



## RTV31, RTV60, RTV88

### *Silicone Rubber Compounds for High Temperature*

#### **Product Description**

RTV31, RTV60 and RTV88 silicone rubber compounds are high temperature two-part silicone elastomers. They are supplied ready-to-use with a base compound and DBT (dibutyl tin dilaurate) as the standard curing agent. DBT is suitable for most applications, however other catalysts are available to facilitate deep section cure, faster cure and automated mixing.

RTV31, RTV60 and RTV88 silicone rubber compounds differ primarily in viscosity in the uncured state.

#### **Key Performance Properties**

- Variable work times and cure rates by adjusting the amount and type of curing agent
- Room temperature cure
- Composition free of solvents and solvent odour
- Excellent adhesion capabilities with primer
- Excellent release properties
- Retention of elastomeric properties at temperatures from -54°C up to 260°C continuously, and up to 316°C for short periods of time

#### **Applications**

Typical high temperature applications for these products include, but are not limited to:

- Potting and encapsulating electric motors and transformers
- Fabrication of rubber parts
- Casting moulds for low-melting point metals
- Release applications such as rubber rollers
- Thermal insulation

#### **Typical Product Data**

<b>UNCURED PROPERTIES OF RTV BASE COMPOUNDS</b>	<b>RTV31</b>	<b>RTV60</b>	<b>RTV88</b>
Colour	Red	Red	Red
Consistency	Pourable	Pourable	Spreadable Paste
Viscosity, mPa-s	25,000	47,000	880,000
Specific Gravity, g/cm <sup>3</sup>	1.42	1.48	1.47
<b>UNCURED PROPERTIES OF RTV BASE WITH 0.5% DBT CURING AGENT ADDED</b>	<b>RTV31</b>	<b>RTV60</b>	<b>RTV88</b>
Work Time @ 25C, hrs	2	2	0.75
Cure Time @ 25C, hrs	24	24	24

<b>CURED PROPERTIES</b> (0.5 wt. % DBT Curing Agent added, cured 7 days at 25C and 50% R.H.)	RTV31	RTV60	RTV88
<b>Mechanical</b>			
Hardness, Shore A Durometer	54	57	58
Tensile Strength, MPa	6.0	7.0	6.0
Elongation, %	170	120	120
Tear Strength, kN/m	5.0	7.0	8.0
Shrinkage, %	0.6	0.6	0.6
<b>Electrical</b>			
Dielectric Strength, kV/mm (1.9 mm thick)	17.0	17.7	17.4
Dielectric Constant @ 1000 Hz	4.4	4	4.3
Dissipation Factor @ 1000 Hz	0.03	0.02	0.03
Volume Resistivity, ohm-cm	$1.6 \times 10^{14}$	$4.4 \times 10^{14}$	$2.8 \times 10^{14}$

### Typical Product Data

<b>Thermal</b>			
Useful Temperature Range, ° C	-54 to 260	-54 to 260	-54 to 260
Thermal Conductivity, W/m-K	0.31	0.31	0.31
Coefficient of Expansion, cm/cm, ° C	$20 \times 10^{-5}$	$20 \times 10^{-5}$	$20 \times 10^{-5}$
Specific Heat, cal/gm, ° C	0.35	0.35	0.35

### Specifications

Typical product data values should not be used as specification. Assistance and specifications are available by contacting GE Bayer Silicones Technical Service RTV1 and RTV2.

### Instructions for Use

#### Mixing

Select a mixing container 4 to 5 times larger than the volume of RTV silicone rubber compound to be used. Weigh out the RTV silicone rubber base compound and add the appropriate amount of curing agent. 0.5% DBT by weight will provide a work time or pot life of about one hour and a cure time of 24 hours. 0.5% DBT is the most commonly used concentration of curing agent for RTV31, RTV60 and RTV88 silicone rubber compounds. The pot life may be lengthened by using less DBT (as little as 0.1% DBT).

#### MEASURING GUIDE FOR CURING AGENT ADDITION

RTV Weight	Dibutyl Tin Dilaurate Concentration	
	0.1%	0.5%
100 grams	5 drops	25 drops
454 grams (1 lb.)	23 drops	115 drops (2.27 grams)

With clean tools, thoroughly mix the RTV base compound and the curing agent, scraping the sides and bottom of the container carefully to produce a homogeneous mixture. When using power mixers, avoid excessive speeds which could entrap large amounts of air or cause overheating of the mixture, resulting in shorter pot life.

### Deaeration

Air entrapped during mixing should be removed to eliminate voids in the cured product. Expose the mixed material to a vacuum of 10-20 mbar. The material will expand, crest, and recede to about the original level as the bubbles break. Degassing is usually complete about two minutes after frothing ceases. When using the RTV silicone rubber compound for potting, a deaeration step may be necessary after pouring to avoid capturing air in complex assemblies.

### Curing

Using DBT curing agent at a level of 0.5%, these RTV silicone rubber compounds will cure in 24 hours at 25° C and 50% relative humidity to form durable, resilient rubbers. Under these conditions a pot life of about one hour will typically be available for pouring and working with the catalyzed material. Pot life may be increased by refrigerating the mixed material at 0° C after catalyzing. Cure times may be shortened by using mild heat up to 93° C maximum.

A choice of curing agents is available for use with RTV31, RTV60 and RTV88 silicone rubber compounds.

Curing Agent	Cure Speed	Curing Agent Concentration	Features
DBT	moderate	0.1-0.5%	standard
STO	fast	0.1-0.5%	small volume applications
RTV9811	moderate	5-10%	good deep section cure suitable for automatic mixing
RTV9950	moderate	5-10%	suitable for automatic mixing
RTV9910	slow	10%	suitable for automatic mixing

### Deep Section Cure

If these RTV silicone rubber compounds are to be used in deep sections at temperatures over 150° C, the cured product should be properly conditioned prior to service. Following room temperature cure of 1-3 days, a typical program would be eight hours at 50° C intervals from 100° C to the service temperature. Longer times at each temperature will be required for larger parts or very deep sections.

### Bonding

If adhesion is an important application requirement, RTV31, RTV60 and RTV88 silicone rubber compounds require a primer to bond to non-silicone surfaces. Thoroughly clean the substrate with a non-oily solvent such as naphtha or methyl ethyl ketone (MEK) and let dry. Then apply a uniform thin film of a suitable silicone primer such as SS4004P and SS4155 silicone primer and allow the primer to air dry for one hour or more. Finally, apply freshly catalyzed RTV silicone rubber compound to the primed surface and cure as recommended.

### Handling and Safety

Material Safety Data Sheets are available upon request from GE BAYER SILICONES. Similar information for solvents and other chemicals used with the GE Bayer products should be obtained from your supplier. When solvents are used, proper safety precautions must be observed.

**Storage and Warranty  
Period**

The warranted shelf life will be indicated by the 'use before date' on the associated documents with a minimum of 4 month when stored in the original unopened containers below 25° C.

**Availability**

RTV31/60/88 are available in 227 kg drums for which the catalyst needed has to be ordered separately. Further in 450 g, 5.5 kg and 23 kg containers all supplied with the DBT amount needed to catalyze the material. If other catalysts are desired for a specific application this should be ordered separately.

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