

# RTV2 Silicone Rubber XTX45

1. Measure 10 parts (by weight) of the catalyst (Part A).
2. In a separate container, measure 1 part (by weight) of the base (Part B).
3. Pour Part B into the Part A container.  
**Note:** make sure that the container is large enough to allow for mixing and for vacuum rise in Step 5.
4. With clean equipment, mix vigorously until the color of the product is homogeneous.  
**Note:** working time begins at this step. Working time is approximately 90 minutes from the start of the mixing process at 73 °F (23 °C). If the temperature exceeds 73 °F (23 °C), the working and setting times are decreased. For example, if the temperature is 104 °F (40 °C), the working time is halved and the setting time is approximately halved. If the temperature is less than 73 °F (23 °C), both the working and setting time are increased considerably. For example, if the temperature is 39 °F (4 °C), the working time doubles and the setting time increases to 45 hours (three times the setting time at 73 °F [23 °C]).
5. Place container under vacuum and vacuum until material bubbles and rises. Release vacuum and repeat until bubbles are removed.
6. Pour the mixed silicone into the mold. Maintain the pouring stream in the same spot so as to minimize introduction of air bubbles into the mold.
7. Allow the mold to sit, undisturbed, for at least 15 hours to ensure the silicone is fully cured.  
**Note:** setting time can be altered by altering the temperature at the time of mixing (see Step 4 for details).
8. Remove the mold from the frame.
9. Cut around the pattern carefully to release it from the silicone rubber mold. It may be necessary to use compressed air to facilitate the separation of the mold and the rubber. It is important not to force this separation with sharp objects that can deform the final stamp. RTV2 silicone rubber XTX45 is compatible with all gypsums, coatings, polyurethane resins and acrylic resins.



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Rubber XTX45



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## Important Recommendations

- The surfaces with which the material enters in contact must be perfectly clean, free of grease and dry.
- Close the bottles after use so as not to confuse the cap of the catalyst with that of the base when re-sealing.
- Shelf life of the base and catalyst is 12 months, if stored correctly at a temperature between 41°F-80°F (5°C-27°C).
- Be aware of possible cross-contamination; it's highly recommended to use only dedicated equipment for processing base and catalyst.
- Be aware that contact with certain materials can inhibit the curing of the silicone, avoid the following contaminants:
  - Natural or synthetic rubber, vulcanized with sulphur derivatives.
  - Poly-condensation RTV catalyzed with metallic salts.
  - PVC stabilizing agents.
  - Amine cured epoxies.
  - Sulphur, tin and amines derivatives.
- Ensure that the package is hermetically sealed each time it is used.

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