SILISIL ZCX 15-3

Technical Data Sheet

1. DESCRIPTION

SILISIL ZCX 15-3 is a poly-condensation curing two component silicone that vulcanizes at room temperature. It presents the following special features:

- Low Shore A hardness (approximately 14)
- High tear strength
- Low dimensional variations
- No inhibition with common materials like plaster, clay or cement

2. MAIN AREAS OF APPLICATION

- Industrial applications where high mechanical resistance is demanded

3. MIXTURE AND APPLICATION

Surface preparation
The surfaces to be reproduced must be clean, dry, and dust-free. Ideally, work at room temperature (approx. 23°C) to ensure consistent processing and curing times.

1. **Preparation:** Shake or stir both components (base and catalyst) well before use to ensure a homogeneous consistency.
2. **Mixing:** Weigh the base and catalyst precisely **in a 10:1** ratio. Mix the components thoroughly, carefully incorporating the mixture into the container walls and bottom.
3. **Processing:** Pour the mixed silicone slowly, ideally from a height of about 30 cm, into the prepared mold to minimize air pockets.
4. **Curing:** Vulcanization takes place at room temperature (23°C). The working time of the product is around 2 hours, demolding is possible after 18-24 hours. The complete mechanical properties and hardness will be reached after 72 hours from the mixing.

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4. IMPORTANT RECOMMENDATIONS

- Before handling the product, read the safety data sheet and make sure to get all the information required for safe use.
- Test the product in small scale quantity before extending the use in larger scale.
- Exact proportions 10:1 must be respected to guarantee the final characteristics of the product.
- It is recommended to use vacuum to eliminate any air bubbles.
- If necessary, use compressed air to facilitate separation. Do not use any tools to force the separation of the model from the mold.
- The working time WT (see table below), also known as "pot life", is the recommended time for mixing/vacuuming prior to casting.
- To increase the working/setting time of RTV2 silicones, you may add SILISIL Delayer PA to the catalyst. For more information, please refer to SILISIL Delayer PA TDS or consult your technical contact at SILITECH AG.
- The working time and setting time are reduced if the temperature exceeds 23°C (e.g., if the temperature is 40°C, the working time and setting time are approximately cut in half). If the temperature is less than 23°C, the working time and setting time increase considerably.
- Close the bottles after use, do not change the caps or lids between the base and catalyst.

5. TECHNICAL DATA

Base (uncured)

Properties	**Specifications**
Color	White
Viscosity of pre-catalyzation mixture	>53000 cP
Density	1,2 g/cc
Working time/Pot life	101'
Shore 00 hardness	58,5 sh00

Catalyst (uncured)

Properties	**Specifications**
Color	Transparent
Viscosity of pre-catalyzation mixture	18 cP
Density	0,95 g/cc
Working time/Pot life	61'

Base + Catalyst (cured components)

Properties	Specifications
Color	White
Viscosity	26500 cP
Mixing ratio	10:1
Working time/Pot life	>2h
Setting time	12 hours
Shore A hardness	14 shA
Tensile Strength	3,3 MPa
Enlargement in %	525 %
Tear strength	21,7 N/mm^2

6. PACKAGING

SILISIL ZCX 15-3 is available as standard in 20 kg + 2 kg, and 200 kg + 20 kg containers. Other container sizes are available upon request.

7. SAFETY INSTRUCTIONS

Before handling the product, read the safety data sheet and ensure that you have all the information required for safe use.

8. IMPORTANT NOTE

This document contains information provided to the best of our knowledge and belief, based on the current state of our understanding. This information is for guidance only and does not constitute any obligation on our part, particularly in the event of an infringement of third-party rights through the use of our products. This information should be supplemented by preliminary testing to ensure the product's suitability for its intended purpose.