



TECHNOLOGY MAKES LIFE BETTER

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日月科技园

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安徽艾约塔硅油有限公司

IOTA CORPORATION LTD.

Sunmoon industry park, 985 Xingzhong Road,
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Food grade silicone rubber for mold making

1: 1 component liquid silicone is addition type non-toxic and tasteless liquid mold silicone rubber, can be placed in the oven pan, resistant to high temperature 250 °C, long-term stability can be used within 200 °C. This product pass the FDA food-grade certification, could be used to produce adult products, human organs, body parts, mannequin, chest pads, shoulder pads and other soft silicone rubber. Also used in food molds, candy molds, cake molds, as well as a good material for soap cake mold making.

Product technical data

Item number	Color	Hardness(A)	Viscosity(cps)	Tear strength(KN/m)	Tensile strength(Mpa)	Elongation (%)	Shrinkage (%)
IOTA 15000	Semi-transparent	0	5000±1000	≥2	2.0	≥500	≤0.1
IOTA 1505	Semi-transparent	5±2	5500±1000	≥4	2.5	≥550	≤0.1
IOTA 1510	Semi-transparent	10±2	6000±1000	≥12	3.0	≥500	≤0.1
IOTA 1515	Semi-transparent	15±2	8000±1000	≥13	3.2	≥450	≤0.1
IOTA 1520	Semi-transparent	20±2	10000±1000	≥16	3.5	≥400	≤0.1
IOTA 1525	Semi-transparent	25±2	15000±1000	≥16	4.0	≥420	≤0.1
IOTA 1530	Semi-transparent	30±2	20000±1000	≥17	4.5	≥350	≤0.1
IOTA 1540	Semi-transparent	40±2	22000±1000	≥17	4.5	≥330	≤0.1
IOTA 1550	Semi-transparent	50±2	25000±1000	≥15	4.6	≥170	≤0.1
IOTA 1560	Semi-transparent	60±2	45000±1000	≥14	4.8	≥150	≤0.1

Products Procedure

1. Mixing: The A and B rubber 1: 1 weight ratio mix and stir evenly.
2. Discharge bulbs: For high requirements should be evacuated discharge bubbles, otherwise the mold will have bubbles.
3. Material pouring: pour the mixing the stirred liquid silicone into the mold box.

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Precautions For Use

1. Before large-scale use, please do small amount of trial, familiar with the production skills to avoid errors.
2. Do according to the manufacturer's instructions ratio for quantity, and the weighing accuracy, please remember that the ratio is by weight rather than volume. After the mixing of AB silicone rubber, stir it fully to avoid not cure or incomplete cure.
3. When make the mold frame, if 502 glue is applied, pour the mixing silicone rubber after half an hour or put it into oven at 50°C for 10 minutes, to prevent 502 glue and silicone poisoning to make it not cure.
4. To accelerate the curing time, heating method can be used to speed up the curing rate of silicone rubber.
5. When mixing the AB silicone, mixing in the same direction. When pour glue, take a little bit of the higher and same position on the female die on the same position, let the glue flow flat on the master die, it will increase the flow time of the glue to reduce the bubble. Generally, the silicone in hardness higher than 20, it will need to do vacuum pumping before use.
6. 1:1 Addition products will have toxic reaction with tin, phosphorus, ammonium, chlorine, carboxylic acids, thiol, hydroxyl and other compounds. It is forbidden to contact with such compounds to avoid the occurrence of non-curing.

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