



Technical Data Sheet

Stretch FX

22 Shore A, Addition Cure, Translucent Moldmaking Material

PRODUCT DESCRIPTION

Stretch FX is a two-component, room temperature, addition cure, silicone material. The cured rubber has excellent mechanical properties and good shelf-life stability. This material is a good choice for moldmaking of intricate patterns, skin molding and applications where a low durometer translucent material is required.

KEY FEATURES

- Low viscosity
- Fast demold time
- Elongation > 1200%
- Excellent flexibility
- Translucent, pigmentable

MAIN APPLICATIONS

- Special effects
- Skin replication
- Applications where pigmentation is required

TYPICAL PROPERTIES

UNCATALYZED		
TEST	Stretch FX A	Stretch FX B
Appearance	Translucent	Translucent
Viscosity	25,000 cps	2,000 cps
Specific Gravity	1.12	0.98

CATALYZED	
MIX RATIO 10:1 by weight	
PROPERTY	RESULT
Catalyzed color	Translucent
Catalyzed viscosity	10,000 cps
Work life at 25°C *	32 minutes
Demold time	6 - 8 hours

* Work life is defined as the time required for the material to double in catalyzed viscosity.



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CURED PROPERTIES	
PROPERTY	RESULT
Durometer, Shore A	22
Tensile	500 psi
Elongation	1,200 %
Tear B	100 ppi
Linear Shrinkage	< 0.1 %
Useful temperature range	- 60°C - 204°C

CURE CHARACTERISTICS

Stretch FX A is catalyzed with Stretch FX B at a 10:1 ratio (base:catalyst) by weight. In order to achieve optimum performance the same lot number of Stretch FX A and Stretch FX B should be used.

The curing process begins as soon as the catalyst is mixed with the base. The material will cure as described in the data above under normal temperature (25°C) and humidity conditions (50% RH). Because this system is sensitive to heat and humidity, a change in cure speed may be observed if one or both of these variables are altered. A large difference in temperature (+/- 5°C) or humidity (> 60% – 70%) may alter the cure profile of the material. In addition, if the product is to be used with aggressive resins such as high styrene polyester resins, it is recommended that the rubber be allowed to cure for 48 hours.

MIXING

QSi recommends that the catalyzed material be tested on a small area of the mold prior to use. .

Combine ten parts of Stretch FX A with one part of Stretch FX B by weight into a clean, compatible container and mix by hand or with mixing equipment until a uniform consistency is observed. Accurate weighing of components on a suitable scale is essential for optimal product performance. The material should have a uniform color with no visible striations.

DE-AERATION

Air trapped during mixing should be removed by vacuum at 29 inches of mercury. During the process, the material will expand and intermittent evacuation may be required. Typically after releasing the vacuum 2 - 3 times, the mass will collapse on itself at which time the vacuum should be left on for an additional 2 - 4 minutes.

Machine mixed material does not normally need to be de-aired.



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STORAGE AND SHELF LIFE

If Stretch FX A and Stretch FX B are stored in their original unopened containers, in an environment that does not exceed 38°C (100°F) then QSi will warranty the material for a period of 12 months from the date of shipment.

DISCLAIMER

The technical data listed is provided for reference only and is not intended as product specifications. QSi has the capability to customize products as requested. For sales and technical assistance please contact customer service at (804) 271-9010 or 1-800-852-3147.

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