

SILICONE CASTING RUBBERS

"Dedicated to QUALITY, SERVICE, SAFETY, and INNOVATION"

TC-5060 A/B 60 SHORE A ROOM TEMPERATURE CURING SILICONE

TC-5060 A/B is a room temperature, addition/platinum curing silicone rubber designed for:

- Mold making
- Encapsulation applications
- Pressure pads
- Gaskets
- Casting low-melt metals into
- Various types of parts

With the use of talc powder as an interface the TC-5060 has been used with cast metal temperatures running 650°F (344°C) and has been subject to temperatures up to 850°F (454°C) for making a limited number of casts. With the ability to withstand high temperatures the TC-5060 works very well as a mask for metal spraying and welding operations.

PHYSICAL PROPERTIES	TEST METHOD	RESULTS
Hardness, Shore A	ASTM D 2240-04 ^{ε1}	60±5
Density (g/cc)	ASTM D 792-00	1.34
Cubic Inches per Pound	N/A	20.8
Color/Appearance	Visual	Pale Green
Tensile Strength (psi)	ASTM D 412-98a(2002) ^{ε1}	754
Elongation (%)	ASTM D 412-98a (2002) ^{ε1}	225
Tear Strength (pli)	ASTM D 624-00 ^{ε1} Die B	85
Coefficient of Thermal Expansion, (in/in/°F)	ASTM E 831	14.91 x 10 ⁻⁵
Shrinkage (in/in) linear	ASTM D2566 @ 1" depth	Nil

HANDLING PROPERTIES	Part A	Part B
Mix Ratio by weight	100	10
Mix Ratio by volume	100	14
Specific Gravity @ 77°F (25°C)	1.37	0.99
Color	Off White	Green
Viscosity (cps) @ 77°F (25°C) Brookfield	131,000	1,200
Mixed Viscosity (cps) @77°F (25°C) Brookfield	91,000	
Work Time, 100g mass @ 77°F (25°C)	35 - 45 minutes	
Gel Time	60 minutes	
Demold Time @ 77°F (25°C)	6 - 8 hours	

INHIBITION:

Certain materials will cause inhibition or neutralization of the curing agent. These materials are sulphur containing and organometallic salt containing compounds such as organic rubbers and many condensation cured RTV silicone rubbers. Inhibition may easily be determined by brushing a small quantity of TC-5060 over a localized area of the surface to be reproduced. If the TC-5060 is gummy or uncured after the curing time, then you know the mold surface is acting as an inhibitor. Molds made from wood, plaster, metal or plastic should not cause inhibition if they are clean. To insure against possible problems, it is advisable to spray a barrier film (product RF-5124) over any questionable surfaces. This is the best way of treating clays and surfaces that cause inhibition.

STORAGE:

Store in a cool dry place. Unopened containers will have a shelf life of 12 months from date of shipment when properly stored at room temperatures. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING	Part A	Part B	Cubic Inches Per Kit
Quart Kits	2 lbs.	3.2 oz.	45.76
Gallon Kits	8 lbs.	13 oz.	183.04
5-Gallon Kits	40 lbs.	4 lbs.	915.20
55-Gallon Drum Kits	450 lbs.	45 lbs.	10,296

SAFETY PRECAUTIONS:

Use in a well-ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction.

Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product.

IF CONTACT OCCURS:

Skin: Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. It is *not* recommended to remove resin from skin with solvents. Solvent only increase contact and dry skin. Seek qualified medical attention if allergic reactions occur.

Eyes: Immediately flush with water for at least 15 minutes. Call a physician.

Ingestion: If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.