



RTV 664, RTV 668

RTV 600 Series Addition Cure Mouldmaking Compounds

Product Description

RTV600 series is comprised of RTV664 and RTV668. Each is a two part, addition (platinum) curing mould making product offering high durometer for applications requiring greater dimensional stability.

RTV664 is a high durometer (62 Shore A). It offers excellent chemical and abrasion resistance and was designed for high production on manufacturing lines.

RTV664 may be used in food contact applications.

RTV668 is a high durometer (62 Shore A) product formulated for sulphur resistance. It is ideal for casting with masters made of pine, oak, and elm.

Key Performance Properties

- Excellent dimensional stability
- High tear strength
- High durometers 62 Shore A
- Virtually no shrinkage (room temperature cure)

Typical Product Data

Product Base	RTV 664 A	RTV 668 A
Colour	Beige	Beige
Viscosity, mPa.s	153,000	151,000
Density, g/cm ³	1.28	1.28
Catalyst	RTV 664 B	RTV 668 B
Colour	blue	green
Viscosity, mPa.s	6,000	3,800
Density, g/cm ³	1.05	1.05
Mix Ratio, (by weight)	10:1	10:1
Catalyzed Properties		
Viscosity, mPa.s	120,000	120,000
Worklife, hrs.	2	2
Demould time, hrs.	18	24
Shore A, 36 hrs.	62	62
Tensile strength, MPa	6.4	7.2
Elongation, %	245	240
Tear Strength, N/mm	22	18
Service Temperature, °C	-60/200	-60/200
Linear Shrinkage, %	< 0.2	< 0.2

Specifications

Typical product data values should not be used as specifications. Assistance and specifications are available by contacting GE Bayer Silicones Technical Service RTV1 and RTV2.

Instructions for Use**Mixing**

Select a mixing container 4-5 times larger than the volume of RTV silicone rubber compound to be used. Weigh out the RTV silicone rubber base compound and add the appropriate amount of curing agent. With clean tools, thoroughly mix the RTV base compound and the curing agent, scraping the sides and bottom of the container carefully to produce a homogeneous mixture. When using power mixers, avoid excessive speeds which could entrap large amounts of air or cause overheating of the mixture, resulting in shorter pot life.

Deaeration

Air entrapped during mixing should be removed to eliminate voids in the cured product. Expose the mixed material to a vacuum of 10 - 20 mbar. The material will expand, crest, and recede to about the original level as the bubbles break. Degassing is usually complete about two minutes after frothing ceases.

Automatic equipment designed to meter, mix, deaerate, and dispense two-component RTV silicone rubber compounds will add convenience to continuous or large volume operations.

Curing

RTV664 and RTV668 silicone rubber compounds will cure sufficiently in 24 hours at 25C. To achieve faster cure speeds, elevated temperatures may be used.

Handling and Safety

Material Safety Data Sheets are available upon request from GE BAYER SILICONES. Similar information for solvents and other chemicals used with the GE Bayer 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

RTV664 and RTV668 are available in kits of 450g, 5kg, 20 kg and 225 kg.

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