
Hardness (A)	25 ± 2
Density (g/cm³)	1,08
Viscosity (MPas -25°C)	19000 - 25000
Tensile strength (MPa)	≥3,5
Tear strength (kg/cm)	≥20
Prolongation interruption (%)	≥ 420
Shrinkage (%)	≤ 0,25

INSTRUCTIONS FOR USE:

This silicone rubber has an exceptional fluidity and good effect. When mixed with 4-5% hardener, it has a pot life of 40-70 min. but will be fully cured after 4-5 hrs. With resistance to deformation, high temperature, acid and alkali, and expansion, flexible silicone molds are used for duplicating shapes and making delicate forms for polyamics, resin lighting and candle crafts.
This product is a white liquid with a hardness of 23-25 Shore A when cured. Moulds in several parts are required for making moulds of large products. For this, you need silicone rubber with a higher hardness. Conversely, soft rubber is indispensable for moulds with intricate patterns and delicate details. The amount of hardener added depends on your requirements. Add more for a quick drying process and rapid demoulding and less for the opposite.
(Notes: Normally we do not recommend adding silicone oil. For special soft moulds or moulds with a complex object or fine details, 5-10% silicone oil can be added to facilitate the flexibility of the mould for ease of release).

Mixing ratio for silicone and hardener and the reaction time (at room temperature-25°C)

1. Adding 2% hardener gives a potlife of 2.5 hours, and de-forming is possible after 8-10 hours.
2. Adding 3% hardener gives a potlife of 1 to 1.5 hours and de-forming is possible after 6-8 hours.
3. Adding 4% hardener gives a potlife of 55-60 min and de-forming can be done after 4-6 hours.
4. Adding 5% hardener gives a potlife of 45-50 min and de-forming is possible after 4 hours.

TECHNICAL GUIDELINES:

1. Stir the base (part A) well before use (except where this depends on the machine).
2. Shake the hardener (part B) well before use.

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3. This is a mixing ratio of 100 parts A to 5 parts B by weight. Weigh the desired amount of base into a clean mixing container.
4. Weigh the appropriate amount of catalyst into the container. Mix the base and catalyst by stirring with a stick until a uniform colour is obtained. Scrape the sides and bottom of the container well to ensure proper mixing.
5 Although the material is often not required to be vented due to its low viscosity, some may choose to do so. If so, place the container in a vacuum chamber and remove the trapped air from the mixture using a vacuum pump that can reach 29 inches of mercury vacuum. Interruption (bumping) of the vacuum may be necessary to prevent the container from overflowing. Keep the mixture under full vacuum for 2-3 minutes.
6 Slowly vent the vacuum chamber. When the chamber has reached atmospheric equilibrium, remove the cover plate and take out the container.
7 Pour the de-aerated material slowly in a steady stream at the highest point of the mould, so that the material flows evenly over the object. This should minimise the inclusion of air bubbles under the flowing material. A "ready" mould can be poured over the object in the first place, which will also help to reduce the chance of air entrapment on the object and in the cured rubber. A mould release agent can be applied to the object first to improve release.
8 Allow the rubber to cure for 2-4 hours at 24°C before removing the cured rubber mould from the object. Heat acceleration is not recommended for this product.
9 For best results, allow the mould to harden in the air for 24 hours before production.

MAINTENANCE:
Twelve (12) months from the date of shipment if stored below 25°C in the original sealed container.

FIRST AID:

- Inhalation: Remove sources of contamination and bring victim into fresh air. Get medical attention immediately.
- Eye contact: Flush eyes with plenty of water. Seek medical attention if irritation persists.
- Skin contact: In case of contact with skin, wash thoroughly with soap and water; remove contaminated clothing and wash before reuse; seek medical attention if a rash develops.
- Ingestion: Do NOT induce vomiting unless directed to do so by a physician. Get medical attention immediately.