



## Technical Data Sheet

### GT-6649 High-Performance Mold Making Silicone

GT Products® GT-6649 is a room temperature curing silicone rubber compound designed for the manufacture of flexible molds.

#### GT-6649 Features

High Strength	10:1 mix
High Durometer	Minimal shrinkage

GT Products® GT-6649 is supplied in matched kits with Catalyst 6649 designed to be used in a 10:1 ratio by weight.

#### Typical Properties

	Base	Catalyst
Mixed Viscosity (cPs)		25,000 cPs
Pot Life (Pour Time)		45-90 Minutes
<b>After Cure (7 days @ 25°C)</b>		
Tensile, psi:		800
Elongation, %		450
Durometer (Shore A)		40
Tear (die B) minimum		125
Linear Shrinkage; %		nil

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

#### Applications:

## **MIXING**

Because pigments can settle during storage, Catalyst 6649 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® GT-6649 will cure sufficiently in 16 hours at room temperature (72°F) to be handled. GT-6649 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® GT-6649 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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