



TC-5024 A/B

25 SHORE A SILICONE ELASTOMER

PRODUCT DESCRIPTION:

TC-5024 A/B is a two-component, room temperature curing silicone elastomer. This system is designed primarily for making molds, but is also used for gaskets as well as a wide variety of parts. This product is a condensation cured system using a tin catalyst that provides a 60-minute work time with a 4-6 hour demold time.

PRODUCT HIGHLIGHTS:

- Excellent physical properties with high tear resistance
- Fast demolds
- Can be used in many high-temperature applications
- Cures against various clays including "Roma"
- Provides excellent detail reproduction
- Exhibits long-term dimensional stability

PHYSICAL PROPERTIES:

Hardness, Shore A ASTM D 2240-04e1	25 ± 5
Density, (g/cc) cured ASTM D792-00	1.21
Cubic Inches per Pound	23.2
Color/Appearance.....	Blue/Opaque
Tensile Strength, (psi) ASTM D 412-98a(2002)e1	590
Tensile Modulus, (psi) ASTM D 412-98a(2002)e1:	
100 %	44
200 %	144
300 %	280
Elongation, (%) ASTM D 412-98a(2002)e1	350
Tear Strength, (pli) ASTM D 624-00e1.....	110
Shrinkage, (in/in) linear ASTM D 2566-.....	0.0025

Note: Reported physical properties are based on a 7 day room temperature cure.

HANDLING PROPERTIES:

Mix Ratio (by weight):	
Part A	100 parts by weight
Part B	10 parts by weight
Mix Ratio (by volume):	
Part A	100 parts by volume
Part B	12 parts by volume
Specific Gravity:	
Part A	1.22
Part B	1.00
Viscosity, (cps) @ 77°F (25° C) Brookfield:	
Part A	61,000
Part B	60
Mixed.....	31,000

HANDLING PROPERTIES (continued):

Color:

Part A	Off-white
Part B	Blue
Work Time (100 gram mass) @ 77°F (25°C)	30-40 minutes
Gel Time	50-60 minutes
Demold Time @ 77°F (25°C)	4-6 hours

MIXING:

TC-5024 A/B is processed by adding curing agent "B" at a ratio of 10 parts by weight to 100 parts by weight of "A". TC-5024 "B" side is tinted blue so that when mixing the "A" and "B" sides together, the colorant in the "B" side will provide a visible means of insuring that a uniform mix is acquired. Mix for 2 to 3 minutes in a clean container, then transfer material to another clean container and mix for another 2 to 3 minutes.

INHIBITION:

New molds made with tin catalyzed silicones often have a tendency to inhibit the cure of various urethane materials that are cast against the silicone. Postcuring a new mold at 150° F for 24 hours may reduce the cure inhibition problem in most cases. It is also recommended that the mold surface be washed thoroughly with soap and warm water then dried before use.

STORAGE:

Store in a cool dry place. Unopened containers will have a shelf life of 6 months from date of shipment when properly stored at room temperatures. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING:

Quart Kits	2 lbs. A, 3.2 oz. B
Gallon Kits.....	8 lbs. A, 13 oz. B
5 Gallon Kits.....	40 lbs. A, 4 lbs. B
Drum Kits	450 lbs. A, 45 lbs. B

SAFETY PRECAUTIONS:

Use in a well-ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction.

Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product.

IF CONTACT OCCURS:

Skin: Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. It is *not* recommended to remove resin from skin with solvents. Solvent only increase contact and dry skin. Seek qualified medical attention if allergic reactions occur.

Eyes: Immediately flush with water for at least 15 minutes. Call a physician.

Ingestion: If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.

Refer to the Material Safety Data Sheet before using this product.

NON-WARRANTY "Except for a warranty that materials substantially comply with the data presented in Manufacturer's latest bulletin describing the product (the basis for this substantial compliance is to be determined by the standard quality control tests generally performed by Manufacturer), all materials are sold "AS IS" and without any warranty express or implied as to merchantability, fitness for a particular purpose, patent, trademark or copyright infringement, or as to any other matter. In no event shall Manufacturer's liability for damages exceed Manufacturer's sale price of the particular quantity with respect to which damages are claimed."