

WACKER

CREATING TOMORROW'S SOLUTIONS

ELASTOSIL®

PRODUCT OVERVIEW

MOLD MAKING: FORM HAS NO LIMITS

ELASTOSIL® M, C and RT High-Quality Silicone Rubber



PRODUCT TO PROPERTY

| Brand | Product | Catalyst | Mixing ratio | Viscosity A [mPa·s] | Viscosity B [mPa·s] | Mixing viscosity [mPa·s] | Hardness [Shore A] | Elongation at break [%] | Tensile strength [N/mm ²] | Tear resistance [N/mm] | Specific gravity (cured) [g/cm ³] | Color (cured) | Potlife [min] | Vulcanization time [h] | Typical mold making applications |
|----------------------------|----------|-------------------------|------------------|---------------------|---------------------|--------------------------|--------------------|-------------------------|---------------------------------------|------------------------|---|---------------|---------------|------------------------|---|
| Condensation Curing | | | | | | | | | | | | | | | |
| ELASTOSIL® | RT 402 | T 12 | 3% | 15,000 | | 13,000 | 11 | 350 | 2 | > 3 | 1.28 | Gray | 75 | 5 | Industrial printing, antistatic |
| ELASTOSIL® | M 1470 | Paste T 40 | 2% | Kneadable | | Kneadable | 45 | 230 | 4.5 | > 10 | 1.28 | Pink | 70 | 4 - 5 | Reproduction |
| ELASTOSIL® | M 4400 | T 37 / T 40 | 3% / 2% | 30,000 | | 25,000 | 23 | 250 | 2 | > 3 | 1.30 | Yellow | 90 / 40 | 9 - 12 / 5 - 7 | Reproduction |
| ELASTOSIL® | M 4440 | T 37 / T 40 | 3% / 2% | 25,000 | | 20,000 | 37 | 220 | 2.5 | > 4.5 | 1.23 | White | 80 / 50 | 8 - 10 / 6 - 7 | Reproduction |
| ELASTOSIL® | M 4470 | T 37 / T 40 | 3% / 2% | 15,000 | | 10,000 | 60 | 120 | 4.5 | > 4 | 1.44 | Reddish brown | 90 / 40 | 20 - 24 / 3 - 4 | Low melting metals |
| ELASTOSIL® | RT 480 | T 37 / T 40 | 3% / 2% | Spreadable | | Spreadable | 55 | 170 | 4.5 | > 7 | 1.20 | Gray | 120 / 20 | 9 / 3 | Reproduction |
| ELASTOSIL® | M 3502 | T 21 / T 51 | 5% / 5% | Non-sag | | Non-sag | 26 | 450 | 4.5 | > 23 | 1.24 | White | 60 - 90 | 8 - 10 | Skin mold, reproduction |
| ELASTOSIL® | M 4511 | T 21 / T 51 | 5% / 5% | 25,000 | | 20,000 | 12 | 600 | 3.5 | > 18 | 1.22 | White | 60 - 90 | 8 - 10 | Reproduction |
| ELASTOSIL® | M 4512 | T 21 / T 51 | 5% / 5% | 30,000 | | 25,000 | 20 | 500 | 3.5 | > 24 | 1.19 | White | 60 - 90 | 8 - 10 | Reproduction, automotive |
| ELASTOSIL® | M 4514 | T 21 / T 51 | 5% / 5% | 35,000 | | 25,000 | 25 | 450 | 4.5 | > 25 | 1.25 | White | 60 - 90 | 8 - 10 | Reproduction |
| ELASTOSIL® | M 4541 | T 21 / T 51 | 5% / 5% | 40,000 | | 35,000 | 32 | 400 | 5 | > 30 | 1.16 | White | 60 - 90 | 8 - 10 | Reproduction |
| ELASTOSIL® | M 4503 | T 35 | 5% | 45,000 | | 40,000 | 25 | 350 | 5 | > 20 | 1.16 | White | 90 | 15 - 20 | Reproduction |
| Addition Curing | | | | | | | | | | | | | | | |
| Brand | Product | Catalyst | A : B Components | Viscosity A [mPa·s] | Viscosity B [mPa·s] | Mixing viscosity [mPa·s] | Hardness [Shore A] | Elongation at break [%] | Tensile strength [N/mm ²] | Tear resistance [N/mm] | Specific gravity (cured) [g/cm ³] | Color (cured) | Potlife [min] | Vulcanization time [h] | Typical mold making applications |
