

**WACKER**

CREATING TOMORROW'S SOLUTIONS

ELASTOSIL®

PRODUCT OVERVIEW

# MOLDMAKING: 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 <sup>2</sup> ]	Tear resistance [N/mm]	Specific gravity (cured) [g/cm <sup>3</sup> ]	Color (cured)	Potlife [min]	Vulcanization time [h]	Typical moldmaking applications
<b>Condensation Curing</b>															
ELASTOSIL®	RT 402	T 12	3%	15,000		13,000	11	350	2	> 3	1.28	Light gray	75	5	Industrial printing, antistatic
ELASTOSIL®	M 1470	Paste T 40	2% / 3% / 5%	Kneadable		Kneadable	45	230	4.5	> 10	1.28	Pink	70 / 50 / 20	4 / 3 / 1	Skin molds
ELASTOSIL®	M 4400	T 37 / T 40	3% / 2%	25,000		20,000	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	60 / 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®	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
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, casting resins
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, casting resins
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, casting resins
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, casting resins
ELASTOSIL®	M 4503	T 35	5%	40,000		35,000	25	350	5	> 20	1.20	White	90	15 - 20	Reproduction
<b>Addition Curing</b>															
Brand	Product	Catalyst in component ...	Mixing ratio A:B	Viscosity A [mPa·s]	Viscosity B [mPa·s]	Mixing viscosity [mPa·s]	Hardness [Shore A]	Elongation at break [%]	Tensile strength [N/mm <sup>2</sup> ]	Tear resistance [N/mm]	Specific gravity (cured) [g/cm <sup>3</sup> ]	Color (cured)	Potlife [min]	Vulcanization time [h]	Typical moldmaking 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	90	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 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 (no oil-bleeding)
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	Pad printing
ELASTOSIL®	RT 623	B	9:1	15,000	800	10,000	31	700	7.5	> 30	1.12	Reddish brown	30	5	Pad printing
ELASTOSIL®	RT 629	B	10:1	14,000	900	8,000	31	500	6	25	1.13	Turquoise	40	3	Pad printing, antistatic
ELASTOSIL®	C 1200	A	1:1	25,000	25,000	25,000	25	500	5	25	1.05	Blue - transl.	20	1	Vacuum-bag composite molding
ELASTOSIL®	M 4115	A	1:1	2,500	2,500	2,500	17	400	3	5	1.05	Translucent	12	1	Reproduction
ELASTOSIL®	M 4119	A	1:1	3,000	4,000	3,500	20	> 400	3.5		1.05	Translucent	7	0.5	Reproduction
ELASTOSIL®	M 4125 F	A	1:1	6,000	6,000	6,000	28	500	5	25	1.05	White	15	2	Printing rollers, reproduction
ELASTOSIL®	VARIO 15	CAT Vario / Vario F	10:1	5,000		3,000	15 ... *	900	6.5	15	1.06	Translucent	150 / 2	6 / 0.25	Reproduction
ELASTOSIL®	VARIO 40	CAT Vario / Vario F	10:1	15,000		10,000	... 40 **	450	8	15	1.15	Translucent	150 / 2	6 / 0.25	Reproduction
ELASTOSIL®	FX tool box	Silicone rubbers for special effects and prosthetics molding (from gel-like to medium hardness; FX Gel 30, FX 10, FX 20, FX 28) and 4 additives (FX Softener, FX Fast cure, FX Slow cure, FX Thixo), more info at <a href="http://www.wacker.com/elastosil-fx">www.wacker.com/elastosil-fx</a>													

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	Processing					Casting Materials Suitability				Special Properties				
		Easy mixing (1:1)	Low viscosity	Non-sag	Fast vulcanization	Long potlife	Food*	Resin stability				Heat resistant	Anti-static	Pad printing	Oil bleeding
								Epoxy	Poly-ester	Polyurethane	Concrete				
<b>Condensation Curing</b>															
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					●									
<b>Addition Curing: Shrinkage &lt; 0.1%</b>															
ELASTOSIL®	M 4370		●				●	●	●	●		●			
ELASTOSIL®	M 4600					●	●								
ELASTOSIL®	M 4601					●	●	●	●	●					
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 4119	●	●		●										
ELASTOSIL®	M 4125 F	●	●		●		●								
ELASTOSIL®	VARIO 15		●		●		●								
ELASTOSIL®	VARIO 40				●		●								

\* FDA conformity

○ For prepreg use

●● Strong oil bleeding



**WACKER**

**Wacker Chemie AG**  
Hanns-Seidel-Platz 4  
81737 Munich, Germany  
[www.wacker.com/contact](http://www.wacker.com/contact)

[www.wacker.com](http://www.wacker.com)

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