

Product Name

ELASTOSIL® M4601 A/B Wacker RTV-2 Silicone Rubber

Product Description

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

- Very Good Flow
- Low Shore A Hardness (approx 28)
- Fast non-shrink cure which can be accelerated considerably by the application of heat
- Excellent long-term stability of the mechanical properties of the cured rubber.
- High tear strength
- Outstanding resistance to casting resins.

Typical Applications

Due to its outstanding resistance to casting resins as well as superior mechanical properties, Elastosil® M4601 is perfectly suitable for all moulds of models with pronounced undercuts that are to be reproduced in casting resins.

Physical Properties

Product Data / Uncured

Components			A	B
Colour			White	Red Brown
Density @ 23°C		[g/cm ³]	1.14	1.01
Viscosity @ 23°C, after stirring	Brookfield	[mPa s]	25 000	800

Product Data / Cured – After 24 hours @ 23°C

Density at 23°C, in water	ISO 2781	[g/cm ³]	1.13
Hardness, Shore A	ISO 867		28
Tensile Strength	ISO 37	[N/mm ²]	6.5
Elongation at Break	ISO 37	[%]	700
Tear Strength	ASTM D 624, B	[N/mm]	> 30
Linear Shrinkage		[%]	<0.1
Coefficient of Linear Expansion	0-150°C	[m/m K]	2.4 x 10 ⁽⁻⁴⁾

Handling Properties

Product Data / Catalysed

Mixing Ratio	A : B	[parts by weight]	9 : 1
Colour			Red Brown
Viscosity @ 23°C	Brookfield	[mPa s]	20 000

Processing

Important – The platinum catalyst is contained in Component B.

Caution – Only Components A and B with the same batch number may be processed together.

The table below indicate the pot lives and curing times at various temperatures.

The pot life figures indicate the time required for the mix to attain a viscosity of 60 000 mPa s.

Curing times apply to a layer thickness of 1cm.

Temp °C	Pot Lives	Curing Times
-15°C	>2 days	
5°C	6 hr	
15°C	3 hr	
23°C	90 min	12 hr
30°C	40 min	
35°C		3 hr
70°C		20 min
100°C		10 min
150°C		5 min

Storage

Elastosil® M4601 has a shelf life of at least 12 months in the sealed container between 5°C and 30°C. If the material is kept beyond 12 months it is not necessarily unusable, but a test should be performed on the product to check suitability to the application.

Notes

Further information on processing silicone can be found in the Wacker leaflet “Processing RTV-2 Silicone Rubbers”. Check with your Barnes Representative for a copy of this leaflet.

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Revision Number

3

Disclaimer

The data presented in this leaflet are in accordance with the present state of our knowledge, and does 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 leaflet 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. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the product for a particular purpose.