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**

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

**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. 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® 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

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 an 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.