



## Technical Data Sheet

### 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

	<b>Base</b>	<b>Catalyst</b>
Color	White	Red or Clear
Specific Gravity	1.27	1.0
Viscosity (cPs)	80,000	1000
Mixed Viscosity		40,000
Pot Life (Pour Time)		60—90 Minutes
<b>After Cure (24 hours @ 25°C)</b>		
Tensile, psi:		650
Elongation, %		300
Durometer (Shore A)		50
Tear (die B) minimum		50
Linear Shrinkage; %		nil
<b>Useful Temperature</b>		<b>-60 — 232</b>
<b>Range °C (°F)</b>		<b>(-75 — 450)</b>

Hobby and art projects

Silicone Print Pads

Candle and Soap Molds

Rapid Prototyping

Special Effects

Model Making

Inventing

Rollers

#### Applications:

## **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

The information, data, and suggestions contained herein are believed to be reliable, based upon our knowledge and experience; however, it is expressly declared that Seller does not guarantee the result to be obtained in Buyers' process. SELLER HEREBY EXPRESSLY DISCLAIMS ANY IMPLIED WARRANTY OF MERCHANTABILITY FOR FITNESS FOR A PARTICULAR PURPOSE AND/OR ANY OTHER WARRANTY, EXPRESSED OR IMPLIED as to any and all products and/or suggestions described herein, whether such products are used alone or in combination with other materials. Buyer must make its own determination of the suitability of a product for its use, and the completeness of any information contained herein. Nothing contained herein shall be construed to constitute inducement or recommendation to practice any invention covered by any patent without authority from the owner of the patent. Applicator is an independent contractor of, and should under no circumstances be viewed as an employee or agent of GT Products, Inc. or GT Products subsidiaries.