

TinSil® 70-Series RTV Silicone Rubbers

High-Performance, Flexible Mold Rubbers

DESCRIPTION: TinSil® 70 Series RTV Silicone Rubbers are condensation-cure, tin-catalyzed, flexible mold rubbers. TinSil products consist of a liquid Part B base and Part A accelerator, which, after mixing at the proper ratio by weight, cure at room temperature to rubber with a tough, knotty tear property. TinSil molds have easy release properties and are resistant to high temperatures. TinSil molds are excellent for casting polyesters, epoxy and polyurethane resins, waxes and many other materials.

As with other Polytek® elastomers, the last two digits in the product name indicate the approximate Shore A hardness of the cured rubber. Choose the appropriate hardness of rubber for your application.

- **TinSil 70-11, 70-20 and TinSil Gel-10** are soft and, therefore, best for delicate castings. TinSil Gel-10 is translucent and especially useful for animatronics and special effects.
- **TinSil 70-25 and 70-30** are Polytek's most popular and versatile, mid-range hardness, silicone rubbers.
- **TinSil Brush/Spray-25** are brushable or sprayable or can be applied by hand or sprayed with a low-cost Plas-Pak spray gun or more sophisticated 1A:10B silicone spray equipment. Spray 25 is great for large scale blanket molds!
- **TinSil 70-60** is stable at higher temperatures making it suitable for casting low melting metals. TinSil 70-60 has limited tear strength because of its hardness.

MODEL PREPARATION: Porous models such as wood or plaster must be sealed to prevent penetration of the liquid rubber into the pores of the material. Wax, petroleum jelly, lacquer, paint and most other coatings are suitable sealers. Pol-Ease® 2350 Release Agent can be sprayed or brushed onto an unsealed model to act as both a sealer and release agent. A couple of coats of Pol-Ease 2350 may be required depending on the porosity of the model. Allow to dry before pouring rubber. Do not use Pol-Ease

2300 Release Agent on surfaces that contact liquid TinSil, since inhibition and/or adhesion can occur. Pol-Ease 2500 Release Agent can be used on sealed models or on cured silicone rubber to prevent additional liquid silicone from adhering. TinSil rubbers bond to cured silicone rubbers unless a parting agent is used. Modeling clays containing sulfur may inhibit curing. In every case where there is any question about the compatibility between the rubber and the prepared model surface, a test cure should be made on an identical surface to determine that complete curing and good release are obtained.

Porous models should be vented from beneath to prevent trapped air from causing bubbles in the rubber.

MIXING & CURING: Weigh proper amounts of Part B and then Part A into a clean mixing container. *Accurate weighing is essential to obtain optimum physical properties from the cured rubber.* Mix thoroughly, scraping sides and bottom of the container. If the liquid rubber is mixed carefully, so as not to whip air into the mix, 70-Series products can be poured without vacuum degassing. To ensure a bubble-free mold, however, deaerate the liquid rubber under vacuum at 28-29 inches mercury until the mass of rubber rises and then collapses. Deaerate for additional 2 minutes. For vacuuming, use a mixing container 3 to 4 times larger than the volume of rubber.

To reach full hardness in the specified demold time, temperature should be above 77°F (25°C). At lower temperatures, more time may be needed to reach full hardness. Curing below 65°F (18°C) is not recommended.

TinSil products release alcohol while curing. Before casting polyurethanes in a TinSil mold, be sure that all alcohol has evaporated since alcohol inhibits surface cure of some polyurethanes. Exposure for 24 hours to a warm location in open air is often adequate, but the mold can be baked for four hours at 212°F (100°C) to speed alcohol evaporation.

PHYSICAL PROPERTIES						
	TinSil Gel-10 & 70-11	70-20	70-25	Brush/Spray 25	70-30	70-60
Mix Ratio (By Weight)	1A:10B	1A:10B	1A:10B	1A:10B	2A:100B	5A:100B
Hardness, Shore A	10	20	25	25	30	60
Pour Time (min)	45	60	60	30	60	30
Demold Time (hr) @ 77°F	16	16	16	16-24	24	24
Specific Gravity	1.1	1.1	1.1	1.1	1.1	1.5
Color, Cured	Translucent (Gel-10) Blue (70-11)	Blue	Blue	Translucent	Beige	Red
Initial Mixed Viscosity (cP)	10,000	10,000	14,000	Thixotropic	26,000	17,000
Specific Volume, in³/lb	25.3	25.3	25.3	25.3	25.3	18
Shrinkage Upon Cure (%)	~0.3	~0.3	~0.3	~0.3	~0.3	~0.8

