



Silicones, Inc.

P.O. Box 363
High Point, NC 27261
Tel: 336-886-5018
Fax: 336-886-7122
www.silicones-inc.com

RTV-2 Silicones Since 1974

P-614

Product Information

General Information

P-614 is a fast curing, two-component addition cure silicone rubber mold making material that has a minimum working time of 40 minutes, yet can be demolded in only 3 to 4 hours. This allows the mold maker to produce both sides of a two part mold in one 8 hour shift. Parts can also be produced in the same day from a one piece mold. **P-614** has a high durometer, minimal shrinkage and excellent chemical resistance, making it a superior choice for prototyping and casting solid polyurethane resins.

Typical Properties

Uncatalyzed Compound

Color	Base: Tan	Activator: Black
Viscosity (cps)	Base: 45,000 - 55,000	Activator: 800 - 1200
Mixing Ratio (B/A)	By weight: 100 / 10	By volume: 100 / 11.1
Mixed Viscosity	35,000 - 45,000	
Working Time	40 minutes (minimum)	
Demold Time	4 hours	
Shelf Life	6 months	

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

Shore A Hardness

	4 Hours:	> 34
	18 Hours:	55 ± 5
	7 Days:	60 ± 5
Tear Resistance (ASTM D624)		45 ± 10 ppi
Tensile Strength (ASTM D412)		600 ± 50 psi
Elongation (ASTM D412)		175 ± 25 %
Service Temperature (° F)		-60 to 650
Shrinkage		nil
Specific Gravity		1.24
Coverage (in³ / lb)		22.4

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