



# Silicones, Inc.

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*RTV-2 Silicones Since 1974*

## GI-650

### Product Information

#### General Information

**GI-650** is a high tear strength, tin-catalyzed RTV-2 silicone rubber, which was designed for casting polyester parts. **GI-650** is not sensitive to inhibition, meaning it will cure at room temperature over virtually any surface. It is easy to mix and de-air, and will cure with only a slight degree of shrinkage. The speed at which the rubber hardens can be accelerated with special activators. Condensation cure two-component silicone rubbers are excellent for most general mold making and prototype applications. They are excellent for casting waxes, gypsum, epoxies and other plastics. **GI-650** is extremely useful for those applications where superior mechanical properties are required.

#### Typical Properties

##### Uncatalyzed Compound

<b>Color</b>	Base: White	Activator: Blue
<b>Viscosity (cps)</b>	Base: 40,000-60,000	Activator: 300-400
<b>Mixing Ratio (B/A)</b>	By weight: 100 / 10	By volume: 100 / 11.1
<b>Viscosity (cps)</b>	Mixed: 20,000-30,000	
<b>Working Time</b>	1.5 to 2.5 hours	
<b>Cure Time</b>	16-18 hours	
<b>Shelf Life</b>	6 months	

##### Vulcanized (cured) Properties (7 days @ 70° F / 50% relative humidity)

<b>Shore A Hardness (±4)</b>	One day: 23	7 Days: 27
<b>Tear Resistance (ASTM D624)</b>	100 ± 10 ppi	
<b>Tensile Strength (ASTM D412)</b>	500 ± 25 psi	
<b>Elongation (ASTM D412)</b>	325 ± 25 %	
<b>Service Temperature (° F)</b>	-60 to 340	
<b>Shrinkage</b>	0.10 %	
<b>Specific Gravity</b>	1.08	
<b>Coverage (in<sup>3</sup> / lb)</b>	25.8	
<b>Dielectric Strength (volts/mil)</b>	<i>n.a.</i>	
<b>Dielectric Constant (@ 100 HZ)</b>	<i>n.a.</i>	
<b>Dissipation Factor (@ 100 HZ)</b>	<i>n.a.</i>	
<b>Volume Resistivity (ohms/cm)</b>	<i>n.a.</i>	

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