Product	Packaging		
	Unit Sizes (lb)	Part A (lb)	Part B (lb)
TinSil Gel-10, 70-11, 70-20, 70-25, & Brush/Spray 25 Mix Ratio 1A:10B	1.0	0.1	0.9
	2.0 (Spray 25 Cartridge)	0.2	1.8
	9.0	0.9	8.1
	44.0	4.0	40.0
	495	45.0	450
TinSil 70-30 Mix Ratio 2A:100B	1.02	0.02	1.0
	8.3	0.2	8.1
	40.8	0.8	40.0
	448.8	8.8	440
TinSil 70-60 Mix Ratio 5A:100B	1.05	0.05	1.0
	8.4	0.4	8.0
	42.0	2.0	40.0

USING THE MOLD: No release agent is necessary for casting most materials in TinSil molds. For longer mold life, however, apply a barrier coat, or Pol-Ease 2300 or 2500 Release Agent to molds before casting epoxy, polyurethane or polyester resins. TinSil molds can be stored for a year or more, but as with most tin-catalyzed silicones, molds may eventually deteriorate and lose their elasticity. Molds made with excess catalyst may degrade from aging faster than silicone rubbers cured with less catalyst.

FASTER CURES FOR RAPID DEMOLDING: Use TinSil FastCat in place of any TinSil Part A to accelerate cure and shorten demold time. When using FastCat, the working time is shorter as well, so avoid over-catalyzing. FastCat can be used in a range of 2 to 6 parts per 100 parts B. At 2 parts FastCat to 100 parts B, the working time and demold time will be similar to that observed when using 10 parts of the appropriate TinSil Part A. At 3 parts FastCat per 100 parts TinSil B, the working time will be reduced to ~20-30 minutes, with <8-hour demold. Experiment with a small mix first to determine the best amount of FastCat to use. Use of FastCat can shorten the library life of cured TinSil rubber.

BRUSH ON BLANKET MOLDS: TinSil 70 Series rubbers can be thickened with TinThix liquid thickener or with Fumed Silica for brushing on a blanket mold. TinThix is a liquid additive that

can be mixed into the Part B (before mixing with Part A) to achieve varying levels of thixotropy.

Blanket molds can be reinforced by placing stretchy, open mesh nylon or dacron cloth into the uncured rubber. The fabric should not be too close to the mold surface or the weave of the cloth may show through to the face of the mold.

THINNING AND SOFTENING WITH SILICONE FLUID:

The very low viscosity 50 cSt Silicone Fluid can be added sparingly to the mixed rubber to thin the mix with some loss of strength, hardness and cure speed. More than 10% fluid addition may exude from the cured rubber. A 10% addition to TinSil 70-20 will reduce hardness to approximately Shore A10-15.

BARRIER COAT: A barrier coat is a fast drying, lacquer-like primer that is sprayed into a silicone mold and allowed to dry prior to pouring liquid plastic or foam. Upon removing the cured plastic casting from the mold, the barrier coat comes out on the casting resulting in a primed part. Also, using a barrier coat can extend mold life.

SAFETY: Before use, read product labels and Material Safety Safety Sheets. Follow safety precautions and directions.

WARNING! Contact with uncured products may cause severe eye and skin irritation. Avoid contact with skin and eyes. Use only with adequate ventilation. Best method of cleanup is by wiping with paper towels and washing with waterless hand cleaner, then soap and water. If solvents must be used, denatured ethyl alcohol is best, but should be handled with respect for health and flammability hazards. TinSil products are not to be used where food or body contact may occur.

STORAGE LIFE: At least 6 months in unopened containers stored at room temperature (60-90°F). Tightly reseal opened containers.

DISCLAIMER: The information in this bulletin and otherwise provided by Polytek is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained by the use thereof, or that any such use will not infringe any patent. Before using, the user shall determine the suitability of the product for the intended use and user assumes all risk and liability whatsoever in connection therewith.

ACCESSORIES

Barrier PF

1 qt (1.5 lb), 5 gal (35 lb)

Fumed Silica

5 gal, 1 bag (10 lb)

Pol-Ease® 2300 Release Agent

12-oz can, case of 12 cans

Pol-Ease® 2350 Release Agent

1 qt (1.5 lb), 5 gal (26 lb)

Pol-Ease® 2500 Release Agent

12-oz can, case of 12 cans

TinSil® FastCat

4 oz, 1 pt (1 lb), 1 gal (8 lb)

TinThix

4 oz, 1 pt (1 lb)

Silicone Fluid 50 cSt Grade

1 qt (2 lb), 1 gal (8 lb), 5 gal (40 lb)

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