

KE 1604 Moldmaking Silicone

Featuring:

- High durometer
- Suitable for urethane foam systems
- Superior tensile strength
- Easy release

KE1604/cat1604T is a high strength, high modulus moldmaking/potting compound of the addition polymerization type. Its good tear resistance, high durometer hardness, low shrinkage and easy release make an excellent moldmaking material for urethane foams and other organic plastics.

GENERAL PROPERTIES

Before Cure

Appearance	blue/off-white
Mix Ratio	10:1
Viscosity (cps)	100,000
Pot Life (min)	1.5 hrs

After Cure (100°C for 10 min.)

Specific Gravity (@ 25°C)	1.26
Hardness	60 Shore A
Tensile Strength	1000 psi
Elongation	170%
Tear Strength	95 ppli
Linear Shrinkage	< 0.1%

RECOMMENDED CURE SCHEDULE

24 hrs	at	25 C
60 min	at	50 C
30 min	at	100 C
20 min	at	150 C

STORAGE AND SHELF LIFE

Shin-Etsu Silicones recommends storage below 80 F in a cool, dry place. If stored in recommended conditions, shelf life is 12 months from date of shipment.

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