



# Factor II, Incorporated

Inventing and Innovating...  
(Information: 1.928.537.8387)  
ONLINE ORDERING [www.factor2.com](http://www.factor2.com)

## PRODUCT INFORMATION SILICONE PUTTY FX-304

### PRODUCT DESCRIPTION:

PUTTY IMPRESSION SYSTEM is a two part, 100% solids, paste consistency silicone elastomer. Mixed material can be applied into desired shape and will cure at room temperature into firm elastomer with a dimensional accuracy of about 99.95%.

PUTTY IMPRESSION SYSTEM is a pigmented tan and is opaque. Additional pigments can be added to produce coatings of other colors, as desired.

### INSTRUCTIONS MIXING AND USE:

This product is designed to be mixed in the ratio of 1 part by weight of crosslinker to 1 part by weight of base. Visual estimation of proportions is usually sufficient. Measure out the desired quantities of respective components and knead with fingers until color is uniform. Be careful not to mix more than can be applied in two minutes.

Immediately after mixing, press material into desired shape. Take care to avoid air entrapment.

Temperature will affect cure rate. Requirement for cure are dependent on the particular application and should be determined by the user.

### TYPICAL PROPERTIES:

BASE, AS SUPPLIED (PART A)	
COLOR	LIGHT TAN, OPAQUE
CONSISTENCY	PUTTY
CROSSLINKER, AS SUPPLIED (PART B)	
COLOR	GREEN
MIXED, UNCURED:	
COLOR	GREEN/WHITE
CONSISTENCY	PUTTY
WORKING TIME @25°C, MINUTES	1
MIXED AND CURED, 1:1 RATIO: (CURED 15 MINUTES AT 25°C)	
DUROMETER, SHORE A UNITS	55
ELONGATION, %	100
TEAR STRENGTH, ppi	30

Values listed are typical and not intended for use in specifications.

### SAFETY PRECAUTIONS:

Contact with the eye may cause temporary eye discomfort. Do not get in eyes.



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## APPLICATIONS and PRECAUTIONS:

The components of this product are designed to be mixed in a 1:1 ration. Visual estimation of proportions within 10% is sufficient to achieve the proper mix ration. Cure rate is very sensitive to ambient temperature. Temperatures below 20° C will increase work and cure time. Refrigeration of components prior to use can be used to extend work time if desired. Putty should be finger kneaded. Determine the amount required and quickly mix components together until color is homogeneous. After mixing, the material is applied within one minute to the desired conformaion and cures in about three minutes to a firm dimensionally stable elastomer. (Take care to avoid frothing when mixing and avoid air entrapment when applying to the desired mold or surface.)

Contamination by trace amounts of various compounds can result in unreliable cure of the material. Therefore, it is important to avoid contamination of the product and any surface/material to which the product is exposed. All the equipment should be thoroughly clean. Organic rubbers often contain compounds which can interfere with the cure of this material and should be avoided. Inhibition may be detected by applying a small quantity of compounded material over a localized area of the surface. If material is gummy after curing time, surface is acting as an inhibitor.

Do not cross contaminate Base and Crosslinker.

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