

## Silicone Condensation DC 3481 F

These easy to use Silicones are ideal for making molds in a relatively short time

### Description

The silicone Condensation DC 3481 with the catalyst 3081 F is a professional 2-component (poly-condensation curing) castable molding silicone which cures at room temperature. The silicone has a good fluidity and gives great detail while still remaining strong. Silicone DC 3481 F is excellently suited for making quick moulds for the casting of eg cement, plaster, wax, soap, and many other casting materials.

### Technical data

Mixing ratio (weight)	[A:B]	100:5
Pot life@ 23°C	[Min]	30-45
Viscosity mixture @ 23°C	[mPa s]	22.100
Hardness	[Shore A]	23
Tensile strength	[Kg/cm <sup>2</sup> ]	46
Tear strength	[Kg/cm]	26
Extensability till break	[%]	543
Linear shrinkage	[%]	0.2-0.4
Demold time max @23°C @50% RH	[Hours]	6
Full strength after	[Days]	3

Note: Pot life and de-mould time are highly dependent on the mixing ratio and Humidity! By adding more than 5% silicone B (hardener) or at high humidity, the pot life and de-mould time are shorter.

### Processing

The silicone DC 3481 with catalyst 3081 F can easily be mixed by hand or by machine. Mix the A and B component carefully and in the indicated ratio (preferably 5%, you can add between 4 and 6% B comp)

Example: To 1 kg of A-Comp add preferably 50 grams of B-component. You can vary between 40 grams (4%) up to 60 grams (6%). Less or more will inhibit cure or alter the final properties of the rubber.

At 4%, the silicone will take longer to harden giving air bubbles more time to escape. With 6% B component the silicone will cure considerably faster. Process the mixture in the pot life and never take more than you can handle within pot-life. Only de-mould after a complete cure. If you wish to make a mold by using a brush or spatula you need to add a 3rd component (0.6% -2% Thixo C). Typically 1% will do the trick. Thixo C thickens the mixture and makes it possible to set up the silicone against vertical surfaces. Please be aware that the mold in this case must be provided with a support cap. This support cap may consist of gypsum bandages or epoxy support cover or acrylic resin with glass fibre fabric.

### Packing

The products are packaged in packs of 5 Kg or 25 Kg or 200 Kg kg of A-component and 250 grams or 1.25 Kg or 10 Kg of B-component. All components can also be ordered separately. For larger packages we ask you to contact us through the site.

### Durability

Provided that the silicone is kept in a sealed package and stored cool and frost-free, the shelf life is at least 1 year.

### Safety

If you frequently work with the silicone is recommended to wear during processing gloves and properly ventilate the area. For safety instructions, see always the safety data sheet.



### Characteristics

- Good liquid (self-deairing)
- Easy to mix
- After curing strongly
- Low shrinkage (<0.3%)
- Colour White
- Non-Bleeding
- Relatively fast