RTV 134 *Condensation Cure Silicone Rubber* *23 Shore A Hardness*

RTV 134 is a two-component condensation cure, low viscosity silicone rubber. Suitable for mould making, producing replicas of polyester, epoxy resins, urethane foam and wax etc. It can precisely reproduce the shape of the original model.

RTV 134 has exceptionally high tear strength and good elongation.

Special Features

- Cures at room temperature within 2 – 8 hours
- Low viscosity
- Easy to demould
- Excellent tear strength and tensile properties
- Low shrinkage

Mix Ratio

	RTV 134 :	**C134**
By Weight	100 :	2 – 5

Product Data

Property	**Units**	**RTV 134**	**C134**	**Mix**
Material	-	Base Rubber	Catalyst	Silicone rubber
Appearance	-	White liquid	Clear liquid	White liquid
Viscosity (25°C)	mPa.s	17,000 – 23,000	10 – 20	14,000 – 20,000 (5% Catalyst)

Cure Time

Property	**Units**	**2% C134**	**3% C134**	**4% C134**	**5% C134**
Pot Life (200g, 25°C, 50%RH)	hours & minutes	1h 30 min – 2h	65 – 85 mins	45 – 65 mins	20 – 40 mins
Cure Time (200g, 25°C, 50%RH)	hours	6 – 8	4 – 6	2 – 4	2 – 3

* %RH = Relative Humidity

Cured Properties

Cured for 7 days at room temperature.

Property	**Standard**	**Units**	**Result**
Hardness	BS 2782: Part 3: Method 365B	Shore A	21 – 25
Linear Shrinkage	500 x 50 x 10 mm	%	< 0.3
Tensile Strength	BS 2782: Part 3: Method 320A	MPa	3.5 – 4.0
Elongation at Break	BS 2782: Part 3: Method 320A	%	420 – 460
Tear Strength	BS 903: Part A3	kN/m	24 – 26

Mould Preparation

Ensure the master mould is clean, dust and dirt free. If the master is made of glass or ceramic, it is possible that the silicone rubber may stick to it, so a release agent is advisable. We recommend Aerosol/Paste Wax Release Agent .

Mixing and Pouring Instructions

Use clean containers, which have a capacity for the rubber to expand to at least five times its volume during degassing e.g. if 1kg is being mixed, use a 5 litre container. Add the Catalyst to the RTV at the correct ratio. Accurate weighing is essential. Mix the Catalyst into the RTV immediately. The product should be mixed thoroughly, paying particular attention to the sides and bottom of the mix vessel. Care should be taken to avoid entrapping too much air during mixing. RTV 134 will self degas, but to achieve best results the product should be de-aired under vacuum. When vacuuming, the material will expand to approximately five times its original volume and collapse, it is at this point the material has been successfully vacuumed. Pour the vacuumed silicone rubber uniformly all over the surface of the master. Any bubbles must be broken with positive air pressure or by passing a spatula gently across the surface. For intricate moulds degas again ensuring there is sufficient room in the mould box for expansion of the rubber. When degassing use 40 mbar vacuum, degassing is completed about 1 minute after the frothing ceases. Mould life and tear strength are improved with degassing.

Curing

Atmospheric temperature and humidity differ from season to season. In winter months the pot life and curing time will be nearly twice their summer values. To carry out curing more rapidly, raise the room temperature to 20 – 30°C. Demould will also depend on the catalyst level used, see the “Cure Time” section.

Thixotropy

RTV 134 can be made thixotropic with the addition of RTV Thixo. The catalyst should be thoroughly mixed into the RTV as standard, and then RTV Thixo should be added at a level of 1 – 3%. The maximum layer thickness for RTV 134 with thixotropic additive is 10mm.

Storage

RTV 134 and CATALYST C134 should be stored in original, unopened containers between 15 and 25°C. Always tightly reseal containers after use. Air, moisture or other contamination causes a reduction in reactivity over time.
If stored under the above conditions, RTV 134 will have a shelf life of 6 months, from the date of production.

Packaging

RTV 134 is supplied in 1kg, 5kg or 20kg packs.
CATALYST C134 is supplied in 50g, 250g or 1kg packs.

Further Information

This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum.

Our technical advice, whether verbal, or in writing is given in good faith, but without warranty – this also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by us as to their suitability for the intended process and use.

Before using any of our products, users should familiarise themselves with the relevant Technical and MSDS provided by ABL.