# ELASTOSIL® M 3646 A/B

RTV - 2 SILICONE RUBBER / MOLD MAKING

**Product description**

Pourable, addition-curing, two-component silicone rubber that vulcanizes at room temperature.

**Special features**

- very good flow
- fast and non-shrink cure at room temperature which can be accelerated considerably by the application of heat
- medium Shore A hardness (approx. 43)
- good transparency of the cured rubber
- no oil bleeding
- high tear strength
- outstanding resistance to casting resins
- larger number of prototypes in rapid prototyping

**Application**

High-performance silicone mold-making compound which is particularly suitable for reproducing models with undercuts in polyurethane or epoxy resins.

Main field of application:
Vacuum casting for rapid prototyping especially suitable if crystal-clear casting resins are used.

**Processing**

Important note:
The platinum catalyst is in component A.

Important:
A and B components may only be used together if they have the same batch number.

Comprehensive instructions are given in our leaflet "ELASTOSIL® - PROCESSING RTV-2 SILICONE RUBBERS".

Detailed information on other mold-making compounds in the ELASTOSIL® M range is contained in our brochure "ELASTOSIL® M. Mold-Making Compounds For Maximum Precision".

**Storage**

The 'Best use before end' date of each batch is shown on the product label.

Storage beyond the date specified on the label does not necessarily mean that the product is no longer usable. In this case however, the properties required for the intended use must be checked for quality assurance reasons.

**Additional information**

Please visit our website www.wacker.com.

**Safety notes**

Components of the addition-curing grade ELASTOSIL® M 3646 A/B contain only constituents that over many years have proved to be neither toxic nor aggressive. Special handling precautions are therefore not required, i.e., only the general industrial hygiene regulations apply.

Comprehensive instructions are given in the corresponding Material Safety Data Sheets. They are available on request from WACKER subsidiaries or may be printed via WACKER web site http://www.wacker.com.

## Product data

| Typical general characteristics | Inspection Method | Value |
|---|---|---|
| **Product data (uncured)** | | |
| **Component A** | | |
| Color | | translucent |
| Density at 23 °C | | 1,08 g/cm³ |
| Viscosity at 23 °C, after stirring | ISO 3219 | 50000 mPa s |
| **Component B** | | |
| Color | | colorless |
| Density at 23 °C | | 0,97 g/cm³ |
| Viscosity at 23 °C, after stirring | ISO 3219 | 400 mPa s |
| **Product data (catalyzed A + B)** | | |
| Mix ratio (pbw) | A : B | 10 : 1 |
| Viscosity at 23 °C | ISO 3219 | 30000 mPa s |
| Pot life at 23 °C, up to 150000 mPa s | | 90 min |
| Cure time, tack-free | | 12 h |
| **Product data (cured)** | | |
| Color | | translucent |
| Density at 23 °C in water | ISO 2781 | 1,07 g/cm³ |
| Hardness Shore A | ISO 868 | 43 |
| Tensile strength | ISO 37 | > 4,50 N/mm$^2$ |
| Elongation at break | ISO 37 | > 300 % |
| Tear strength | ASTM D 624 B | > 25 N/mm |
| Linear shrinkage | | < 0,1 % |

Vulcanizate after 24 h at 23 °C
These figures are only intended as a guide and should not be used in preparing specifications.

The data presented in this medium are in accordance with the present state of our knowledge but do not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this medium should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. The information provided by us does not absolve the user from the obligation of investigating the possibility of infringement of third parties' rights and, if necessary, clarifying the position. Recommendations for use do not constitute a warranty, either express or implied, of the fitness or suitability of the product for a particular purpose.

The management system has been certified according to DIN EN ISO 9001 and DIN EN ISO 14001

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For technical, quality, or product safety questions, please contact:

Wacker Metroark Chemicals Pvt. Ltd
D.H. Road, Chandi,
24 Parganas (S)
West Bengal – 743 503

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