The data presented in this brochure 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 brochure 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.
FROM THE CONCEPT TO SERIES PRODUCTION IN RECORD TIME

Ever faster innovation cycles are forcing engineers and product designers to work ever more efficiently. This means having a prototype in the original material at the earliest possible stage. Rapid prototyping with ELASTOSIL® M makes this possible.

Whether you’re producing specific machine parts or complicated resin castings, ELASTOSIL® M mold-making compounds can be used to make cost-effective reproductions of the original part or even small series.

<table>
<thead>
<tr>
<th>Product</th>
<th>Properties</th>
<th>Color</th>
<th>Hardness [Shore A]</th>
<th>Tensile strength [N/mm²]</th>
<th>Elongation at break [%]</th>
<th>Tear strength [N/mm]</th>
<th>Viscosity [mPa•s]</th>
</tr>
</thead>
<tbody>
<tr>
<td>M 4641 A/B</td>
<td>medium hard, very high mechanical strength</td>
<td>Transparent</td>
<td>43</td>
<td>4.5</td>
<td>300</td>
<td>&gt; 28</td>
<td>30,000</td>
</tr>
<tr>
<td>M 4644 A/B</td>
<td>medium hard, high mechanical strength, weakly oil-bleeding</td>
<td>Transparent</td>
<td>40</td>
<td>5.5</td>
<td>400</td>
<td>&gt; 28</td>
<td>50,000</td>
</tr>
<tr>
<td>M 4645 A/B</td>
<td>medium hard, high mechanical strength, strongly oil-bleeding</td>
<td>Transparent</td>
<td>40</td>
<td>5.0</td>
<td>330</td>
<td>&gt; 28</td>
<td>35,000</td>
</tr>
<tr>
<td>M 4670 A/B</td>
<td>hard, high mechanical strength, for casting polyamide</td>
<td>Beige</td>
<td>55</td>
<td>5.5</td>
<td>300</td>
<td>&gt; 12</td>
<td>80,000</td>
</tr>
</tbody>
</table>

ELASTOSIL® M silicone rubber grades from WACKER are some of the highest quality, most technically advanced materials used in vacuum casting.

The properties of pourable, addition-curing RTV ELASTOSIL® M silicone rubber have been specially tailored to the needs of vacuum casting for rapid prototyping and small-series production.

Special Characteristics
- Good flow
- Fast, shrink-free curing at room temperature, which can be greatly accelerated by heating
- High transparency
- High tear resistance
- Outstanding long-term stability of the cured rubber's mechanical properties
- Excellent resistance to casting resins and polyamide

Whether you’re producing specific machine parts or complicated resin castings, ELASTOSIL® M mold-making compounds can be used to make cost-effective reproductions of the original part or even small series.

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

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