| ELASTOSIL® | M 4370 | A | 9:1 | 10,000 | 350 | 8,000 | 55 | 130 | 3 | > 4 | 1.43 | Reddish brown | 80 | 6 | Low melting metals |
| ELASTOSIL® | M 4600 | B | 10:1 | 20,000 | 12,000 | 15,000 | 20 | 800 | 7 | > 20 | 1.10 | Translucent | 80 | 12 | Reproduction |
| ELASTOSIL® | M 4601 | B | 9:1 | 15,000 | 800 | 10,000 | 28 | 700 | 6.5 | > 30 | 1.13 | Reddish brown | 90 | 12 | Reproduction, automotive, composite |
| ELASTOSIL® | M 4615 | B | 100:15 | 7,000 | 500 | 5,000 | 13 | > 700 | 3 | > 10 | 1.03 | Blue | 40 | 5 | Reproduction, glove molding |
| ELASTOSIL® | M 4630 | B | 10:1 | 15,000 | 800 | 10,000 | 28 | 700 | 6.5 | > 30 | 1.13 | White | 90 | 12 | Construction |
| ELASTOSIL® | M 4635 | B | 10:1 | 20,000 | 700 | 15,000 | 37 | 480 | 7 | > 30 | 1.14 | White | 90 | 12 | Construction |
| ELASTOSIL® | M 4641 | A | 10:1 | 50,000 | 400 | 30,000 | 43 | > 300 | > 4.5 | > 25 | 1.07 | Translucent | 90 | 12 | Prototype |
| ELASTOSIL® | M 4642 | B | 10:1 | 20,000 | 700 | 15,000 | 37 | 480 | 7 | > 30 | 1.14 | Dark red | 90 | 12 | Reproduction, composite |
| ELASTOSIL® | M 4643 | B | 9:1 | 40,000 | 800 | 25,000 | 48 | 300 | 5 | > 10 | 1.31 | Gray | 90 | 12 | Reproduction, automotive |
| ELASTOSIL® | M 4644 | A | 10:1 | 70,000 | 500 | 50,000 | 40 | 400 | 5.5 | > 25 | 1.07 | Translucent | 80 | 12 | Prototype (slight oil bleeding) |
| ELASTOSIL® | M 4645 | A | 10:1 | 50,000 | 3,500 | 35,000 | 40 | 330 | 5 | > 28 | 1.06 | Translucent | 80 | 12 | Prototype (strong oil bleeding) |
| ELASTOSIL® | M 4670 | A | 10:1 | 120,000 | 7,000 | 80,000 | 55 | 250 | 5.5 | > 12 | 1.28 | Beige | 90 | 12 | Reproduction, prototype, composite |
| ELASTOSIL® | RT 620 | B | 10:1 | 7,000 | 1,200 | 6,000 | 17 | 900 | 5 | > 12 | 1.05 | Translucent | 35 | 4 | Industrial printing |
| ELASTOSIL® | RT 623 | B | 9:1 | 15,000 | 800 | 10,000 | 31 | 700 | 7.5 | > 30 | 1.12 | Reddish brown | 30 | 5 | Industrial printing |
| ELASTOSIL® | RT 629 | B | 10:1 | 14,000 | 900 | 8,000 | 31 | 500 | 6 | 25 | 1.13 | Turquoise | 40 | 3 | Industrial printing, antistatic |
| ELASTOSIL® | C 1200 | A | 1:1 | 20,000 | 20,000 | 20,000 | 25 | 500 | 5 | 25 | 1.05 | Blue | 20 | 1 | Composite |
| ELASTOSIL® | M 4115 | A | 1:1 | 2,500 | 2,500 | 2,500 | 17 | 400 | 3 | 5 | 1.05 | Translucent | 12 | 1 | Cosmetic |
| ELASTOSIL® | M 4125 | A | 1:1 | 6,000 | 6,000 | 6,000 | 25 | 500 | 5 | 25 | 1.05 | Translucent | 60 | 12 | Industrial printing (printing roller) |
| ELASTOSIL® | M 4125 F | A | 1:1 | 6,000 | 6,000 | 6,000 | 28 | 500 | 5 | 25 | 1.05 | White | 15 | 2 | Industrial printing (printing roller), reproduction |
| ELASTOSIL® | VARIO 15 | CAT Vario / Cat Vario F | 10:1 | 5,000 | | 3,000 | 15 ... * | 900 | 6.5 | 15 | 1.06 | Translucent | 150 / 2 | 6 / 0.25 | All |
| ELASTOSIL® | VARIO 40 | CAT Vario / Cat Vario F | 10:1 | | 15,000 | 10,000 | ... 40 ** | 450 | 8 | 15 | 1.15 | Translucent | 150 / 2 | 6 / 0.25 | All |

The data are only intended as a guide and should not be used in preparing specifications.

