



Replication Technologies Limited
Unit 38, Hillgrove Business Park
Nazeing Road, Nazeing
Waltham Abbey
Essex
EN9 2HB
Tel: 01992 892 894
Fax: 01992 892 901
Email: enquiries@reptech.co.uk
Website: www.reptech.co.uk

ADSIL 25 P

ADSIL 25P is an addition-curing **RTV Silicone** mouldmaking rubber that has been developed specifically for the production of case moulds used for the production of plaster parts.

ADSIL 25P is characterised by low viscosity, excellent flow, good strength, extremely high elongation and long term stability.

ADSIL 25P is formulated to provide an intermediate hardness coupled with excellent handling and mechanical properties.

Degassing performance is extremely good; at least double the normal amount of mixed rubber may be degassed compared to other grades, and flow is also superior enabling large pours to be completed in less than the usual time.

PROPERTIES

Mixing Ratio A:B (volume)	8.5:1
Mixing ratio A:B (weight)	10:1
Colour	Red
Mixed viscosity	11000cps (viscosity increases on storage)
Density	1.18
Gel time @ 25 C	90 minutes
Hardness Shore 'A' (7 days R.T.)	25
Demould time @25C	18 hours/overnight
Tensile Strength	5.0 M.Pa.
Elongation at break	600%
Shrinkage under room temperature cure	<0.05%
Tear Strength	21 N/mm
Shelf life	12 months when stored in clean & dry conditions

INSTRUCTIONS FOR USE

Weigh the individual components on accurate scales. For optimum performance and material properties, the ratios of 'A' to 'B' should be better than +/- 3%. Mix intensively until the mixture is a homogeneous, creamy mass. It is strongly recommended that the mixed material should be poured into a second mixing vessel and remixed before pouring or degassing. Always mix in a vessel at least 5 times the volume being mixed. Failure to do so can lead to loss of material on degassing. If the surface has a 'marbled' finish on the surface following degassing, this is cosmetic but may be cured by stirring briefly and performing a secondary degassing.

Degas before pouring into the mould. If the master shape is a complex one or has undercuts, the mould should be subjected to a second degassing operation. Work quickly.

Inhibition is a source of problems for all Addition-curing RTV Silicones. Certain chemicals will interfere with the curing process, and in some instances can destroy the ability of the RTV to cure completely. Avoid tin based materials, sulphurous e.g. Natural rubber (including natural rubber gloves), neoprene and other materials that are well documented. If a cast is found to be sticky, cut the mould in half. If the centre of the mould is cured and dry, it proves the presence of surface inhibition

The information herein is offered in good faith based on Replication Technologies Ltd research and is believed to be accurate. However because conditions and methods of use of our products are beyond our control, this information shall not be used as a substitute for preliminary tests which are essential to ensure that our products are fully satisfactory for your specific applications before using them in a full scale production. Therefore unless RTL provides you with a specific written warranty of fitness for use, Replication Technologies Ltd sole warranty is that the products will meet Replication Technologies Ltd then current sales specification. Replication Technologies Ltd specifically disclaims any other express or implied warranty and your exclusive remedy and Replication Technologies Ltd sole liability for breach of warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted; Replication Technologies Ltd expressly disclaims any liability for incidental or consequential damages. Suggestions of use should not be taken as inducements to infringe any patent.