



# Silicones, Inc.

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*RTV-2 Silicones Since 1974*

## XT-491

### Product Information

#### General Information

**XT-491** is a high tear, high tensile strength, tin catalyzed silicone designed to be used when casting polyurethane foam, polyester and epoxy parts. **XT-491** is useful for applications where a flexible rubber with increased chemical resistance is required. When catalyzed with one of our library life extending catalysts (see supplemental products) and stored correctly, a longer life of the cured mold should be expected. Its high tear strength, elongation and tensile strength make it an excellent choice for any mold making application. It is also resistant to inhibition by most common mold making substrates, eliminating the need to use mold sealers.

#### Typical Properties

##### Uncatalyzed Compound

<b>Color</b>	Base: Off White	Activator: Blue
<b>Viscosity (cps)</b>	Base: 50,000 - 70,000	Activator: 350-500
<b>Mixing Ratio (B/A)</b>	By weight: 100 / 10	By volume: 100 / 11.1
<b>Mixed Viscosity</b>	30,000 - 45,000	
<b>Working Time</b>	1 to 1.5 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 (<math>\pm 3</math>)</b>	One day: 20	7 Days: 26
<b>Tear Resistance (ASTM D624)</b>	120 $\pm$ 10 ppi	
<b>Tensile Strength (ASTM D412)</b>	525 $\pm$ 25 psi	
<b>Elongation (ASTM D412)</b>	300 $\pm$ 25 %	
<b>Service Temperature (<math>^{\circ}</math> F)</b>	-60 to 350	
<b>Shrinkage</b>	0.10 %	
<b>Specific Gravity</b>	1.09	
<b>Coverage (in<sup>3</sup> / lb)</b>	25.2	

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