

# FEINGOSIL PA 325

## Addition-cured RTV-2 silicone rubber

FEINGOSIL PA 325 is a pourable bi-component RTV-2 silicone rubber vulcanizing at room temperature with a poly-addition process.

- Easy to use, high details reproduction
- Excellent mechanical properties, low viscosity and high elasticity
- Used in the reproductions of wax, plaster, resins models

### General properties

Aspect	Viscous fluid
Chemical characterization	Addition-cured RTV-2
Odour	Odourless
Colour part A	White
Colour part B	Red
Solubility	Not mixable in water, dispersible in most of solvents
Density (g/cm <sup>3</sup> )	1.15
Viscosity (mPa.s)	7000

### Curing properties

Mix ratio	100 : 100
Working time (Minutes)	45 ÷ 60
Setting time (Hours)	4

### Properties of the cross linked product

Hardness 24 h (Shore A)	25
Tear strength (KN/m)	20.0
Tensile strength (MPa)	4.0
Elongation (%)	400 ÷ 500
Shrinkage (After 5 days)	< 0.1 %

The information here provided is not sale specification. Test have done at 23°C and 50% of RH.

## How to use and advice

Some inhibitions to vulcanization process may occur when the silicone rubber get in contact with amines, plastilines, metal salts, sulphides, tin catalysts and poly-condensation silicone rubbers. To avoid any inhibition problems, we recommend a preliminary test for the compatibility of the silicone on the material to duplicate.

Before use, make sure that the model to duplicate is perfectly clean and dry. Shake well the bottles of part A and B. Weigh the same quantity of part A and B. If the proportions aren't exact, the curing times and the final properties can be different. Mix by hand or with a mechanical low-speed stirrer in a suitable container to minimize air occlusion. Mix about a minute until a homogeneous colour is obtained. Before casting, vacuum degassing (20-30 mm of mercury) is recommended. Release the vacuum several times. To achieve this, the container should allow an expansion of the fluid at about 3-5 times the initial level. Avoid prolonged degassing, because an excessive degases reduces curing times.

The curing speed is influenced by the temperature. We recommend to work in an isothermal place at 23°C. Higher temperatures accelerate the curing times, lower temperatures reduce them. It is recommended not to use the product at temperatures lower than 10°C. In these conditions, the final product performance will be difficult to achieve. The cured silicone can be demoulded after 4 hours. In order to reach the best performance of the moulds, we suggest to wait for 24 hours before using them.

**CAUTION:** Only components A and B with the same lot number may be processed together! The platinum catalyst is contained in component A (white colour).

## Reproduction of vertical surfaces

After you have homogenized the silicone rubber, add THIXO PA, from 1% to 3%, depending on the desired effect. Mix in a suitable container for 2 ÷ 4 minutes. The more THIXO PA you add (maximum 3%), the more viscous the mixture becomes, so you can apply in vertical. With a brush or a spatula, spread the thixotropic silicone rubber to form a layer of 5-10 mm. If necessary, repeat after 3 ÷ 4 hours (before the silicone rubber is completely cured) to obtain a mould with good strength (20-40 mm).

## Packaging

Pack size	Base	Catalyst
Big	200 Kg	200 Kg
Standard	20 Kg	20 Kg
Small	5 Kg	5 Kg



## Storage and shelf life

The product, when stored under appropriate conditions, is stable and usable for 12 months. Beyond this date, Feinchimica no longer guarantees that the product meet sales specifications. The expiration date is indicated on the product label. We suggest to keep the product in its original packaging, well-closed at a temperature between +5°C and +30°C, in well-aired places. Mix it with a clean shaker before use. This operation is necessary to homogenize the mixture. Close always the bottles after use. Do not reverse the cap.

## Safety information

This product doesn't contain toxic or corrosive compounds. It doesn't require special safety measures during handling. Follow normal safety precautions taken in the case of contact with chemicals. See, however, the safety data sheet of Base and Catalyst before use.

## Additional notes

The information contained in this sheet is based on knowledge available at the time of compilation. It isn't a substitute of the necessary preliminary tests that guarantee that the product is suitable for a specific use. Users must check to have the latest version of this document. FEINCHIMICA doesn't assume any responsibility for incorrect, improper or non-compliant use of the product.

This new data sheet replaces all previously ones.

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