Technical Data Sheet

Viscolo 22 Addition Cure RTV

Two part coloured RTV silicone rubber – easy use 1:1 mixing

Viscolo 22 is a bi-component addition cured RTV silicone rubber, particularly recommended for making objects in polyester resins and concrete. It is also compatible with all plasters, coatings, polyurethane resins, acrylic resins and polyester resins.

Special Features

- Coloured parts indicate when product is mixed
- 1:1 Mix Ratio
- Near Zero Shrink
- Shorter Potlife
- Better Tear Strength
- Very Low viscosity

Mix Ratio

	Viscolo 22 A	:	**Viscolo 22 B**
By Weight	1	:	**1**
By Volume	1	:	**1**

Product Data

Property	Units	Viscolo22A	Viscolo22B	Mix
Material	-	Base	Catalyst	RTV Silicone
Appearance	-	Coloured Liquid	Coloured Liquid	Coloured Liquid
Viscosity (25°C)	cP	4000 ± 500	4000 ± 500	4000 ± 500
Density (25°C)	g/cm^3	1.01	1.01	1.01
Pot Life (200g, 25°C)	Minutes	-	-	14-17
Demould Time (200g, 25°C)	Hours	-	-	1-1.5

Cured Properties

Properties	Standard	Units	Result (Full Cure)
Hardness	Shore Scale	Shore A	21 ± 2
Linear Shrinkage	-	%	0 ± 0.05
Tensile Strength	-	N/mm	4 ± 1
Elongation at break	-	%	380 ± 20
Service Temperature	-	°C	-50 to +180

Method of Use

Former prep: Ideally coat with a gloss polyurethane varnish for a glossy mould face.

Assess the volume of material required to make your mould. This can be done by filling the mould cavity with dry rice/beans etc and measuring the volume they occupy. Consider mixing extra for contingency, though if you run short, additional material can be mixed and poured on and will bond well.

If mixing by volume, half the volume calculated and add Part A to a clean graduated mixing vessel. Add the same volume of part B and stir for 1-2 minutes ensuring a complete homogenisation of both parts.

All to stand for 2-3 minutes to degass (or degass in a vac chamber) and then pour into the low corner of your mould box. A steady slow pour will help with air release.

Fine details can be pre coated before the pour using a brush, visual inspection should be made for air bubbles and entrapments.

If using the weight system, the volume calculated above in CC should be halved and converted to grams. Eg 500cc = 500g

Allow to cure for the prescribed period noted above. This can be accelerated with the introduction of heat, however speeding the cure process may affect the final properties and create a weaker less long lasting mould.

If in doubt about any cure inhibition, PLEASE test a small amount of material first.

Storage

Store product at room temperature where possible and do not allow to fall below 10 Celsius without being cured. Where possible do not exceed 27 Celsius as this may provoke the material to set.

Keep containers tightly closed and DO NOT accidentally swap lids of the products as this may cause setting of the material

Kept in these conditions shelf life is considered to be 12 months.

Further Information

All data listed relates to typical values. This data should not be considered a product specification.

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