GT-1350 Standard Mold Making Silicone

GT Products® 1350 is a room temperature curing silicone rubber compound designed for the manufacture of flexible molds.

GT-1350 Features

- Low Viscosity
- Minimal shrinkage
- Medium Durometer

GT Products® 1350 is supplied in matched kits with Catalyst 1350 designed to be used in a 10:1 ratio by weight.

**Typical Properties**

<table>
<thead>
<tr>
<th></th>
<th>Base</th>
<th>Catalyst</th>
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</thead>
<tbody>
<tr>
<td>Color</td>
<td>White</td>
<td>Red or Clear</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.27</td>
<td>1.0</td>
</tr>
<tr>
<td>Viscosity (cPs)</td>
<td>80,000</td>
<td>1000</td>
</tr>
<tr>
<td>Mixed Viscosity</td>
<td>40,000</td>
<td></td>
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<tr>
<td>Pot Life (Pour Time)</td>
<td>60—90 Minutes</td>
<td></td>
</tr>
</tbody>
</table>

**After Cure (24 hours @ 25°C)**

- Tensile, psi: 650
- Elongation, % 300
- Durometer (Shore A) 50
- Tear (die B) minimum 50
- Linear Shrinkage; % nil

**Useful Temperature**

- Range °C (°F)
  - -60 — 232 (-75 — 450)

**Applications:**

- Hobby and art projects
- Silicone Print Pads
- Candle and Soap Molds
- Rapid Prototyping
- Special Effects
- Model Making
- Inventing
- Rollers
MIXING
Because pigments can settle during storage, Catalyst 1350 should be thoroughly stirred before mixing. Use separate tools for mixing the base and catalyst to avoid cross contamination. Accurate weighing is essential to obtain maximum physical properties from the cured silicone. Add the catalyst to the base and mix until the color is uniform. Low-shear mixing of the mixture is recommended. Use clean tools and scrape the bottom and sides of the container to assure a homogeneous mixture. Avoid stirring in an excessive amount of air.

DEGASSING
Air entrapped during mixing should be removed to prevent voids in the cured product. Deair the mixed material under a vacuum of 25 mm (29 inches) of mercury. The mixture will froth and, expand four times its volume, crest and recede to about the original level as the bubbles break. Degassing is usually complete about two minutes after frothing subsides.

CURING
GT Products® 1350 will cure sufficiently in 16 hours at room temperature (72°F) to be handled. GT 1350 will reach 90% of ultimate cure in 24 hours at room temperature. For full cure an additional 1-2 days at room temperature is required.

STORAGE and HANDLING
GT Products® 1350 will remain useful for six months when stored in the original unopened containers at temperatures below 80°F (27°C).

Accessories:
ER-200 Mold Release
GT Products Silicone Pigments
GT-5985 Primer for adhesion to metals and other substrates

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