

# ELASTOSIL<sup>®</sup> M 4511

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## Room Temperature Curing Silicone Rubber (RTV-2)

Pourable, condensation-curing, two-component silicone rubber that vulcanizes at room temperature.

Main application: Making cost effective molds, specially suited for casting PE and PU resins.



## Properties

- very good flowability and self-deaeration
- very low Shore A hardness (approx. 12)
- high tear strength
- extremely high elongation and flexibility
- outstanding chemical resistance to attack by polyester and polyurethane resins, mold life is significantly extended

## Specific features

- Condensation-curing
- Flowable
- Resistance against polyester
- Resistance against PU
- Two-component

## Technical data

### Properties Uncured

Property	Condition	Value	Method
Color	-	white	-
Density	23 °C	1.22 g/cm <sup>3</sup>	-
Viscosity, dynamic after stirring	23 °C	25000 mPa·s	DIN EN ISO 3219

These figures are only intended as a guide and should not be used in preparing specifications.

### Catalyzed

with 5 wt % Catalyst T 51

Property	Condition	Value	Method
Viscosity, dynamic	23 °C	20000 mPa·s	ISO 3219

These figures are only intended as a guide and should not be used in preparing specifications.

### Properties Cured

with 5 wt % Catalyst T 51, after 4 days at 23 °C / 50 % rel. humidity

Property	Condition	Value	Method
Density in water	23 °C	1.22 g/cm <sup>3</sup>	ISO 2781
Tear strength	-	> 18 N/mm	ASTM D 624 B
Hardness Shore A	-	12	ISO 868
Tensile strength	-	3.5 N/mm <sup>2</sup>	ISO 37
Elongation at break	-	600 %	ISO 37
Linear shrinkage	-	< 0.4 %	-

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All the information provided is in accordance with the present state of our knowledge. Nonetheless, we disclaim any warranty or liability whatsoever and reserve the right, at any time, to effect technical alterations. The information provided, as well as the product's fitness for an intended application, should be checked by the buyer in preliminary trials. Contractual terms and conditions always take precedence. This disclaimer of warranty and liability also applies particularly in foreign countries with respect to third parties' rights.

## Applications

- Reproduction Molding

## Application details

ELASTOSIL® M 4511 is a high-performance moldmaking compound, which is particularly suitable for the reproduction of models with extensive undercuts. ELASTOSIL® M 4511 is especially suitable for the processing of polyester and polyurethane resins.

Due to its very high extensibility and low flexural modulus, ELASTOSIL® M 4511 is best suited for the reproduction of fine or fragile models, where the piece may be damaged by more rigid molding materials on demolding.

ELASTOSIL® M 4511 exhibits low hardness and high strength, plus excellent ink transfer characteristics. These make it a perfect base material for the production of printing pads.

## Processing

If molds for processing epoxy or polyurethane resins are to be made, ELASTOSIL M 4511 is cured by adding 5 wt % Catalyst T 21.

For molds used to process other reproduction materials such as polyester resins, plaster, concrete, synthetic stone, wax or low-melting alloys, 5 wt % Catalyst T 51 should be used.

Catalyst	Pot life, [min]	Curing time (tack-free), [h]
5 % T 21	60-90	8-10
5 % T 51	60-90	8-10

Pot lives and curing times of both catalysts may be accelerated, and thus adjusted to suit the individual application by blending with Catalyst T 47. For faster curing either catalyst may be blended with Catalyst T 47. E.g. at a ratio of 95 : 5 (T51 : T47) the pot life decreases to about 30 min, and the mold needs only about 4 h to cure.

Further instructions on blending any catalyst with Catalyst T 47 may be found in our data-sheet: **"WACKER® T-series catalysts"**.

The pot life is the period of time at 23 °C / 50 % rel. humidity during which the catalyzed mix to attain a viscosity of 100000 mPa s and still be just pourable

**Please check also our brochures and info sheets.**

## Packaging and storage

### Storage

The 'Best use before end' date of each batch is shown on the product label.

Storage beyond the date specified on the label does not necessarily mean that the product is no longer usable. In this case however, the properties required for the intended use must be checked for quality assurance reasons.

## Safety notes

Comprehensive instructions are given in the corresponding Material Safety Data Sheets. They are available on request from WACKER subsidiaries or may be printed via WACKER web site [www.wacker.com](http://www.wacker.com).

## QR Code ELASTOSIL® M 4511



**For technical, quality or product safety questions, please contact:**

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