

Polycraft™ RTV-3481 Base
Polycraft™ RTC-10F / 10VF Curing Agent

High strength silicone moldmaking rubber

Features & Benefits

- Outstanding release properties
- High flowability and long working time
- Medium hardness
- High tear resistance
- High elasticity, for easy removal of, complex replica parts
- Can be made thixotropic (nonflowable) for vertical surface replication
- Choice of curing agents for special applications

Applications

- Polycraft™ RTV-3481 Base is suited for the detailed reproduction of figures, art objects and similar items.

Typical Properties

Specification Writers: These values are not intended for use in preparing specifications.

Base and Curing Agent mixture (100:10 by weight)			
Color	Off-White		
Relative density at 25°C (77°F) of cured rubber	1.21		
	Polycraft™ RTC 10F / VF Curing Agents		
	RTC-10F (Red)	RTC-10F (Clear)	RTC-10VF (Green)
	Fast	Fast	Very Fast
Working time of catalyzed mixture at 23°C (73.4°F), minutes, min	40-60	40-60	20-30
Mixed viscosity, mPa.s	18,000	18,000	18,000
Cured for 2 days at 23°C (73.4°F)			
Hardness (Shore A)	27	27	27
Tensile strength, MPa	3.0	3.0	3.0
Elongation at break,%	520	520	520
Tear strength, kN/m	23	23	23
Linear shrinkage, %	0.2-0.5	0.2-0.5	0.2-0.5
Curing time, hours, max	6-8	6-8	2-4

Description Polycraft™ RTV-3481 Mould-Making Rubber is a two-component material consisting of Polycraft RTV-3481 Base which when mixed with a Polycraft™ RTC-10F / VF Mould-Making Curing Agents, cures at room temperature by a condensation reaction. A range of materials can be cast into the cured silicone mold: plaster, polyurethane and polyester resins are materials typically used.

How To Use **Substrate Preparation**
The surface of the original should be clean and free of loose material. If necessary, and in particular with porous substrates, use a suitable release agent such as petroleum jelly or soap solution.

Mixing

Thoroughly stir Polycraft RTV-3481 Base before use, as filler separation may occur upon prolonged storage. Weigh 100 parts of Polycraft RTV-3481 Base and 10 parts of Polycraft RTC-10F or 10VF Curing Agent in a clean container. Mix together until the curing agent is completely dispersed in the base. Hand or mechanical mixing can be used, but do not mix for an extended period of time or allow the temperature to exceed 35°C (95°F). Mix suitably small quantities to ensure thorough mixing of base and curing agent. It is strongly recommended that entrapped air be removed in a vacuum chamber, allowing the mix to completely expand and then collapse. After a further 1–2 minutes under vacuum, the mix should be inspected and can be used if free of air bubbles. A volume increase of 3–5 times will occur on vacuum de-airing the mixture, so a suitably large container should be chosen.

Caution: prolonged vacuum will remove volatile components from the mix and may result in poor thick section cure and non-typical properties.

Note: If no vacuum de-airing equipment is available, air entrapment can be minimized by mixing a small quantity of Polycraft RTV-3481 Base and Polycraft RTC-10F or 10VF Curing Agent, then using a brush, painting the original with a 1–2 mm layer. Leave at room temperature until the surface is bubble free and the layer has begun to cure. Mix a further quantity of base and curing agent and proceed as follows to produce a final mold.

Pouring The Mixture And Curing

Pour the mixed Polycraft RTV-3481 Base and Polycraft RTC-10F Curing Agent as soon as possible onto the original, avoiding air entrapment. The catalyzed material will cure to a flexible rubber within 24 hours (or faster when Polycraft RTC-10VF Curing Agent is used) at room temperature (22–24°C / 71.6–75.2°F) and the mould can then be separated from the material. If the working temperature is significantly lower, the cure time will be longer. If the room temperature or humidity is very high, the working time of the catalyzed mixture will be reduced. The final mechanical properties of the mold will be reached within 7 days.

Additional Information (Cont.)

Reproduction of vertical surfaces if a skin mold is required of a vertical object or surface and cannot be made by normal pouring techniques, the catalyzed mixture can be made nonflowable by the addition of **Polycraft Silicone Thixo Additive**.

1. Prepare the original as described earlier.
2. Brush the original with a thin layer of catalyzed mixture. Repeat the operation when the first layer has started to cure, to achieve a coating thickness of > 2 mm. Leave to cure at room temperature until the material is tacky.
3. Prepare a new catalyzed mixture of **Polycraft RTV-3481 Base** and add 3% by weight of **Polycraft Silicone Thixo Additive** and mix thoroughly until a paste consistency is reached. De-airing of the mixture is not required.
4. Using a spatula, cover the coated original with the thixotropic coating until all undercuts are filled; leave to cure for 24 hours, or less if **Polycraft RTC-10VF Curing Agent** is used, at room temperature.
5. Construct a support mould using polyester resin or plaster and allow to set in contact with the silicone coating. Carefully remove the support mould. Peel the rubber off the original and place in the support mould.

Other Curing Agents

The standard curing agent for **Polycraft RTV-3481 Base** is **Polycraft RTC-10F Curing Agent** and **RTC-10VF Curing Agent**.

- **Polycraft RTC-10F Curing Agent** for demolding after 6-8 hours.
- **Polycraft RTC-10VF Curing Agent** for demolding after 2-4 hours.

Use At High Temperatures

Some molds produced from condensation cure silicone rubbers can degrade when exposed to temperatures above 150°C (302°F) over a period of time or when totally confined in storage at high ambient temperatures. This can result in softening and loss of elastic properties.

Please contact a distributor for further advice.

Resistance To Casting Materials

The chemical resistance of fully cured **Polycraft RTV-3481 Base** is excellent, and similar to all condensation cure silicone elastomers. It should be noted however that ultimately, resins and other aggressive casting materials will attack silicone molds, changing physical properties, surface release and possibly mold dimensions. Molds should be checked periodically during long production runs.

Note: **Polycraft RTV-3481 Base** is an industrial product and must not be used in food molding, dental and human skin molding applications.

Handling
Precautions

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE ON THE MBFG WEBSITE AT WWW.MBFG.CO.UK, OR BY CALLING MBFG CUSTOMER SERVICE ON +44 (0)2890 861992.

Usable Life And
Storage

Product should be stored at or below 32°C (89.6°F) in original, unopened containers.

Limitations

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

Health And
Environmental
Information

For further information, please see our website, www.mbfg.co.uk

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