



## Technical Data Sheet

### GT-6595 High-Performance Mold Making Silicone

GT Products® 6595 is a room temperature, addition cure silicone rubber compound designed for the manufacture of flexible molds.

#### GT-6595 Features

Low Viscosity

Minimal shrinkage

Low Durometer

GT Products® 6595 is supplied in matched kits with 3 available catalyst listed below. Each catalyst is designed to be used in a 10:1 ratio by weight. Varying properties can be achieved by the use of each individual catalyst.

#### Typical Properties

	GT-6595 Base	CA-6595	CA-6596	CA-6597
Color	Translucent	Clear	Clear	Clear
Viscosity (cPs)	30,000	1000	1000	1000
Pot Life (pour time)		60—90	60—90	60—90
After Cure (7 days @25°C)				
Tensile, psi:		850	990	840
Elongation, %		570	675	725
Durometer (Shore A)		25	20	15
Tear (die B) Minimum		105	130	170
Specific Gravity	1.1			

#### 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 6595 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. 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® 6595 will cure sufficiently in 16 hours at room temperature (72°F) to be handled. GT 6595 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® 6595 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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