



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

Product Information

XT-153 SILICONE RUBBER

DESCRIPTION

XT-153 is a two component condensation cure silicone rubber mold making material. It differs from most silicone rubber materials in that it is translucent rather than opaque. In thin sections, it is nearly transparent. It has been designed with a low viscosity to enable it to reproduce intricate detail and a very low durometer that allows maximum flexibility. It can also be easily colored by the addition of appropriate pigments. This unique combination of properties makes XT-153 well-suited for the special effects and movie making industries.

MIXING INSTRUCTIONS

Mix 10 parts by weight of XT-153 base with 1 part by weight of XT-153 activator in a container that will hold about three times the volume of the rubber being mixed. Stir thoroughly either by hand or by mechanical means. Since both base and activator are nearly colorless, care must be taken to insure that they are completely blended before deaeration. Immediately after mixing, place the container in a vacuum chamber capable of 28 inches of mercury vacuum. The rubber will expand to double or triple its original volume as it is being deaired. After the rubber collapses, maintain the vacuum for an additional two minutes and release. Carefully pour the catalyzed silicone rubber over the released pattern (MR-15 is recommended).

TYPICAL PROPERTIES

Color, base	Translucent
Color, activator	Translucent
Base viscosity (cps)	20,000 - 30,000
Activator viscosity (cps)	300 - 400
Working Time (hrs)	1 to 2
Cure Time (hrs)	18 to 24
Specific Gravity, cured rubber	1.06
Shore A hardness	
1 day	2 to 4
7 days	5 to 8
Tear Resistance (ppi)	50 ± 10
Tensile Strength (psi)	220 ± 25
Elongation (%)	475 ± 25
Shrinkage (%)	0.1

The information contained in this product information sheet is based on sources believed to be accurate. It is offered in good faith, but without guarantee since the conditions of use are beyond our control. All risks of use are assumed by the user.