



Technical Data Sheet

GT-6406 High-Performance Mold Making Silicone

GT Products® 6406 is a room temperature curing silicone rubber compound designed for the manufacture of flexible molds.

GT-6406 Features

Low Viscosity

Easy 1:1 mix

Low Durometer

Minimal shrinkage

GT Products® 6406 is supplied in matched kits with Catalyst 6406 designed to be used in a 1:1 ratio by weight.

Typical Properties

	Base	Catalyst
Color	Translucent	Translucent
Viscosity (cPs)	63,000	25,000
Pot Life (Pour Time)	45-90 Minutes	
After Cure (7 days @ 25°C)		
Tensile, psi:	450	
Elongation, %	300	
Durometer (Shore A)	20	
Tear (die B) minimum	100	
Linear Shrinkage; %	nil	

Applications:

Hobby and art projects	sculpture and figurines	Candle and Soap Molds
Rapid Prototyping	Special Effects	Model Making
Inventing	Rollers	Silicone Print Pads

MIXING

Because pigments can settle during storage, Catalyst 6406 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. Low-shear mixing of the mixture is recommended. Use clean tools and scrape the bottom and sides of the container to ensure 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. Dearth 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® 6406 will cure sufficiently in 16 hours at room temperature (72°F) to be handled. GT 6406 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® 6406 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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**501 Industrial Blvd, Grapevine, TX 76501 • (800)221-0866 or (817)481-7113
• fax (817)421-1211 • www.gtproducts.com • info@gtproducts.com**