* Can be blended by adding ELASTOSIL® VARIO 40

** Can be blended by adding ELASTOSIL® VARIO 15

PROPERTY TO PRODUCT

| Brand | Product | FDA | Low viscosity | Easy mixing (1:1) | Heat resistant | Anti-static | Fast vulcanization | Long potlife | Shrinkage <0.1% | Resin stability | | | Oil bleeding | Ink resistant | Non-sag |
|----------------------------|----------|-----|---------------|-------------------|----------------|-------------|--------------------|--------------|-----------------|-----------------|------------|---------------|--------------|---------------|---------|
| | | | | | | | | | | Epoxy | Poly-ester | Poly-urethane | | | |
| Condensation Curing | | | | | | | | | | | | | | | |
| ELASTOSIL® | RT 402 | | | | | • | • | | | | | | | | |
| ELASTOSIL® | M 1470 | | | | | | • | | | | | | | | • |
| ELASTOSIL® | M 4400 | | | | | | | • | | | | | | | |
| ELASTOSIL® | M 4440 | | | | | | | • | | | | | | | |
| ELASTOSIL® | M 4470 | | • | | • | | | • | | | | | | | |
| ELASTOSIL® | M 3502 | | | | | | | • | | | | | | | • |
| ELASTOSIL® | M 4511 | | | | | | | • | | | • | • | | | |
| ELASTOSIL® | M 4512 | | | | | | | • | | | • | • | | | |
| ELASTOSIL® | M 4514 | | | | | | | • | | | • | • | | | |
| ELASTOSIL® | M 4541 | | | | | | | • | | | • | • | | | |
| ELASTOSIL® | M 4503 | | | | | | | • | | | | | | | |
| Addition Curing | | | | | | | | | | | | | | | |
| ELASTOSIL® | M 4370 | • | • | | • | | | | • | | | | | | |
| ELASTOSIL® | M 4600 | • | | | | | | • | • | | | | | | |
| ELASTOSIL® | M 4601 | • | | | | | | • | • | | | | | | |
| ELASTOSIL® | M 4615 | | • | | | | • | | • | | | | | | |
| ELASTOSIL® | M 4630 | • | • | | | | | • | • | | | | | | |
| ELASTOSIL® | M 4635 | • | | | | | | • | • | | | | | | |
| ELASTOSIL® | M 4641 | • | | | | | | • | • | | | • | | | |
| ELASTOSIL® | M 4642 | | | | | | | • | • | • | | • | | | |
| ELASTOSIL® | M 4643 | | | | | | | • | • | • | | • | | | |
| ELASTOSIL® | M 4644 | | | | | | | • | • | | | • | • | | |
| ELASTOSIL® | M 4645 | | | | | | | • | • | | | • | •• | | |
| ELASTOSIL® | M 4670 | • | | | | | | | • | • | | • | | | |
| ELASTOSIL® | RT 620 | • | | | | | | • | • | | | | | • | |
| ELASTOSIL® | RT 623 | | • | | | | | • | • | | | | | • | |
| ELASTOSIL® | RT 629 | | • | | | • | | • | • | | | | | • | |
| ELASTOSIL® | C 1200 | | | | • | | | • | • | ○ | • | | | | |
| ELASTOSIL® | M 4115 | | • | • | | | | | • | | | | | | |
| ELASTOSIL® | M 4125 | • | • | • | | | | | • | | | | | | |
| ELASTOSIL® | M 4125 F | • | • | • | | | | • | • | | | | | | |
| ELASTOSIL® | VARIO 15 | • | • | | | | | • | • | | | | | | |
| ELASTOSIL® | VARIO 40 | • | | | | | | • | • | | | | | | |

○ For prepreg use

•• Strong oil bleeding

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