



ASSYST bvba / A.S.O.W. bvba  
Hellegatstraat 13a - 2590 Berlaar - België  
Tel: +32 495 50 61 14 / +32 496 83 70 27  
Website: [www.assyst.org](http://www.assyst.org) / [www.artsuppliesonweb.com](http://www.artsuppliesonweb.com)  
Email: [ao@assyst.org](mailto:ao@assyst.org) / [vera.opsommer@assyst.org](mailto:vera.opsommer@assyst.org)

## **ZHERMACK ZA 35 MOULD YELLOW**

### **Description and key features**

Pourable two-component polyaddition silicones that vulcanise at room temperature.

Special features

- Fast curing
- Low Viscosity
- Excellent long-term stability of the mechanical properties of the hard rubber.

### **Main application areas**

- Fast mold curing, low viscosity and dimensional stability, precision in reproduction and easy to trim
- Master Mold fast curing, low viscosity, dimensional stability, precision in reproduction and easy to trim

### **Processing**

Important Note: The platinum catalyst is in the CATALYST part.

Catalyst and base components should only be used together if they have the same batch number.

Before pouring epoxy, polyester and PU resins onto the silicone, apply a release agent to protect the silicone mold.

If you are using this silicone or any new resin for the first time, please do a small test before it will jeopardize the job.

### **Operating instructions**

Take the two bi-component products supplied by Zhermack (base and catalyst) and shake before use in order to homogenize each component prior to mixing. Weigh an equal amount of catalyst and base (e.g. 100 grams of catalyst and 100 grams of base; within a 5% error range the results will not change). Please keep in mind that the exact proportions 1:1 must be respected in order to guarantee the final characteristics of the product.

Once the product is weighted in equal quantities, the base and catalyst must be inserted in a recipient and mixed thoroughly. Make sure the surfaces of the recipient are perfectly clean, free of grease and dry.

While mixing, it is important to check that no residue remains on the base and sides of the recipient. Mix energetically until the blended color is homogeneous. Once the product is thoroughly mixed, it is ready to be casted and we recommend pouring the silicone from a 30 cm height into the mould.

The working time WT (see table below), also known as "pot life", is the recommended time period for mixing/vacuuming prior to casting.

Please pay attention some Vaseline Oil could inhibit the product. Make a small test first.

The reported WT shown in the table refers to a standard temperature of 23°C. We recommend using vacuum to eliminate any air bubbles. In the event that the quantity of silicone used is less than what is required, complete the mould by adding the missing quantity of silicone within 24 hours of the hardening of the first layer of silicone. The second layer will attach to the first one without altering the final outcome. The setting time ST (see table below) is the time it takes for the silicone to harden from the beginning of mixing of the two components. The reported ST shown in the table refers to a standard temperature of 23°C. After the ST is complete, the model can be separated from the mould. If necessary, use compressed air to facilitate this separation. Do not use any tools to force the separation of the model from the mould.



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### Effects of temperature on setting and working times:

The working time and setting time are reduced if the temperature exceeds 23°C (e.g. if the temperature is 40°C, the working time and setting time are approximately cut in half). If the temperature is less than 23°C, the working time and setting time increase considerably.

Cured Silicone properties are guaranteed within temperatures ranging from a minimum temperature of - 40 °C to a maximum temperature of +200°C.

### Chemical and physical properties

#### PRODUCT DATA (not mixed)

	Base	Catalyst
Colour	Yellow	White
Density at 23°C (g/cc)	1.18	1.18

#### PRODUCT DATA (Vulcanised product)

Colour	Yellow
Mixing ratio	1:1
Viscosity of pre-catalyst mixture	4000 cP
Operating time at 23°C (73°F)	15 min
Initial curing at 23°C (73°F)	60 min
Shore A hardness after 24 hours	35 sh A
Tensile strength	4.2 N / mm <sup>2</sup>
Stretch to break	310%
Tear strength	8 N / mm

These figures are for guidance only and should not be used in the preparation of specifications. Vulcanisation after 24 hours at 23°C.

### Shelf life

The ZA 22 MOULD silicone is guaranteed for a period of 12 months if correctly stored at a temperature of 5°- 27°C (41°-80°F).

Close the bottles after use, do not twist the caps or lids between the base and catalyst.

Storage after the date indicated on the label does not 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.