



THE COMPLEAT SCULPTOR

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TECHNICAL INFORMATION SHEET - XP-268 SILICONE RUBBER

DESCRIPTION

XP-268 is a two component addition cure silicone rubber mold making material. It has a high durometer, high modulus, superb physical properties, minimal shrinkage and extreme chemical resistance making it an excellent choice for prototyping, casting urethane foam and other plastics. XP-268 cures at room temperature in 16 - 24 hours; however, the curing rate can be accelerated with Pt Accelerator at room temperature, or with heat.

MIXING INSTRUCTIONS

Mix 100 parts by weight of XP-268 Base with 10 parts by weight of XP-268 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 until a uniform blue color is achieved. 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 then release. Carefully pour the catalyzed silicone rubber over the released pattern (MR-15 is recommended).

TYPICAL PROPERTIES

Color, Base	Tan
Color, Activator	Blue
Base viscosity (cps)	160,000 to 200,000
Activator viscosity (cps)	100 to 500
Working Time (hrs)	3 to 4
Cure Time (hrs)	16 to 24
Specific Gravity, cured rubber	1.30
Shore A Hardness	
24 hours @ 701 F/50% R.H.	70 1 5
7 days @ 701 F /50% R.H.	70 1 5
Tear Resistance (ppi)	60 1 15
Tensile Strength (psi)	800 1 50
100 % Modulus	700 ± 50
Elongation (%)	175 1 25
Shrinkage (%)	nil

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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