



# THE COMPLEAT SCULPTOR

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## TECHNICAL INFORMATION SHEET - GI-1110 SILICONE RUBBER

### DESCRIPTION

GI-1110 is a high tear strength, two-component, tin catalyzed RTV silicone rubber which was especially designed for casting polyester parts. It offers the following advantages:

**High tear strength** GI-1110 is especially good for molds with deep undercuts and for those molds which require flexing for part removal.

**Low durometer** GI-1110 is soft and very useful for applications where severe flexing is required.

**Low shrinkage** GI-1110 offers exceptional reproduction capability. It is particularly valuable in the production of many-sided molds where exact registrations are required.

**Very good chemical resistance** GI-1110 exhibits long mold life due to unique processing techniques that were developed to meet the rigors of polyester and polyurethane casting.

**Excellent shelf aging** GI-1110 retains its dimensional stability and resists embrittlement on aging.

**Low viscosity** The low viscosity of GI-1110 allows for easy mixing, de-airing, and pouring. It is useful for applications where very minute details must be registered.

**Color-coded catalyst** The blue activator ensures homogeneous mixing and eliminates mold loss resulting from inadequate stirring.

**Long pot life** GI-1110 gives good overnight cure despite having a working time of two hours. In addition, it is relatively insensitive to temperature and humidity fluctuations.

**Insensitive to inhibition** GI-1110 is not inhibited by most common mold-making substrates, eliminating the need to use mold sealers.

### APPLICATIONS

GI-1110 is recommended for casting polyester and polyurethane parts where high strength and very fine detail registration are required. It is also excellent for casting waxes, gypsum, epoxies and other plastics. It is extremely useful for those applications where superior elongation and low durometer are required.

### TYPICAL PROPERTIES

#### Uncatalyzed Compound

Color  
Viscosity (cps)  
Specific Gravity  
Working Time (minimum)

Cure Time

Shelf Life

#### Cured Rubber (7 days @70° F & 50% R.H.)

Hardness, Shore A

Tensile Strength (ASTM D412)

Elongation (ASTM D412)

Tear, Die B (ASTM D624)

Shrinkage

Specific Gravity

#### GI-1110B

White

15,000-25,000

1.08

1 to 2 hours

16 to 18 hours

6 months

10 ± 4

275 ± 25 psi

450 ± 25%

75 ± 15 ppi

0.1%

1.08

#### GI-1110A

Blue

300-400

.99

### MIXING INSTRUCTIONS

Mix 100 parts by weight of GI-1110 Base with 10 parts by weight of GI-1110 Activator in a container that will hold approximately two times the volume being used. Stir thoroughly either by hand or by mechanical mixing until a light blue color results. Immediately after mixing, place the material in a vacuum chamber capable of 28 inches of mercury vacuum. The material will expand to double its original volume and then collapse. Maintain vacuum for an additional minute and release. Carefully pour the catalyzed silicone rubber over the released pattern (MR-15 is recommended). Allow to cure for 16 to 18 hours.

*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.*

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