



# Factor II, Incorporated

Inventing and Innovating...

(Information: 1.928.537.8387)

ONLINE ORDERING [www.factor2.com](http://www.factor2.com)

## PRODUCT INFORMATION

### A-2000

### Silicone Elastomer

#### PRODUCT DESCRIPTION:

Factor II Inc. A-2000 is a translucent platinum cure, two part silicone elastomer formulated to provide excellent properties and working characteristics for special prosthetic applications. It is a 1:1 mixing ratio with an overnight cure @77°F.

#### TYPICAL PROPERTIES AS SUPPLIED:

#### TYPICAL CURED PROPERTIES

Color .....Translucent  
Viscosity A .....40,000cps  
Viscosity B, cps .....31,000cps

Durometer Shore A .....25  
Tensile Strength, psi.....750  
Elongation, %.....475

#### Preparation and Mixing:

1. Clean stainless steel spatula with IPA isopropyl alcohol, wipe clean and dry.
2. Using a clean container such as glass, stainless steel or a 16-20oz polypropylene container (D-234).
3. Weigh equal parts of A & B, 1:1. Always measure A first to avoid confusion, then add B mix together thoroughly.
4. Add necessary Intrinsic II, pigments:

At his point the material must be vacuum deaired or Thixotropic agent may be added.

#### A. Vacuum Deairing

Care should be taken to minimize air entrapment during mixing. Vacuum deairation at 28 inches Hg is recommended. Apply vacuum to a container at least four times the volume of the material to avoid overflow of the bubbles. Large bubbles will be formed almost immediately. Allow the material to reach it's maximum capacity, and to fall to the bottom of the container. Continue to hold the vacuum for 3 to 5 minutes. This will eliminate the smaller bubbles. When packing the material into a mold care should be taken to minimize trapping air bubbles.

#### B. Thixotropic Agent A-300-8

An alternaive to vacuum deairing is to add 1-2 drops of thixo per 10gms of mixed material. This will raise the viscosity of the silicone and create sufficient pressure inside the mold so as to prevent air bubbles

#### Working Time

At room temperature approximately 45 minutes.

Pack material into mold close and clamp mold. Place into a dry heat oven at Room Temperature.

Elevate temperature to 165°F for 3 to 4 hours. Turn oven off and allow mold to return to room temperature before removing mold. Recommend turning oven off and leaving overnight to return to room temperature. Larger molds will require more time in oven or elevate temperature to 180°F.



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## **Cure Inhibition:**

Inhibition or contamination is caused by trace quantities of certain types of chemicals. The most common cause of inhibition is sulfur or any sulfur containing chemical compound amines and other nitrogen containing compounds acitic materials organic compounds and some RTV silicone catalyst. These chemicals will interfere with the cure reaction and thus prevent the material from curing. **The use of latex gloves can cause contamination and an incomplete cure.**

## **Other Contamination:**

Inhibition sometimes will occur on the exposed surface of a casting while it is curing in a contaminated oven. In these cases the atmospheres within the oven contains sufficient contaminates leftover from a previous product placed into the oven (for example form latex). This will exhibit itself as a surface inhibitor and an incomplete cure of the surface of the elastomer.

## **Mold Contamination:**

Molds are another potential source of inhibition. This will exhibit surface contamination or incomplete cure of the casting where it contacts the mold.

This can be caused by:

- A. Inappropriate mold material.
- B. Oil base sculpting medium.
- C. Previous casting of a condensation cure RTV Elastomer.
- D. Mold release contaminate or propellant.

New applications with mold making materials should always be tested until proven safe for use with platinum silicones.

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