

Plat 10, 25, & 40

Silicone Mold Making Rubber

Product Description:

Alumilite's Plat 10, 25, and 40 silicone mold making rubber are 1:1, platinum base, FDA food compliant silicone rubber that are great for making molds of all kinds including resin, wax, soap, chocolate, sugar, fondant, ice, plaster, concrete, and more. The Plat 10 is extremely flexible and is great for making molds with extreme undercuts or molds for delicate casting materials such as chocolate and sugar. Plat 25 and 40 are great for one or two piece molds with undercuts. The Plat 10, 25, & 40 are low viscosity silicones that are extremely easy to mix and use. Degassing is not required but always recommended if available. The Plat 10, 25, and 40 reproduce extremely fine detail. When making 2 part molds, Alumilite's UMR mold release, Rubber to Rubber Mold Release, or Vaseline must be applied to prevent it bonding to itself. Plat 10, 25, and 40 are platinum base silicones and care must be taken to eliminate the possibility of contamination from items containing tin, sulfur, vinyl, amines, and organotin salts which may inhibit or prevent the silicone from curing where ever they come in contact with these elements.

Physical Properties:

	Plat 10	Plat 25	Plat 40
Color	Translucent	Translucent	Translucent
Mixed Viscosity (cps)	5,000	6,000	8,000
Hardness, (ASTM D-2240) Shore A	10	25	40
Specific Gravity	1.15	1.15	1.15
Shrinkage (in/in)	<.1%	<.1%	<.1%
Tensile Strength (ASTM D-638) (psi)	460	520	550
Elongation (in/in)	650%	550%	350%
Temperature Range (Degrees F)	-67 to 395	-67 to 395	-67 to 395
Tear Strength (ppi)	85	87	91

General Properties:

Color	"A" Side - Base "B" Side - Catalyst	Translucent Translucent
Mix Ratio	1:1 by wt. or vol.	
Shelf Life	1 year	
Pour Time at 75 Degrees F (100g mass)	35 minutes	
Demold Time at 75 Degrees F (100g mass)	16-24 hours	
Full Cure Schedule	7 days	

Packaging:	<u>Approximate Volume:</u>	
	2 lb	Quart Kit
10 lbs	1 gallon	
50 lbs	5 gallon	
80 lbs	10 gallon	
880 lbs	110 gallons	

Preparation:

If you are unsure what the original part or mold box is made of and you are not sure the Plat mold making rubbers will not inhibit, mix a small amount and pour a test spot over a non-cosmetic area of the part to be molded. Once you are sure the Plat rubbers will not contaminate, thoroughly clean and remove all dirt/contaminates. Make sure mold box and part are sealed to eliminate possibility of leakage or silicone wicking into the part. Mold release is required when pouring against another silicone if you do not want the two to bond, as when making two piece molds. Use Alumilite's UMR or a thin layer of Vaseline to avoid the two silicone pours from bonding to one another. Avoid contact with all porous materials such as fabric, clothing, carpet, and other non sealed materials.

Mix Instructions:

The proper mix ratio for Plat 10, 25, & 40 is 1:1 by wt or vol. Use an accurate scale and measure out equal parts of the A and B. Mix thoroughly, degas if possible, and pour slowly to avoid introducing air bubbles.

Read all MSDS and cautions on the bottle prior to using.