

Stretch FX 2 part moldmaking material

Description	Property	Test Method	Value
This is a soft, colourless, pourable 2-part addition cure silicone elastomer system. Due to its high elongation, fast cure and physical strength it is particularly suitable for use in replicating skin for prosthetics and special effects in theatre and film. After mixing parts 'A' and 'B' in the correct proportions, the system will cure at ambient temperatures within 5 hours, the rate of cure can be accelerated by heat.	Uncured Product		
	Color A		Translucent
Key Features	Color B		Translucent
	Cure Profile		RTV heat accelerated Addition
• Low viscosity • Fast de-mold time • High elongation (>1200%) • Excellent flexibility, translucent and pigmentable	Cure Type		6 - 8 hrs
	De-mould Time / Full Cure at 23°C/73°F		10:1
Application Special effects, skin replication, pigmentable	Mix Ratio By Weight		Liquid
	Rheology		1.12
Use and Cure Information	Specific Gravity A		0.98
	Specific Gravity B		25,000 cP
IMPORTANT: The 'A' part of product contains the platinum catalyst; great care should be taken when using automatic dispensing equipment. Please ensure that it is not contaminated by residual hydride containing rubber in the dispensing equipment, as curing will result. If in doubt, it's advised to thoroughly purge the equipment with a suitable hydrocarbon solvent or silicone fluid.	Viscosity A	Brookfield	2,000 cP
	Viscosity B	Brookfield	10,000 cP
Mixing Both the 'A' and 'B' parts should be well stirred to ensure the material is uniform and any settlement of the fillers have been remixed. In order to achieve optimum performance, the same "A" and "B" side lot number should be used. Place the required amount of 'A' and 'B' parts by weight at the mix ratio shown opposite, in a clean plastic or metal container of approximately 3 times their volume, and mix until the colour of the mixture is uniform. For best results, we recommend degassing. Degass by intermittent evacuation, the larger volume of the mixing vessel helps prevent overflow during this operation. In case of automatic dispensing with static mixing head, the two components should be degassed before processing. Recommended vacuum conditions are 30-50 mbar intermittently over 5-10 minutes. Cast the mixture either by gravity or pressure injection.	Viscosity Mixed	Brookfield	30 minutes
	Work life at 25°C to Double Initial Viscosity		30 minutes
Inhibition of Cure Great care must be taken when handling and mixing all addition cured silicone elastomer systems, ensuring that all the mixing tools (vessels and spatulas) are clean and constructed in materials which do not interfere with the curing mechanism. The cure of the rubber can be inhibited by the presence of compounds of nitrogen, sulphur, phosphorus and arsenic; organotin catalysts and PVC stabilizers; epoxy resin catalysts and even contact with materials containing certain of these substances e.g. moulding clays, sulphur vulcanised rubbers, condensation cure silicone rubbers, onion and garlic.	Cured Product		
	3 days at 25°C		
Health & Safety Safety Data Sheets available on request.	Color		Translucent
	Elongation at Break	ISO 37	1,200 %
Packaging CHT Moulding Rubbers are available in a variety packaging including bulk containers. Please contact our sales department for more information.	Hardness Shore A	ASTM D 2240-95	22
	Linear Shrinkage (%)		<0.1 %
Revision Date 11 Oct 2021 Revision No 3 Download Date 03 Jul 2024	Max Working Temp		204 °C / 399 °F
	Min Working Temp		-55 °C / -67 °F
The data offers a guide to the rate of cure at various temperatures. Mixing of the components at temperatures between 15 and 25°C is recommended to ensure adequate pot life for degassing and handling. The pot life can be extended to several hours by chilling the components before mixing.	Tear Resistance (N/mm)	BS ISO 34-1	17.4 N/mm / 99 ppi
	Tensile Strength	ISO 37	3.45 N/mm² / 500 psi
Storage Max Storage Temperature Shelf Life	38 °C / 100 °F		
	24 mths		