



Technical Data Sheet

GT-6142 Mold Making Silicone

GT Products® 6142 is a room temperature curing silicone rubber compound designed for the manufacture of flexible molds. This material has been designed to be a mid-grade silicone with the properties of a premium mold making silicone.

GT-6142 Features

Lower Cost

High Tear Strength

Low Durometer

Resistance to Sulfur Based Clays

GT Products® 6142 is supplied in matched kits with Catalyst 6142 designed to be used in a 10:1 ratio by weight.

Typical Properties

	Base	Catalyst
Color	White	Orange
Viscosity (cPs)	50,000	100
Mixed Viscosity	46,000	
Pot Life (Pour Time)		60-90 Minutes
After Cure (7 days @ 25°C)		
Tensile, psi:	500	
Elongation, %	400	
Durometer (Shore A)	20-25	
Tear (die B) minimum	130	
Linear Shrinkage; %	0.3-0.4	
Specific Gravity	1.16	

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 6142 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 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® 6142 will cure sufficiently in 16 hours at room temperature (72°F) to be handled. GT 6142 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® 6142 will remain useful for six months when stored in the original unopened containers at temperatures below 80°F (27°C).

Both GT Products® 6142 and catalyst-6142 are sensitive to moisture. Keep containers covered.

Accessories:

ER-200 Mold Release

GT Products Silicone Pigments

Fast Catalyst

GT-6125 Thixotropic Additive

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