

## Silicon Condensation HT60

In forms made out of these silicones you can cast alloys with a melting point up to 380°C.

### Description

The silicone condensation HT 60 is a 2-component condensation curing casting silicone that cures at room temperature. The silicone is highly filled and suitable for the production of moulds for low temperature alloys like Zamak, tin or lead.

Because the silicones are highly filled they tend to break when bent too far. Therefore we advise not to use this silicone for moulds with many or large undercuts.

### Technical Data

The mixing ratio (by weight)	[A:B]	100:2
Pot life at 20°C	[Min]	40
Demolding at 20°C	[Hours]	4
Full strength after	[Days]	3
Hardness	[Shore A]	60
Viscosity at 20°C	[mPa s]	11.000
Tear strength	[Kg/cm <sup>2</sup> ]	45
Color		Red brown

**Note:** Pot life and demold time are dependent on the mixing ratio and Humidity. Addition of more than 2% silicone B (harder) or working at higher humidity will shorten pot life and demould time.

### Processing

The fillers in the A-component must be mixed thoroughly before use.

The silicone C HT 60 can easily be mixed by hand or by machine. Mix the components thoroughly in the ratio indicated. Process the mixture within the pot life and de-mould after the whole thing is completely cured. Make the mould as thin as possible.

After cure, post cure the rubber mould by putting it in an oven for 2-3 hours at 150 ° C to remove trapped vapors. Coat the mold (prior to casting the alloy into it) with a layer of talcum powder or graphite powder, this will improve the wetting of the alloy onto the mould surface. Make sure that the mold is heated prior to casting the alloy. Put the mould on a surface with a high thermal conductivity.

### Packing

The package contains 1 kg A-component and 20 g B-component.

### Shelf life

When stored in sealed packaging at a temperature of 10-25 ° C, the shelf life is at least 1 year. If the A component has been on the shelf for long, the fillers should be stirred well before use.

### Safety

If you frequently work with silicones, it is recommended to wear gloves during processing and to ventilate the room well. Please refer to the Material Safety Data Sheet for more information.

## Characteristics

- Color Red brown
- Easy to mix
- Short-term heat resistant up to 380 ° C
- Very hard Shore A 60

