

Technical Data Sheet

Product Code	Silcon60
Product Description	Uncured silicone rubber intensifier material - colour Orange Supplied as milled and pressed sheet - approx 12mm (½") thick Maximum usage temperature 230°C

General Description	Uncured silicone rubber compound for use as an intensifier to aid definition / intensification of the laminate during the cure - especially in intricate detail areas. It is also used as an infill within void areas of tooling, to ease bagging and reduce the chance of bag burst.
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Properties

Colour:	Orange
Density:	1.25 g / cc ³
Maximum Usage Temperature:	230°C (continuous)
Hardness (when cured):	60 Shore A
Thickness:	Supplied nominally 12mm thick
Cure Parameters:	
Time / Temperature	60 mins @ 80°C
Time / Temperature	45 mins @ 120°C
Time / Temperature	30 mins @ 150°C

Curing Instructions:	Press into place within the tooling void or on the area of the laminate to be intensified. Ensure that the Silcon60 is separated from the laminate by release film and that additional release film is used to separate the Silcon60 from the breather fabric. Cure under vacuum in an oven or autoclave under the above time / temperature conditions. Silcon60 will cure before the resin does and therefore, will intensifier the laminate cure stage of the resin.
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General (repeat) Usage:	Place the cured infill / intensifier in place during the lay-up stage and separate from the breather fabric using release film. Note, the life of the intensifier will be reduced if it is not separated from the curing resin by a layer of release film. Where the moulded profile of the intensifier allows, it is recommended that the intensifier is covered by a layer of PTFE release tape.
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Storage Conditions:	The uncured material has a shelf-life of 6 months when stored at 25°C, or 24 months when stored in a freezer.
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IMPORTANT INFORMATION:

The information cited is in good faith and has been established from sources held to be secure and reliable. The values listed are typical properties and are not intended to be used as specifications for defined applications. Users must determine the product suitability for the end use application and assume all risks and liabilities.

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