



Technical Data Sheet

GT-2135 High Performance Mold Making Silicone

GT Products® 2135 is a room temperature curing silicone rubber compound designed for the manufacture of flexible molds.

GT-2135 Features

Low Viscosity

Minimal shrinkage

Medium Durometer

GT Products® 2135 is supplied in matched kits with Catalyst 2135 designed to be used in a 10:1 ratio by weight.

Typical Properties

	Base	Catalyst
Color	Translucent	Clear
Specific Gravity	1.11	1.0
Viscosity (cPs)	104,000	1000
Mixed Viscosity		85,000
Pot Life (Pour Time)		60—90 Minutes
After Cure (24 hours @ 25°C)		
Tensile, psi:		850
Elongation, %		400
Durometer (Shore A)		35
Tear (die B) minimum		120
Linear Shrinkage; %		nil
Useful Temperature		-60 — 232
Range °C (°F)		(-75 — 450)

Applications:

Hobby and art projects

Silicone Print Pads

Model Making

Rapid Prototyping

Special Effects

Inventing

Rollers

MIXING

Because pigments can settle during storage, Catalyst 2135 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® 2135 will cure sufficiently in 16 hours at room temperature (72°F) to be handled. GT 2135 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® 2135 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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