



## EAGLE SEAL RTV AKD 40 A FOR GRC MOLD MAKING

### AKD 40 A



#### PRODUCT DESCRIPTION

AKD 40 A is a two-part condensation cure silicone rubber. It is used for mould making where it is mixed with its catalyst and then poured around a pattern to create a flexible silicone mould.

#### USES

The mold made of AKD 40 A silicone rubber mainly used for products which are made from unsaturated polyester, epoxy, polyurethane resin, gypsum, concrete, Crafts, Furniture part and assembly, Lighting parts, Soap molds, other decorating products. It can be also used in fields such as Leather printing, Transfer printing rubber head and other elastic products.

#### FEATURES

- Excellent fluid property
- Good mold release property
- Weather resistance
- Thermal resistance
- Chemical resistance

#### PROPERTIES

<b>Color</b>	White/Translucent
<b>Mixing ratio</b>	100:3 by weight
<b>Hardness</b>	40±2 A
<b>Viscosity</b>	27000±2000 MPa.s
<b>Tear strength</b>	≥22 KN/m
<b>Tensile strength</b>	≥4.1
<b>Elongation break</b>	≥240%
<b>Linear shrinkage</b>	≤0.3
<b>Working time</b>	30-45 min
<b>Curing time</b>	8-10 hrs
<b>Shelf life</b>	12 month

We can adjust all the properties according to customers requirements.

#### MIXING

Use clean containers. If you will be degassing the silicone in a degassing chamber ensure you use containers which have capacity for the rubber to expand to at least five times its volume during degassing e.g. If 1 kg is being mixed, use a 5 litre container. Add the catalyst to the silicone at the correct ratio. Accurate weighing is essential. Mix the catalyst into the silicone immediately. The product should be mixed thoroughly, paying particular attention to the sides and bottom of the mix vessel. Care should be taken to avoid entrapping too much air during mixing, especially important if you won't be vacuum degassing. 30 grams (Ratio) of catalyst to each 1 kg.

#### PREPARATION

Ensure the master mould is clean, dust and dirt free. If the master is made of glass or ceramic, it is possible that the silicone rubber may stick to it, so a compatible release agent is advisable.

#### POURING

Start by carefully pouring the silicone all over the surface of the master. Burst any air bubbles on the surface by gently pressing them with a spatula. This way we can ensure that no air is trapped around cavities or details of the master. Once the master is lightly covered all over with silicone start filling the set-up box completely with the remaining silicone. It is preferable to pour the compound at one point in the mould box so as to ensure not to trap any air within the compound. If you have a degassing chamber you can degas again now that the silicone has been poured.



## CURING

Atmospheric temperature and humidity vary from season to season. In winter months the pot life and curing time will be nearly twice their summer values. Demould will be 6-8hrs depending on ambient temperature and humidity.

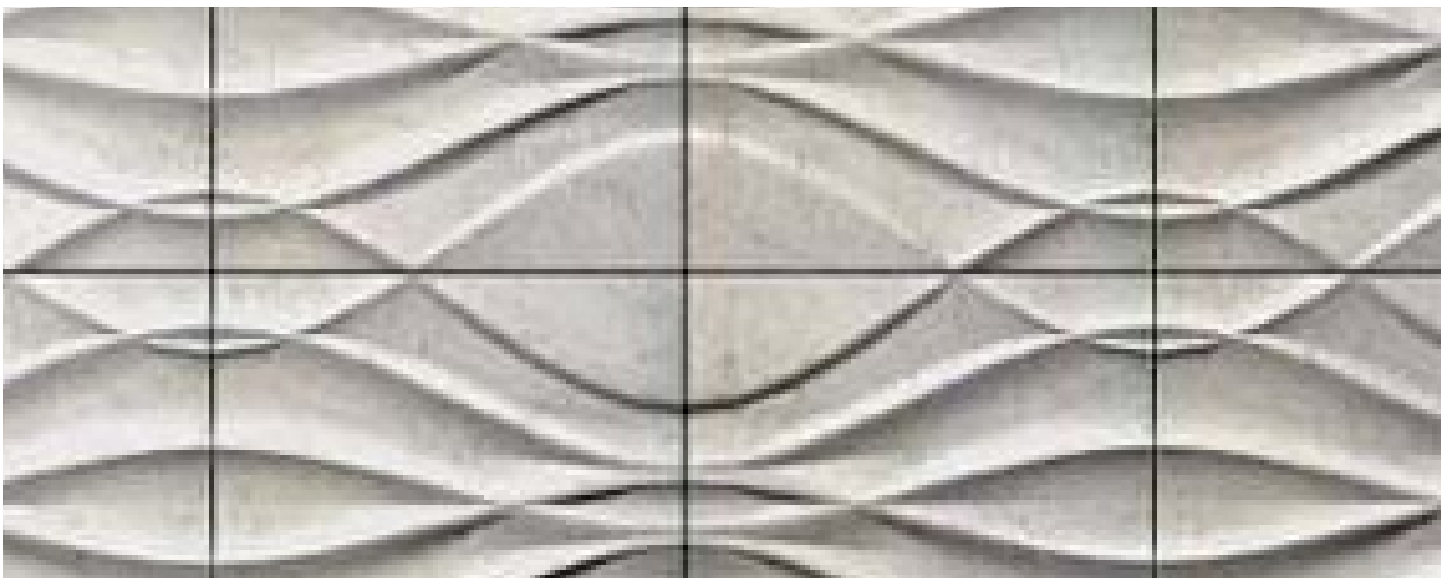
## PACKAGE

Part A (silicone) : 1kg / bottle, 5kg / drum, 20kg / drum, 25kg / drum, and 200kg / drum

Part B (catalyst) : 40g / bottle, 0.2kg / bottle, 1kg / bottle, and 2kg / bottle

## STORAGE

AKD 40 A and its catalyst should be stored in original, unopened containers between 15 and 25°C. Always tightly reseal containers after use. Air, moisture or other contamination causes a reduction in reactivity over time. If stored correctly our AKD liquid silicone rubber will have a shelf life of 12 months, from the date of production.



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