

TECHNICAL DATA

Ace 500 Silicone Rubber & Catalyst

Ace 500 Silicone Rubber is a two component silicone elastomer which crosslinks at room temperature by a polycondensation reaction. It produces a flexible elastic silicone material with excellent tear strength.

Uses

As moulds for making reproductions of objects of complex form with strong undercuts.

Characteristics

1.	Before catalysis Properties	Ace 500 RTV	Catalyst
	Aspect	Viscous liquid	Clear liquid
	Colour	Grey	Colourless to pale yellow
	Approximate Density at 25°C approx.	N/A	N/A
	Approximate Density at 25°C, mPa.s approx. <i>*Measured on a Brookfield viscosity, Spindle #6. Speed 5 r.p.m.</i>	40,000 - 50,000*	N/A
2.	Catalysis Ace 500	(by weight) 100 parts	(by Weight) 1 - 2 parts
3.	After addition of catalyst Process condition Results		
	Pot life of the catalysed mixture of 1% at 25°C approx and approximately 50% to 60% relative humidity.		40 minutes
	Pot life of mixture catalysed of 2% at 25°C approx and approximately 50% to 60% relative humidity.		20 minutes
	Time after which the elastomer can be handled at 25°C, catalysed at 2% Approximately and approximately 50% to 60% relative humidity.		3 to 4 hours
4.	After vulcanisation Process condition Measurements made after curing for 4 days at 25°C approximately and approximately 50% to 60% relative humidity.	Character Test	Results
	4.1.1 On specimen 6mm thick:	Shore A Hardness (ASTM D 2240)	Approximately 21+1 Points
	4.1.2 On film 2mm thick:	Tensile Strength (AFNORNFT46002)	Approximately 4.0 MPa – 4.5 MPa
		Ultimate Elongation (AFNORNFT46002)	Approximately 500% - 550%
		Tear Strength (ASTM D 624 Method A)	>23kN/m – 24 kN/m
		Linear shrinkage	Approximately 0.40% to 0.45%

TECHNICAL DATA

Ace 500 Silicone Rubber & Catalyst

Packaging

Ace 500 is supplied in 5 and 20 kilogram kits plus the required quantity of Catalyst .

Storage and Shelf Life

Ace 500 and Catalyst should be stored at a temperature below 30°C and be used within 12 months of delivery.

Safety

Please refer to the Safety Data Sheets on Ace 500 and Catalyst.

DISCLAIMER: The information in this bulletin and otherwise provided, is given in good faith and considered accurate, but it is intended only as a guide and does not constitute a guarantee on our part. No warranty is expressed or implied regarding the accuracy of the data, the results to be obtained by the use thereof, or that any such use will not infringe any patent, particularly in the case of legal action by a third party in connection with the use of our products. Before using, the user shall determine the suitability of the product for the intended use and user assumes all risk and liability whatsoever in connection therewith. The manufacturer reserves the right to make technical modifications to the product. These formulas must on no account be used as substitutes for prior tests, which are essential to ensure that the product is suitable for each specific case. In all cases, local regulations applicable to the use of our product should be checked.