

# ANCHOR SEAL

10/15/09

## Product # XT-491 RTV Silicone Molding Rubber

### Features:

Tin, condensation cure  
Heat resistance  
Low shrinkage  
High tear & tensile strength

### Applications:

RTV molds  
Fabricating parts  
Polyurethane foam  
Polyester & epoxy

### Mixing & Curing Instructions:

**Mix Ratio:** 100 Base to 10 GI-1000 Activator by wt.

**Cure Schedule:** Cure 16-18 hours @ 77°F before removing the master. After removing the master, season the mold at room temperature for 2 days before casting.

### Properties @ 77°F, Uncured:

Pot Life, hours..... 1.5-2.5  
Viscosity, CPS..... Base... 60,000 ..... Activator... 350  
Viscosity, B:A mixed, CPS..... 40,000  
Specific Gravity..... Base 1.10 ..... Activator 0.99  
Shelf life, factory sealed cans, minimum, months..... 6

### Physical Properties @77°F, Cured:

Color..... opaque, light blue  
Durometer, (Hardness) Shore A..... 26  
Specific Gravity, cured, grams/cc.....1.09  
Tensile Strength, ASTM D-412, PSI..... 525  
Tensile Elongation, ASTM D-412, %..... 300  
Tear Strength, Die B, ASTM D624, ppi ..... 120  
Shrinkage, %..... 0.1  
Service Temperature, °F..... -60 to 350

### Electrical Properties @ 77°F, Cured:

Dielectric Strength, ASTM D149, volts/mil..... N/A  
Dielectric Constant, ASTM D150, 1 KHz ..... N/A  
Dissipation Factor, ASTM D150, 1 KHz..... N/A  
Volume Resistivity, ASTM D257, ohm-cm ..... N/A

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### IMPORTANT INFORMATION: READ BEFORE USING PRODUCT

**Directions for Use:** Because of differences in density, *pigments and fillers, when present, may separate* from the liquid components during storage. To insure product homogeneity and maximum performance, check the containers for settling. Loosen any settled pigments from the bottom of the container and ***thoroughly mix contents prior to use.*** Use a mixing stick or power mix at slow speed with a drill press and dispersion blade.

**Measuring:** Carefully weigh Part B and Part A components with an accurate scale. If measuring volumetrically, use precise metering pumps, graduated/pre-marked containers or pre-measured kits. Place the correct proportions of Part B and Part A into a straight-sided container. **Note:** Altering the mix ratio from what is specified on the data sheet is not recommended. Cured properties could be adversely affected.

**Mixing:** Mix thoroughly with a flat-ended stick or a slow speed drill press with a dispersion blade. Scrape the sides and bottom occasionally to assure a thorough blend. Do not whip excessive air into the mixture. To guard against partially cured sections, never apply material *scraped* from the sides of the original mixing container. For best results, transfer the mixture into a second container and stir it again before application. This will help insure consistent properties and maximum performance.

**De-airing:** Some applications require a totally air-free product. If a vacuum pump and chamber are used, evacuate the material for 10-15 minutes @ 28-29 inches of mercury. Allow sufficient space above the liquid for expansion, about four times the liquid volume. Curing under pressure, 60 psi, will compress most bubbles and promote a bubble free casting.

**Curing:** A tin based RTV will cure against all surfaces without fear of inhibition caused by chemical contamination. Proper curing requires exposure to a minimum 50% relative humidity. Do not try to cure the product in a completely closed cavity unless a few % of U.F.C. (ultra fast catalyst) is added to the mixture. Do not cure this product in an oven at elevated temperatures.

**Handling Cautions:** Review the Material Safety Data Sheet before using this product.

**Warning: For Industrial Use Only.** All chemicals must be handled with care. Avoid breathing fumes and mists, they could cause respiratory discomfort or damage. Work in a well-ventilated area. Avoid all contact with the skin. If contact occurs, wash affected area thoroughly with soap and water. Repeated skin contact may cause dermatitis in susceptible individuals. Wear protective clothing and gloves. Irritation may result if this product is splashed into the eyes. Always wear eye protection. If eye contact occurs, flood eyes with clear water for 15 minutes and immediately seek medical attention. Always maintain good industrial hygiene when using this product.

**Notice To Buyer:** All information contained herein is believed to be accurate. However, it is the responsibility of the end user to determine the suitability of this product in his particular application. As the use of this product by others is beyond our control no warranty, whether expressed or implied is made by Anchor-Seal, Inc. or any of its representatives as to this product's merchantability or fitness for a particular purpose. Under no circumstances shall Anchor-Seal, Inc. be liable for incidental, consequential or other damages for any reason. The sole liability of Anchor-Seal, Inc. shall be to refund the purchase price or replace materials deemed to be defective by us.