Technical Data Sheet

GT-5090  High Performance Mold Making Silicone

GT Products® 5090 is a room temperature curing silicone rubber compound designed for the manufacture of flexible molds. This material has been designed to be used on basic shape patterns and low run molds.

GT-5090 Features

- Low Viscosity
- Resistance to Sulfur Based Clays
- Low Durometer

GT Products® 5090 is supplied in matched kits with Catalyst 5090 designed to be used in a 10:1 ratio by weight.

Typical Properties

<table>
<thead>
<tr>
<th></th>
<th>Base</th>
<th>Catalyst</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>White</td>
<td>Purple</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.12</td>
<td>0.98</td>
</tr>
<tr>
<td>Viscosity (cPs)</td>
<td>30,000</td>
<td>100</td>
</tr>
<tr>
<td>Mixed Viscosity</td>
<td>20,000</td>
<td></td>
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<tr>
<td>Pot Life (Pour Time)</td>
<td></td>
<td>60-90 Minutes</td>
</tr>
</tbody>
</table>

After Cure (7 days @ 25°C)

- Tensile, psi: 425
- Elongation, %: 550
- Durometer (Shore A): 8
  - (Shore 00): 55
- Tear (die B): 110
- Linear Shrinkage; %: 0.3-0.4
- Specific Gravity: 1.1

Applications:

- Hobby and art projects
- Foundry, sculpture, and figurines
- Candle and Soap Molds
- Rapid Prototyping
- Special Effects
- Model Making
MIXING

Because pigments can settle during storage, Catalyst 5090 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 to four times its original 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® 5090 will cure sufficiently in 16 hours at room temperature (72°F) to be handled. GT 5090 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® 5090 will remain useful for six months when stored in the original unopened containers at temperatures below 80°F (27°C).

Both GT Products® 5090 and catalyst-5090 are sensitive to moisture. Keep containers covered.

Accessories:

| ER-200 Mold Release | CA-5275 Fast Catalyst |
| GT Products Silicone Pigments | CA-5560 Ultra Fast Catalyst |

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