

**WACKER**

CREATING TOMORROW'S SOLUTIONS

ELASTOSIL®

Wacker Chemie AG
Hanns-Seidel-Platz 4
81737 München, Germany
Tel. +49 89 6279-0
Fax +49 89 6279-1770
info@wacker.com

www.wacker.com

Your local partner



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MOLDMAKING | **PRODUCT OVERVIEW**

FORM HAS NO LIMITS.
ELASTOSIL®-HIGH QUALITY
SILICONE RUBBER

The data presented in this brochure are in accordance with the present state of our knowledge but do not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this brochure should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. The information provided by us does not absolve the user from the obligation of investigating the possibility of infringement of third parties' rights and, if necessary, clarifying the position. Recommendations for use do not constitute a warranty, either express or implied, of the fitness or suitability of the product for a particular purpose.

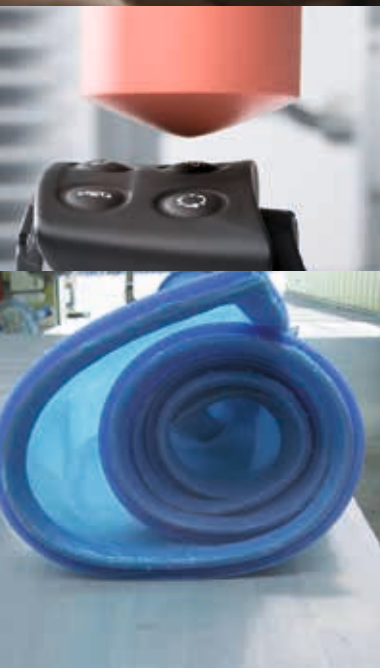
FORM HAS NO LIMITS. WITH ELASTOSIL® SILICONE RUBBER ...

Whatever it is that needs to be copied, printed or manufactured – experts around the globe rely on ELASTOSIL® silicone rubber from European silicone producer WACKER.



Moldmaking

For decades, ELASTOSIL® M silicone rubber has been the ideal solution for the production of cured articles with high elasticity, excellent release properties and optimum durability. These invaluable processing properties make ELASTOSIL® M indispensable, whether to industrial or to artisan moldmakers.



Printing Industry

ELASTOSIL® RT silicone rubber grades are essential basic materials for pad printing on account of their outstanding flow properties and short demolding times.

Composites

Thanks to ELASTOSIL® C, reusable vacuum bags can be manufactured. So even intricate geometries lend themselves to high production runs.

... FROM WACKER, THE EUROPEAN SILICONE PRODUCER

ELASTOSIL® silicone rubber grades are available as condensation-curing and addition-curing systems. Thanks to their consistency, reactivity and the properties of the cured rubber, they offer users immense scope.

Addition-Curing Grades

Maximum precision for complex Moldmaking, because they cure without shrinking, addition-curing ELASTOSIL® silicone rubber grades ensure dimensionally accurate molds for

- Prototypes
- Industrial mass production
- Composites industry
- Concrete moldings

Condensation-Curing Grades

Faithful reproductions achieved cost effectively condensation-curing ELASTOSIL® silicone rubber grades provide maximum mold-making accuracy for versatile applications

- Restoration
- Decorative arts
- Museums
- Archeology

This brochure contains an overview of the properties and incredibly diverse range of applications opened up by ELASTOSIL® silicone rubber grades.

Please don't hesitate to contact our technical support team if you have specific questions concerning your application.

Just call us! We'll be happy to advise you.

