



## In brief

Silicone casting rubber. 1:1 mixing ratio. Mix very well. Approx. 30-50 minutes working time at 25 degrees. Cured after 4-6 hours.

## Application

The Resion Silicone Rubbers 1:1 are universally applicable liquid casting rubbers for making molds, flexible objects, impressions, and more. These silicone rubbers are available in 4 different Shore A hardnesses, so a suitable choice can always be made, appropriate for the application.

## Properties

- Simple mixing ratio
- Easy to mix
- Fast curing
- Tear-resistant
- Long lifespan
- Food-safe

## Processing Instructions

Mix the A and B components well separately. Then dispense 1 part by weight of component A and 1 part by weight of component B, and mix them carefully together. Frequently scrape the bottom and walls of the mixing cup while doing this. Then pour the mixture into a second mixing cup, scraping the first one empty. Mix again to ensure a homogeneous mixture. Especially with the translucent version, it is difficult to determine whether everything is mixed properly. Therefore, mix carefully and long enough.

After mixing, pour the silicone into the deepest part of the mold.



## Technical Data

- Shore hardness: Shore 8, Shore 15, Shore 25, Shore 40
- Mixing ratio: 1:1
- Working time: 30-50 minutes
- Curing time: 8 hours (tack-free)
- Heat resistance: 250°C long-term, 300°C short-term
- Color:
  - Shore 8: dark pink
  - Shore 15: blue or translucent
  - Shore 25: green
  - Shore 40: black or translucent
- Colors may deviate in incidental cases

Type	Color	Mixing ratio	Working time at 25°C (min)	Curing time (hours)	Hardness (Shore A)	Tensile strength (MPa)	Tear strength (kN/m)	Viscosity mixed	Shrinkage (%)	Elongation (%)
Shore 8	A: red B: white	1:1	30-50	4-6	8±2	3.5	17	1400±300	<0.1	>670
Shore 15	A: blue B: white or A: translucent B: translucent	1:1	30-50	4-6	15±2	4	20	2000±300	<0.1	>700
Shore 25	A: green B: white	1:1	30-50	4-6	25±2	5.5	25	3000±300	<0.1	>680
Shore 40	A: black B: white or A: translucent B: translucent	1:1	30-50	4-6	40±2	6.5	12	5800±500	<0.1	<400

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## Tips

Before casting, the silicone can also be applied with a brush to prevent air bubbles on the surface.

During the first 10 minutes of the working time, the silicone rubber is at its thinnest. This is when air bubbles rise most easily. Try to process the silicone rubber as quickly as possible.

For a bubble-free result, a vacuum degassing chamber can also be used to remove air from the mixture before casting, or a pressure pot can be used to compress the remaining air bubbles after casting.

## Additives

3 additives are available for silicone rubber:

- **Silicone oil** can be added in low dosages up to 15%. The addition of silicone oil lowers the Shore hardness of the final product. Always do a test to see if the final product meets the requirements.
- **Silicone thickener** can be added to thicken the silicone rubber into a paste during processing. This makes the silicone rubber suitable for brushing instead of casting. This way, the silicone rubber can also be used vertically and even overhead, for example, for molding ceiling decorations.
- **Silicone pigment** gives the silicone a different color. This is primarily used in the translucent silicone rubber. Do not use more pigment than indicated; this is a very low concentration of pigment. High concentrations of pigment can cause curing problems.

## Cure inhibition

Addition silicones are based on a curing reaction under the influence of a platinum hardener. To prevent curing problems, we provide the following tips:

- Do not mix the silicone with condensation-cure silicones; do not even use reused mixing cups or stir sticks that have been mixed with condensation silicone.
- Do not mix the silicone with organic materials such as compounds containing sulfur, nitrogen, or phosphorus, or ionic substances containing tin, arsenic, mercury, or phosphorus. Some types of clay or sealant may contain these products. If in doubt, do a test beforehand.
- Do not mix pigments into the silicone before testing them for suitability.



## Handling

Use latex or nitrile gloves and safety glasses.

## Storage and Shelf Life

Store dry and dark. Always close packaging tightly to prevent moisture absorption. Avoid UV light.

Under these conditions, silicone rubber has a shelf life of at least 2 years.

## Troubleshooter

For solving any problems, use the online troubleshooter for silicone rubber. This can be found at:

<https://polyestershoppen.com/info/probleemoplosser-siliconenrubber>