

PRODUCT DATA SHEET

SikaBiresin® SI292

Translucent polyaddition-cure silicone elastomer with long pot life

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Component A SikaBiresin® SI291	Component B SikaBiresin® SI292
Chemical base	2-component silicone	
Cure mechanism	Polyaddition	
Color	Translucent	Transparent
	mixed	Translucent
Density	1.08 kg/l	0.98 kg/l
	cured	1.05 kg/l
Mixing ratio	by weight	100 : 10
Viscosity (by Brookfield)	130 000 mPa·s	3000 mPa·s
	mixed	60 000 mPa·s
Pot life (CQP021-4)	200 g at 23 °C	110 minutes
Demolding time	at 23 °C	16 hours
	curing after gel, at 40 °C	10 hours
Shore A hardness (CQP023-1 / ISO 868)	34 ^A	
Tensile strength (ISO 37)	3.8 MPa ^A	
Tear strength (CQP045-1 / ISO 34)	11.4 kN/m ^A	
Elongation at break (ISO 37)	571 % ^A	
Shelf life	12 months	

CQP = Corporate Quality Procedure

^{A)} curing condition: 23 °C for 7 days

DESCRIPTION

SikaBiresin® SI292 is a polyaddition-cure silicone system for production of flexible molds in the prototyping industry with good chemical resistance.

SikaBiresin® SI291 (A) is also available with a catalyst SikaBiresin® SI291 (B) for production of translucent parts.

PRODUCT BENEFITS

- Long pot life
- Oily catalyst for longer mold life
- Good chemical resistance towards polyurethanes
- High tear and tensile strength
- Low-shrink curing at room temperature
- Easy to mix and to cast

AREAS OF APPLICATION

SikaBiresin® SI292 is designed for production of flexible silicone molds in the prototyping industry.

The material is particularly suitable for casting prototypes and technical parts using vacuum casting resins.

Complex geometries with undercuts can be easily reproduced using this material.

This product is suitable for experienced professional users only. Tests under actual processing conditions and with additional materials such as coatings and release agents must be performed to proof material compatibility.

METHOD OF APPLICATION

Surface preparation

The material and processing temperature shall be between 18 °C and 25 °C.

Make sure the mold or master model is clean, dry, dust and grease free.

Mixing process

Select a smooth-walled container that has 5 times the volume of the mixture to be processed.

Both components must be mixed thoroughly respecting the defined mixing ratio. The mixing can be performed with a spatula or a machine stirrer at ≤ 300 rpm.

Do not forget to scrape the bottom and side of the container with a spatula and mix again. To avoid bubbles, the mixture shall be evacuated under vacuum for maximum of 15 minutes.

Cast the Product in the frame or the mold within 10 to 15 minutes.

Note: Both containers must be closed tightly immediately after use.

Once opened the Product shall be used up as soon as possible.

Application

Leave it to cure at room temperature. After bubble-free casting the curing time can be shortened by heating to a maximum temperature of 40 °C. If heat cured, higher shrinkage and hardness must be expected.

Polyaddition-curing silicone elastomers show a high sensitivity to certain substances, which inhibit the proper hardening of the material.

The following substances are critical: amines, polyurethanes, epoxies another nitrogenous substances, polysulfones, polysulfides, natural and synthetic rubber and other sulfurous substances, organometallic compounds, vulcanizates and (tin-catalyzed) hardeners of condensation-curing silicones. The effect of this irreversible inhibition is a sticky silicone mass. Always check the compatibility of the model material and the silicone.

SikaBiresin® SI292 (B) is not suitable for transparent castings.

STORAGE CONDITIONS

Both components must be stored at temperature between 15 °C and 25 °C in original unopened containers.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

SikaBiresin® SI291 (A)

Hobbock	20 kg
Drum	200 kg

SikaBiresin® SI292 (B)

Canister	2 kg 20 kg
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BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

PRODUCT DATA SHEET

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