



Freeman Clear Silicone

Freeman Clear Silicone is a two component, room temperature vulcanizing (RTV) silicone rubber compound. Designed specifically for mold making, it is an ideal rubber for reproducing intricate detail and maintaining close tolerances. It features low viscosity for easy pouring and excellent clarity for ease of use and cutting visibility. It also features high tear strength and the ability to endure temperatures up to 350 F.

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- TYPICAL APPLICATIONS**
- Conventional production and prototype molds
 - Intricate wax patterns
 - Stereolithography (SLA) mold

TYPICAL PROPERTIES (AS SUPPLIED)

Part A - Base Component

Color	Translucent
Consistency	Pourable
Viscosity, cP. (mPa.s)	50,000

Part B-Catalyst Component

Color	Translucent
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TYPICAL CATALYZED PROPERTIES

Mixed at 24°C (75°F) and 50% R.H.

Mix Ratio, A:B (Parts by wt)	10:1
Viscosity, cP. (mPa.s)	40,000
Work Life, hours	1
Pot Life, hours	2

TYPICAL PROPERTIES OF CURED RUBBER

Cured 24 hours at 24°C (75°F) and 50% RH

Color	Translucent
Specific Gravity	1.08
Hardness (Shore A)	39 (ASTM D224)
Tensile Strength, psi (N/mm ²)	930 (4.8) (ASTM D412)
Elongation (%)	350 (ASTM D412)
Tear Resistance, ppi (N/mm)	135 (24) (ASTM D624, Die B)
Linear Shrinkage (%) 24 Hours	<0.1
Linear Shrinkage (%) 7 Days	<0.1
Temperature Range °C (°F)	-54 to 204 (-65 to 400)

NOTE: Cure may be accelerated by oven curing at 40-65°C (120-150°F) for 3-4 hours. HEAT CURING WILL AFFECT PHYSICAL PROPERTIES.

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FPB 917/12_06