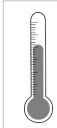




Technical Data Sheet
Art. No. (4640190118)

Polycraft K4

Translucent Addition Curing RTV Silicone

A : B 1 : 1 (By weight)	90 Minutes (At 20°C)	8-9 Hours (At 20°C)	Translucent	Shore A40	 (20°C)	1.1kg by weight equals approx. 1 Litre in Volume
Mix Ratio	Pot Life	Demould Time	Cured Colour	Hardness	Working Temperature	Approximate Density

Key Features

- **Translucent**
- **Easy Mix Ratio**
- **Addition Cure**
- **Long Potlife**
- **High Strength**
- **Easily Pigmented**
- **No odour**
- **Reproduces Fine Detail**

Technical Overview

Properties	Component	Value
Material	A+B Mix	RTV Silicone
Colour	A	Translucent
	B	Translucent
Viscosity (mPas) @25°C	A+B Mix	40000
Density 20°C g/cm3	A	1.08
	B	1.08
Pot Life (Min.)	A+B Mix	90
Curing Time (Hrs.)	A+B Mix	8-9

Properties	Component	Value
Tensile Strength	MPa	> 6.0
Elongation At Break	%	380 (approx)
Resistance to Tear	N/mm	> 25.0
Shore Hardness	Shore A	40

Measure / Mix

Before use, ensure that parts A & B are at room temperature (20°C). Surface and air temperatures should be above 15°C during application and for the entire curing period. At higher or lower temperatures pot-life and cure time can be significantly affected.

Part A & Part B are mixed by hand using a ratio of 1A:1B by weight. (Example 100g A : 100g B) Mixing accuracy is important as imprecise ratios will affect the cure.

Scrape the sides and bottom of the mixing vessel multiple times to ensure adequate mixing taking care not to splash or spill.

Key Information

Inhibition

Inhibition may occur when the silicone comes in contact with amines, plastilines, metal salts, sulphides, tin catalyst, onion, garlic, latex etc. To avoid any inhibition problems, we recommend you run a test to ensure compatibility of the silicone and your object to be moulded.

Pigmentation

This silicone will readily accept pigment. Its important to use silicone pigments. We recommend the polycraft silicone pigments with a typical addition rate of 1% to 5% by weight. If using other sources of silicone pigments we recommend testing to ensure compatibility.

Storage and Shelflife

Open each container individually and remove the appropriate amount of material before closing and opening the second. Ensure there is no cross contamination between each product as this is likely to cause a degree of curing of the products within the containers which will result in wasted material. Ensure lids are replaced tightly. We recommend using the materials within 3 months however the products will easily last up to 6 months if stored in the correct conditions (between 10°C to 27°C) well aired cupboard out of direct sunlight.

Safety Precautions

Safety First! Goggles, gloves and appropriate mask whilst working in a well ventilated area is highly recommended. Always read the SDS before use.

Potlife / Working Time

Once Part A & Part B have been combined and mixed thoroughly you will have approximately 90 minutes before the silicone begins to set. Once the material begins to set it will quickly become unusable. Mix only what you can use within the time frame.

Product Overview

An ideal material for areas of moulding where model visibility is important. In order to obtain good visibility this silicone will require degassing to remove all the dissolved air within the mix. Without degassing visibility will be greatly reduced. A vacuum pressure of 29hg is typically sufficient.