

SILICONES and more

Wacker Elastosil FX additives

Description

ELASTOSIL® FX additives are used to adapt the Wacker FX silicone to your needs. Slow down, speed up, soften and thicken. It is all possible with these materials.

Soften with FX Softener

The Elastosil FX Softener, is used to soften the FX silicone. Mix the A and B component of the silicone well and only then add the softener.

The table indicates the percentage of softener by weight over the entire mixture. Addition of 15% Softener approximately halves the hardness. Example: 100 grams FX 20 A with 100 grams FX 20 B and 30 grams Softener gives a hardness of Shore A 10

With a larger addition, the end result will become a bit stickier (more tacky).

Sample Calculation Starting with ELASTOSIL® FX 20 and Adding a Certain Percentage [%] of Softener												
FX Softener [%]	0	5	10	15	20	25	30	35	40	45	50	
Shore A	20	17	13	10	8	6	5	3	2	---	---	Shore A
Shore 00	---	---	---	---	50	45	43	34	25	20	18	Shore 00
Tack	-	-	-	-	-	(-)	(-)	(+)	+	++	++	Tack

Sample Calculation Starting with ELASTOSIL® FX 10 and Adding a Certain Percentage [%] of Softener												
FX Softener [%]	0	5	10	15	20	25	30	35	40	45	50	FX Softener [%]
Shore A	10	8	7	6	3	3	2	1	---	---	---	Shore A
Shore 00	---	50	48	38	33	30	25	18	13	11	0	Shore 00
Tack	-	-	-	-	(-)	(-)	(+)	+	++	++	+++	Tack

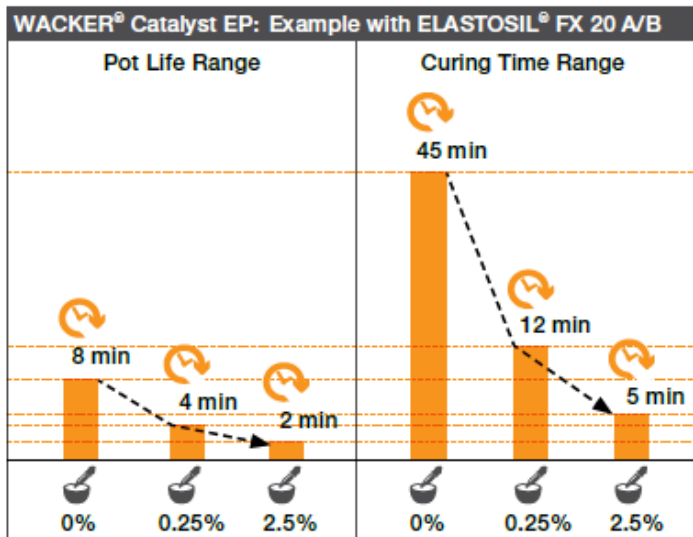
- non-tacky
(-) very slight
(+) slight

+ more
++ strong
+++ very strong

Calculation example for [%]: A/B + 10%, e.g. 100 g A + 100 g B + 20 g Softener

Speed up with Catalyst EP

Mix the A and B component well. If desired, you can now soften the silicone with the softener. Only then add a few drops of Catalyst EP / accelerator to shorten the processing time and curing time. This is especially useful with silicones that are applied to the skin so that the model does not have to stand for too long. About 20 drops per 100 grams of FX silicone mixture halves the pot life and curing time.



These figures are intended as a guide and should not be used in preparing specifications.

Drop Dosing Recommendation: WACKER® Catalyst EP (for Small Volumes)		
Drops	Pot life/Working time	Curing time
0	8 min	35 min
7 – 10	6 min	20 min
20 – 25	3 min	10 min

Note: the above schedule applies to drops per 100 grams of Elastosil FX A/B.



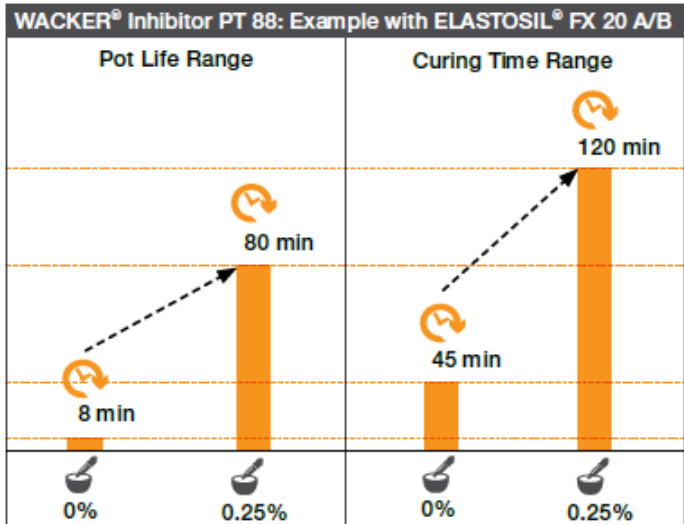
Properties

- Safe to use on the skin
- Very versatile system

SILICONES and more

Slow down with inhibitor PT 88

Mix the A and B component well. If desired, you can now soften the silicone with the softener. Only then add a few drops of PT 88 / retarder to extend the processing time and curing time. This is especially useful for thick or complicated shapes where air bubbles must be allowed to escape for a long time or where the silicone must be able to be processed wet in wet. About 12 drops per 100 grams of FX silicone mixture gives a ten times longer working time.



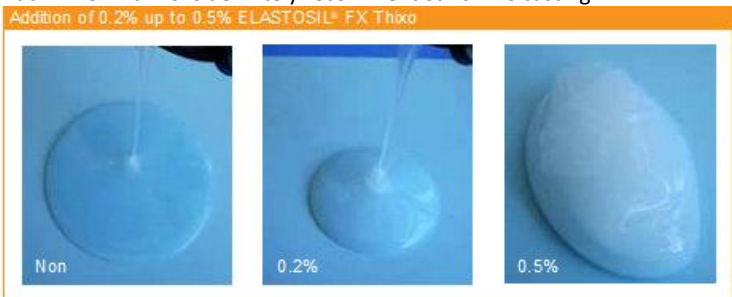
Drop Dosing Recommendation: WACKER® Inhibitor PT 88 (for Small Volumes)

Drops	Pot life/Working time	Curing time
0	8 min	35 min
8 – 10	60 min	90 min
12 – 16	80 min	120 min

Please note: the above schedule applies to drops per 100 grams of Elastosil FX A/B.

Thicken with FX Thixo

Mix the A and B component well. Then, if desired, soften and speed up/slow down and only thicken as the very last step. This is especially useful when working on angled or vertical surfaces where the silicone should not run off too much. The FX thixo is definitely recommended for life casting.



Drop Dosing Recommendation: ELASTOSIL® FX Thixo (for Small Volumes)

Drops	Flow
0	Best flow
0 – 10	Medium flow
20 – 25	No flow

Please note: the above schedule applies to drops per 100 grams of Elastosil FX A/B

Shelflife

ELASTOSIL® FX Silicone A/B is best stored between 5°C and 30°C in the tightly closed original packaging. The expiration date of each batch is printed on the product label. Storage after the date stated on the label does not necessarily mean that the product is no longer usable. In this case, however, the properties required for the intended use must be checked for quality assurance reasons.

Safetymeasures

Components A and B of the addition curing class ELASTOSIL® FX Silicone A/B contain only components that have not been shown to be toxic or aggressive over many years. No special precautions for handling are therefore required, i.e. only general industrial hygiene practices apply. Detailed safety information is included in the safety data sheet.