

# SILPAK, INC.

470 E. BONITA AVE. POMONA, CA 91767  
(909) 625-0056 FAX (909) 625-0082 [WWW.SILPAK.COM](http://WWW.SILPAK.COM)

## R-1324 A / B

### PRODUCT DATA SHEET ROOM TEMPERATURE CURING SILICONE

350  
300  
250

#### INTRODUCTION:

R-1324 A/B is a room temperature vulcanizing silicone rubber intended primarily for making molds, and highly flexible props. It is also used as a general purpose, high strength rubber. The main features of this product are:

- 1) Excellent physical properties with high tear resistance.
- 2) Low viscosity for ease of pouring
- 3) Produces mold with a long working life.

#### PHYSICAL PROPERTIES OF THE UNVULCANIZED MATERIAL

Color: Off-white/Blue  
Viscosity @ 25C: 30,000 cps mixed A & B  
Shelf Life: 6 months in a closed container

#### TYPICAL PROPERTIES OF THE CURED RUBBER

Specific Gravity: 1.15  
Hardness: 30 shore  
Tensile Strength: 550 psi  
Elongation at Break %: 350  
Tear Resistance: 110

#### METHOD OF USE:

R-1324 A is processed by adding curing agent R-1324 B. The addition of 10% catalyst (by weight) has a pot life of 40 minutes and is ready for de-molding after 15 to 24 hours. R-1324 B has a trace of pigment for good dispersion.

After the mold has been removed from the master, it should be left for 24 hours in order to develop its maximum mechanical strength.

Use Thix 5170 and PE-ESS-5F (Mini Fibers) to create a brush-on, low sag, rubber bladders. To quick cure R-1324 A/B add 2% of FC-200 and extra R-1324 B (12%) for a 3-4 hour de-mold time.

**THE INFORMATION AND DATA CONTAINED HEREIN ARE BASED ON INFORMATION WE BELIEVE RELIABLE. EACH USER OF THE MATERIAL SHOULD THOROUGHLY TEST ANY APPLICATION AND INDEPENDENTLY CONCLUDE SATISFACTORY PERFORMANCE BEFORE COMMERCIALIZING. SUGGESTIONS OF USES SHOULD NOT BE TAKEN AS INDUCEMENTS TO INFRINGE ON ANY PARTICULAR PATENT.**

# SILPAK, INC.

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## MATERIAL SAFETY DATA SHEET

### SECTION I

MANUFACTURER: SILPAK, INC.  
ADDRESS: 169 ATLANTIC STREET/POMONA, CA. 91768  
EMERGENCY TELEPHONE #: 909-595-6191  
CHEMICAL NAME AND SYNONYMS: ORGANOPOLYSILOXANE MIXTURE  
TRADE NAME & SYNONYMS: **R-1324 A**  
CHEMICAL FAMILY: 2 PART RTV RUBBER MIXTURE  
FORMULA: NOT A SINGLE CHEMICAL.  
DOT (CFR 49): HAZARD CLASSIFICATION/PER CFR 49  
NFPA: HEALTH 0, FIRE 1, REACTIVITY 0  
CALIFORNIA PROP 65: NOT LISTED  
SARA SECTION 313: NOT LISTED

### SECTION II HAZARDOUS INGREDIENTS

POLYDIMETHYL SILOXANE MIXTURE: <50 CAS # 63148-60-7  
MINERAL FILLERS: >50 CAS # 1317-65-3  
HYDROPHOBIC SILICON DIOXIDE AMORPHOUS >40 CAS # 112945-52-5

ABOVE IS A PROPRIETARY FORMULATION

### SECTION III PHYSICAL DATA

BOILING POINT (F): N/A SPECIFIC GRAVITY (H2O=1): 1.16  
VAPOR PRESSURE (mm Hg) @ 77F: NEG  
PERCENT VOLATILE BY VOLUME (%) @ 77F: 0.5 MAX  
VAPOR DENSITY (AIR=1): N/A  
EVAPORATION RATE (ETHYL ETHER = 1): NEG.  
SOLUBILITY IN WATER: N/A  
APPEARANCE AND ODOR: NATURAL AND ODORLESS PASTE

### SECTION IV

#### FIRE AND EXPLOSION HAZARD DATA

FLASH POINT (METHOD USED): UN#: NOS  
FLAMMABLE LIMITS: Not Measured  
EXTINGUISHING MEDIA: Foam, dry chemical, or carbon dioxide  
SPECIAL FIRE FIGHTING PROCEDURES: None required  
UNUSUAL FIRE AND EXPLOSION HAZARDS: None

### SECTION V HEALTH HAZARD DATA

THRESHOLD LIMIT VALUE: N/A  
EFFECTS OF OVEREXPOSURE: No significant effect. Eye Contact: May cause slight irritation.  
Ingestion: Induce vomiting and contact a physician or a poison control center.

EMERGENCY AND FIRST AID PROCEDURES: SKIN: Remove liquid from skin with a towel or dry cloth and wash exposed area with detergent. EYES: Immediately flush with water for at least 15 minutes.  
INGESTION: Induce vomiting.

#### **SECTION VI REACTIVITY DATA**

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STABILITY: Stable                      CONDITIONS TO AVOID: N/A  
INCOMPATIBILITY (MATERIALS TO AVOID): None  
HAZARDOUS DECOMPOSITION PRODUCTS: None  
HAZARDOUS POLYMERIZATION: Will not occur

#### **SECTION VII SPILL OR LEAK PROCEDURES**

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STEPS TO BE TAKEN IN CASE MATERIAL IS RELEASED OR SPILLED: Contain the spill or leak, scrape up with cardboard or a rag, and place in a container.

