

RTV 8335

2 Component addition cure Pad Printing material

Product Description RTV 8335 is a liquid 2-component RTV silicone rubber with a convenient mix ratio of 9:1. The material is specially designed to be diluted with low viscosity silicone oil such as Silopren S50 RTV, to be used as printing pads in tampon printing applications. The mixed material will vulcanise at room temperature by an addition reaction. The cure rate will be influenced by temperature. Low temperatures will prolong the work life and cure time, high temperatures will shorten the work life and cure time.

Key Performance Properties

- easy dilution and mixing
- good flow, easily pourable
- low shrinkage
- cure time below 24 hrs after dilution with Silopren S50 RTV
- obtain required hardness for the printing PAD with addition of Silopren S50 RTV
- easy to colour

Typical Product Data RTV 8335 has been especially developed for pad printing applications. Common practice in the pad printing industry is to dilute the base product by adding silicone oil, like Silopren S50 RTV, to match the hardness required for the printing pad in the application.

Individual components	Unit	base	catalyst
Appearance		Translucent	Translucent
Viscosity 20 °C	mPa s	70.000	1 100
Mixed components	Unit	RTV 8335 BASE: CATALYST 9: 1	
Appearance		Translucent	
Pot life at RT	min	90	
Viscosity 20°C (Haake)	mPa s	34 000	

Typical cured properties:

Cure conditions:

9:1 mix, 2 mm thick sheet, cured for 24 hrs at RT

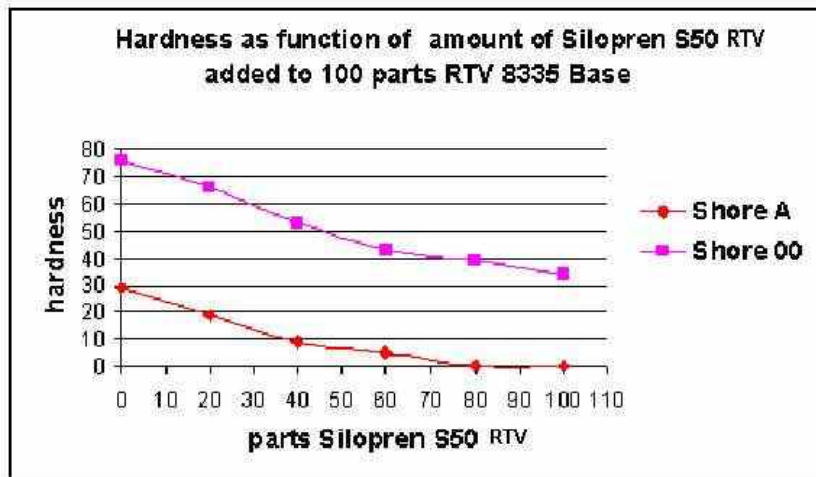
Property	Test method	Unit	Typical Values
Hardness	DIN53505	Shore A	30
Hardness	ASTM D-2240	Shore 00	80
Tensile strength	DIN53504	MPa	6
Elongation	DIN53504	%	500
Tear strength	ASTM D-624	N/mm	30
Linear shrinkage		%	0.1
Density		g/cm ³	1.08

Specifications Typical product data values should not be used as specifications. Assistance and specifications are available by contacting Momentive performance materials Technical Service RTV1 and RTV2.

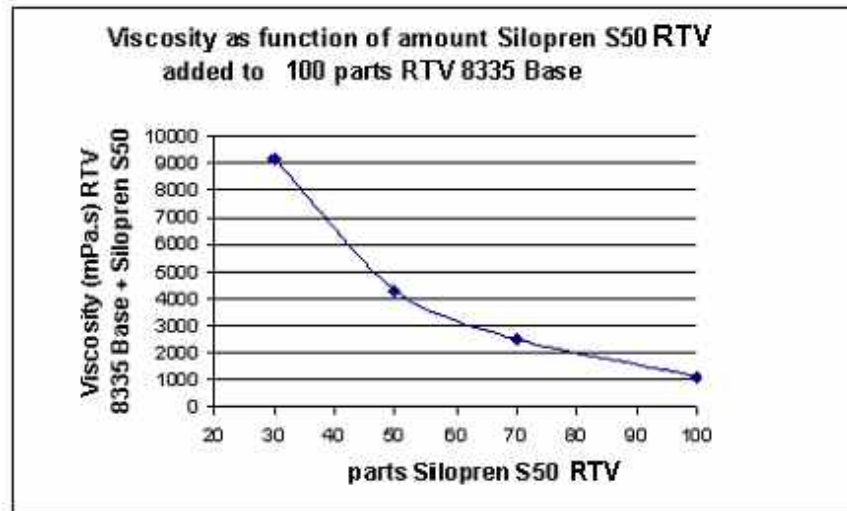
Instructions for Use **Mixing**

To obtain a material with hardness suitable for a printing pad, 100 parts of RTV8335 base has to be mixed with a suitable amount of Silopren S50 RTV. This mix is then catalyzed with 10 parts RTV8335 catalyst solution. Optionally a pigment paste (like e.g. 1 or 2 % by weight of Silopren LSR colour batch) can be added. These components must be stirred for several minutes in a container 4 – 5 times larger than the volume of the mix until a homogeneous mixture is obtained. The air entrapped in the mixing step needs to be removed. This can be done by exposing the material to a vacuum of 10-20 mbar. The material will expand, crest and reduce to about the original level. Degassing of the material under these conditions will take 5 – 10 minutes in diluted form.

The graphs below give an indication of viscosity and Shore 00 after mixing the RTV8335 base + Silopren S50 RTV + RTV8335 catalyst. In these mixes Silopren S50 RTV is added in different ratios to RTV8335. The RTV8335 base: RTV8335 catalyst ratio in these mixes is 100:10 by weight.



Mixtures of RTV 8335 Base + Silopren S50 RTV:



These graphs can only be used as an indication and should be verified with each new batch of pad printing base material or silicon fluid to assure that the normal batch to batch variation of these materials is captured.

Compatibility Certain materials such as butyl and chlorinated rubber, sulfur containing materials, amines and certain metal soap cured RTV silicon rubber compounds can cause cure inhibition. Cure inhibition is characterized by a gummy appearance of the silicone at the interface between the silicon and the substrate/mould. It is recommended that a sample patch test is performed with the RTV 8335 to determine if a barrier coating or other inhibition preventing measure is required.

Curing RTV 8335 has been developed to give full cure within 24 hrs even when diluted with 100 parts of Silopren S50 RTV fluid. Addition of fluid will have some effect on pot life and demoulding time.

Handling and Safety Material Safety Data Sheets are available upon request from Momentive performance materials Silicones. Similar information for solvents and other chemicals used with the Momentive performance materials products should be obtained from your supplier. When solvents are used, proper safety precautions must be observed.

Storage and Warranty Period The warranted shelf life will be indicated by the 'use before date' on the associated documents with a minimum of 4 months when stored in the original unopened containers below 27° C.

Availability RTV 8335 is available in 20kg pail kits RTV 8335.



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