ADDITION-CURING
GRADES

ELASTOSIL®													
Product	Properties		Consistency	Color	Mixing Viscosity	Density	Hardness	Tensile Strength	Elongation at Break	Tear Strength	Mixing Ratio A : B	Pot Life at 23 °C	Demolding Time
					[mPa•s]	[g/cm3]	[Shore A]	[N/mm2]	[%]	[N/mm]	[wt.-%]	[min]	[h]
M 4115 A/B	Very soft; high heat resistance, high thermal conductivity	A	Pourable	Translucent	2,500	1.05	17	3.0	400	5	1 : 1	12	1
M 4118 A/B	Soft; high heat resistance, high thermal conductivity	A	Pourable		2,500	1.10	20	3.5	400	4.5	1 : 1	6	0,5
M 4125 A/B	Soft	A	Pourable	Translucent	6,000	1.05	25	5.0	500	25	1 : 1	60	12
M 4370 A/B	Hard	LM	Pourable	Reddish brown	8,000	1.43	55	3.0	130	4	9 : 1	80	6
M 4600 A/B	Soft; ■ ◆	A	Pourable	Translucent	15,000	1.10	20	7.0	800	20	10 : 1	90	12
M 4601 A/B	Soft; ■ ◆	A	Pourable	Reddish brown	10,000	1.13	28	6.5	700	30	9 : 1	90	12
M 4615 A/B	Very soft; ■ ◆	A	Pourable	Blue	5,000	1.03	13	3.0	700	10	100 : 15	90	12
M 4630 A/B	Soft; ■ ◆	A/CM	Pourable	White	10,000	1.13	28	6,5	700	0	10 : 1	90	12
M 4635 A/B	Medium hard; ■ ◆	A/CM	Pourable	White	15,000	1.14	37	7.0	480	30	10 : 1	90	12
M 4641 A/B	Medium hard	RPT	Pourable	Transparent	30,000	1.07	43	4.5	300	28	10 : 1	90	15
M 4642 A/B	Medium hard; ■	A	Pourable	Dark red	15,000	1.14	37	7.0	550	30	10 : 1	90	12
M 4643 A/B	Medium hard	A	Pourable	Gray	25,000	1.35	48	5.0	300	10	9 : 1	70	12
M 4644 A/B	Medium hard; slightly oil-bleeding	RPT	Pourable	Transparent	50,000	1.07	40	5.5	400	28	10 : 1	90	15
M 4645 A/B	Medium hard; strongly oil-bleeding	RPT	Pourable	Transparent	35,000	1.06	40	5.0	330	28	10 : 1	90	15
M 4670 A/B	Hard	RPT, A	Pourable	Beige	80,000	1.34	55	5.5	300	12	10 : 1	90	12
RT 620 A/B	Very soft; ■	PP	Pourable	Translucent, pigmentable	20,000	1.05	17	5.0	900	12	10 : 1	35	4
RT 623 A/B	Medium hard; ■	PP	Pourable	Reddish brown	10,000	1.12	31	7.5	700	30	9 : 1	30	5
RT 629 A/B	Medium hard; antistatic	PP	Pourable	Turquoise	8.000	1.13	31	6.0	500	25	10 : 1	40	3
C 1200 A/B	Soft	CO	Spreadable	Blue	20,000	1.05	25	5.0	500	25	1 : 1	20	1

A = all-round grade
LM = especially for low melting metal alloys
CM = especially for concrete molding
RPT = especially for rapid prototyping
PP = especially for pad printing
CO = especially for composite applications

■ very high mechanical strength
◆ very high elasticity

Wacker Chemie AG is certified to ISO 9001 and ISO 14001.

The figures and information contained in this table are intended as a guide only.
You can obtain detailed information from your technical advisor.

CONDENSATION-CURING GRADES

ELASTOSIL®															
Product	Properties		Consistency	Color	Mixing Viscosity	Density	Hardness	Tensile Strength	Elongation at Break	Tear Strength	Linear Shrinkage after 7 Days	Catalyst	Dosage	Pot Life *	Demolding Time *
					[mPa•s]	[g/cm3]	[Shore A]	[N/mm2]	[%]	[N/mm]	[%]		[wt.-%]	[min]	[h]
M 1470	Hard	A	Kneadable	Pink	> 1,000,000	1.28	50	4.5	230	10	0.2	Paste T 40	2	70	5
M 3502	Soft; ■ ◀▶	A ¹⁾	Spreadable, Non-sag	White	> 1,000,000	1.24	26	4.5	450	23	0.4	T 21 / T 51	5	65	9
M 4400	Soft	A	Pourable	Pale yellow	25,000	1.30	23	2.0	250	3	0.7	T 37	3	90	12
M 4440	Medium hard	A	Pourable	Beige	20,000	1.22	37	2.5	200	3	0.4	T 37	3	80	10
M 4470	Hard; high heat resistance, high thermal conductivity	LM	Pourable	Reddish brown	10,000	1.44	60	4.5	120	4	0.8	T 37	3	90	24
M 4500	Very soft; ◀▶	A	Pourable	White	20,000	1.20	14	3.0	450	15	0.6	T 12	3	60	7
M 4503	Soft	A	Pourable	White	40,000	1.16	25	5,0	350	20	0.5	T 35	5	90	20
M 4511	Very soft; ■ ◀▶	A ¹⁾	Pourable	White	20,000	1.22	12	3.5	600	18	0.4	T 21 / T 51	5	75	10
M 4512	Soft; ■ ◀▶	A ¹⁾	Pourable	White	25,000	1.19	20	3.5	500	24	0.4	T 21 / T 51	5	75	10
M 4514	Soft; ■ ◀▶	A ¹⁾	Pourable	White	25,000	1.25	25	4.5	450	25	0.4	T 21 / T 51	5	75	10
M 4541	Soft; ■	A ¹⁾	Pourable	White	30,000	1.16	32	5.0	400	30	0.4	T 21 / T 51	5	75	10
RT 402	Very soft; antistatic	PP	Pourable	Gray	13,000	1.28	11	2.0	350	3	0.3	T 12	3	75	5

A = all-round grade

¹⁾ = outstanding resistance to polyester and polyurethane resins

PP = especially for pad printing

LM = especially for low melting metal alloys

■ very high mechanical strength

◆ very high elasticity

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* at 23 °C / 50% rel. humidity