



Polycraft FS30 RTV

Food Safe Addition Curing RTV Silicone Rubber

10:1	1 Hour	16 Hours	White	Shore A28	 20-25°C	1.1kg by weight Equals approx. 1 Litre in Volume
Mix Ratio By Weight	Pot Life (23°C)	Demould Time (23°C)	Cured Colour	Hardness	Working Temperature	Approximate Density

Technical Overview

Property	Component	Value
Material	A B	Base Curing Agent
Appearance	A B	Viscous Liquid Viscous Liquid
Colour	A B	Colourless White
Viscosity (mPas) @23°C	A B	25000 8000
Density @ 23°C g/cm3	A B	1.1 1.1
Mix Ratio (by weight)	A&B Mix	10A:1B

Property	Unit	Value
Nominal Hardness	Shore A	28
Tensile Strength	mPa	7.5
Cured Colour	-	White
Elongation	%	600
Tear Strength	KN/m	20
Linear Shrinkage	%	0.1
De-Mould Time (@ 23°C)	Hours	16
Full Cure (@23°C)	Days	7

Storage / Shelf-life

Polycraft FS30 RTV should be stored between 18°C and 25°C. Under these conditions, shelf-life in the original, unopened containers is six months. Care should be taken to avoid contact with moisture as this is a moisture sensitive product.

Store in a dry place and reseal containers immediately after use.

Technical Advice provided by MB Fibreglass - Either verbal, in writing or by way of trials - is given in good faith but without warranty, where proprietary rights of third parties are involved this applies also. This does not release you from the obligation to test the products supplied by us to ascertain their suitability for the intended processes and uses. The application, use, handling and processing of the products are outside of our control and therefore entirely your own responsibility.

MB Fibreglass

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Product Overview

Polycraft FS30 RTV is a medium viscosity food safe addition curing rtv silicone rubber which produces flexible moulds with excellent reproduction, mechanical resistance and good durability. Polycraft FS30 RTV is produced for the intention of moulding objects in chocolate, sugar, marzipan, confectionery biscuits and other baked products. Given its outstanding tensile and tear strength it can also be used across a wide range of different moulding applications.

Instructions for Use

Mixing

Combine material at a ratio of 100 Parts A to 10 Parts B and mix thoroughly until well combined.

Degassing

After mixing Part A & B it is recommend to eliminate entrapped air by degassing under a vacuum of 30 to 50 mbar (0.8 to 1.5inHg). The material will expand 3 to 4 times its original volume, forming bubbles before collapsing, after the initial collapse of material release vacuum and repeat again after a few minutes for best results. Whilst it is recommend to degas for best results it is not a necessity and with care the material can be poured into a mould slowing away from the object to be moulded and good results can be still be easily obtained.

Curing / Cure Inhibition

Room temperature conditions are best, higher temperatures will lead to a shorter potlife and faster cure time, lower temperatures will increase viscosity, potlife and cure time. To minimize shrinkage its not recommend to cure at temperatures over 60°C. Certain materials / compounds can cause cure inhibition on this material, such as latex rubbers, condensation cure rtv, PVC stabilisers, amine cured epoxies and sulphur based clays (this is a non exhausted list, if unsure please test by applying a small patch of mixed material to your item / substrate).

Fat based products such as chocolate should not exceed 2 hours in the mould and mould temperatures should not exceed 40°C during this period, other foodstuffs can be used without any particular precautions in terms of contact, duration and temperatures (while remaining within the temperature range compatible with the heat stability of silicone elastomers).

Approvals

Approved by the regulations in force in the following countries:

France: Journal Officiel, Brochure 1227

Germany: BGA, chapter XV-A

United States: FDA Regulations, CFR-2 1

This document is not a compliance certificate.

Health and Safety

Before use please read product labels, technical sheets and safety data Sheets and ensure you have adequate understanding of the safety precautions and directions before using the materials.

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