

TC-5120 A/B

20 SHORE A

TRANSLUCENT SILICONE RUBBER



TC-5120 A/B is a room temperature, 20 shore A, addition/platinum curing silicone rubber designed for part making or mold making. TC-5120 A/B is easy to use with its 100 to 100 parts by weight ratio.

- Flexible Molds
- Easily Pigmented
- Encapsulation
- Parts and Skins

PHYSICAL PROPERTIES	TEST METHOD	RESULTS
Hardness, Shore A	ASTM D2240-04e1	20 ± 5
Density (g/cc)	ASTM D792-00	1.052
Cubic Inches per Pound	N/A	26.42
Color/Appearance	Visual	Colorless/Translucent
Tensile Strength (psi)	ASTM D412-98a(2002)e1	380
Tensile Modulus (psi)	ASTM D412-98a(2002)e1	170
Elongation (%)	ASTM D412-98a(2002)e1	400
Tear Strength (pli)	ASTM D624-00e1 Die B	26
Shrinkage (in/in) linear	ASTM D2566 @ 1" depth	Nil
Dielectric Constant, 1 MHz	ASTM D150-87	2.839
Dissipation Factor, 1 MHz	ASTM D150-87	0.0023

HANDLING PROPERTIES	Part A	Part B
Mix Ratio by weight	100	100
Mix Ratio by volume	98	100
Specific Gravity @ 77°F (25°C)	1.06	1.04
Color	Colorless	Colorless
Viscosity (cps) @ 77°F (25°C) Brookfield	16,500	12,800
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	15,000	
Work Time, 100g mass @ 77°F (25°C)	40 minutes	
Gel Time	85 minutes	
Demold Time @ 77°F (25°C)	24 hours	

INHIBITION:

Certain materials will cause inhibition or neutralization of the curing agent. These materials include condensation/tin cured based silicone, lacquer and enamel coatings, polyester-based products, copper or copper containing metals, some SLA resins, and natural rubbers like latex. Inhibition may easily be determined by brushing a small quantity of TC-5120 A/B over a localized area of the surface to be reproduced. If the TC-5120 A/B is tacky or uncured after the cure time, then you know the mold surface is acting as an inhibitor. Molds made from wood, plaster, steel, aluminum, or plastic should not cause inhibition if they are clean. To insure against possible problems, it is advisable to spray a barrier film over any questionable surfaces. This is the best way of treating clays and other surfaces that cause inhibition. Contact BJB for recommended products.

STORAGE:

Store ambient temperatures, 65-80°F (18-27°C). Unopened containers will have a shelf life of 6 months from date of shipment when properly stored at recommended temperatures. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING	Part A	Part B	Cubic Inches per Kit
Quart Kits	2 lbs.	2 lbs.	106
Gallon Kits	8 lbs.	8 lbs.	423
5-Gallon Kits	40 lbs.	40 lbs.	2,114
55-Gallon Drum Kits	450 lbs.	450 lbs.	23,778

SAFETY PRECAUTIONS:

Use in a well-ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction. Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product.

IF CONTACT OCCURS:

- Skin:** Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. It is *not* recommended to remove resin from skin with solvents. Solvents only increase contact and dry skin. Seek qualified medical attention if allergic reactions occur.
- Eyes:** Immediately flush with water for at least 15 minutes. Call a physician.
- Ingestion:** If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.

Refer to the Material Safety Data Sheet before using this product.



Silicone Handling Guide



TC-5120 Part A SDS



TC-5120 Part B SDS