WASTE DISPOSAL METHOD: Can be burned in accordance with regulations.

#### **SECTION VIII SPECIAL PROTECTION INFORMATION**

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RESPIRATORY PROTECTION (SPECIFY TYPE): Not required  
PROTECTIVE GLOVES: Plastic film or rubber gloves  
EYE PROTECTION: Safety glasses  
OTHER PROTECTIVE EQUIPMENT: Eye wash equipment

#### **SECTION IX SPECIAL PRECAUTIONS**

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PRECAUTIONS TO BE TAKEN IN HANDLING AND STORING: KEEP CONTAINER CLOSED. STORE IN A COOL PLACE AND KEEP AWAY FROM HEAT OR FLAME. DON'T LAY CONTAINER ON IT'S SIDE.

OTHER PRECAUTIONS: AVOID PROLONGED CONTACT WITH EYES AND REPEATED CONTACT WITH SKIN.

\*NOS: NOT OTHERWISE SPECIFIED

Prepared by: JERRY GALARNEAU 01-2-02

**MATERIAL SAFETY DATA SHEET  
"B" COMPONENT**

**SECTION I**

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CHEMICAL NAME AND SYNONYMS: ORGANOPOLYSILOXANE SOLUTION  
TRADE NAME & SYNONYMS: **R-1324 B**  
CHEMICAL FAMILY: CATALYST FOR SILICONE RUBBER  
FORMULA: PROPRIETARY MIXTURE  
DOT (CFR 49): HAZARD CLASSIFICATION/PER CFR 49  
NFPA: HEALTH 0, FIRE 1, REACTIVITY 0  
CALIFORNIA PROP 65: NOT LISTED  
SARA SECTION 313: NOT LISTED

**SECTION II HAZARDOUS INGREDIENTS**

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PIGMENT: COLOR PER SYSTEM  
CATALYST: METALLIC COMPLEX >10  
POLYSILOXANE POLYMER <40  
POLYSILICATES <20

ABOVE IS A PROPRIETARY MIXTURE

**SECTION III PHYSICAL DATA**

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BOILING POINT (F): 172                      SPECIFIC GRAVITY: 1.05  
VAPOR PRESSURE (mm Hg.): 50  
PERCENT VOLATILE BY VOLUME (%) AFTER 3 HRS @ 221F: N/A  
SOLUBILITY IN WATER: NO  
VAPOR DENSITY (AIR=): 1.6  
EVAPORATION RATE: (ETHANOL=1): 1  
APPEARANCE & ODOR: SLIGHTLY SOLVENT ODOR, COLOR BLUE

**SECTION IV**

**FIRE AND EXPLOSION HAZARD DATA**

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FLASH POINT (METHOD USED): 166F                      UN#: NOS  
FLAMMABLE LIMITS: Ethanol Lel - 4.3 / Uel - 1.9  
EXTINGUISHING MEDIA: Foam, dry chemical, or carbon dioxide  
SPECIAL FIRE FIGHTING PROCEDURES: Use approved respirator & protective clothing. Flammable material due to solvents.  
UNUSUAL FIRE AND EXPLOSION HAZARDS: Solvent vapors form explosive mixtures with air.

**SECTION V HEALTH HAZARD DATA**

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THRESHOLD LIMIT VALUE: N/A  
EFFECTS OF OVEREXPOSURE: Inhalation may cause dizziness, headache and nausea. Eye and skin contact: May cause irritation and dermatitis.

EMERGENCY AND FIRST AID PROCEDURE: Inhalation: Remove to fresh air; give artificial respiration or oxygen; call physician.

Eyes: Immediately flush with water for at least 15 minutes; call physician. Skin: remove from skin with a dry cloth - then wash with detergent.

#### **SECTION VI REACTIVITY DATA**

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STABILITY: STABLE

HAZARDOUS DECOMPOSITION PRODUCTS: None

HAZARDOUS POLYMERIZATION: WILL NOT OCCUR

INCOMPATIBILITY (materials to avoid): None

CONDITIONS TO AVOID: Heating

#### **SECTION VII SPILL OR LEAK PROCEDURES**

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STEPS TO BE TAKEN IN CASE MATERIAL IS RELEASED OR SPILLED: Shut off ignition sources; wear appropriate protective equipment. Collect spill on absorbent material.

#### **SECTION VIII SPECIAL PROTECTION INFORMATION**

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RESPIRATORY PROTECTION (SPECIFY TYPE): Approved Respirator

VENTILATION: Local Exhaust Required

PROTECTIVE GLOVES: Rubber Gloves

EYE PROTECTION: Splash Proof Goggles

OTHER PROTECTIVE EQUIPMENT: Safety shower and eye wash equipment.

#### **SECTION IX SPECIAL PRECAUTION**

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PRECAUTIONS TO BE TAKEN IN HANDLING AND STORING: KEEP CONTAINER CLOSED. STORE IN A COOL PLACE.

OTHER PRECAUTION: WASH THOROUGHLY AFTER HANDLING. KEEP AWAY FROM SPARKS, FLAME AND HEAT. USE ONLY WITH ADEQUATE VENTILATION.

\*NOS: NOT OTHERWISE SPECIFIED

PREPARED BY: JERRY GALARNEAU 1/2/02