

***** Hei-Tool S7691 *****

1. Overview

Hei-Tool S7691 is an addition type silicone rubber putty developed for applications such as repairing material for silicone rubber mold, jigs, simplified mold and putty to fill voids on various members.

It has the following characteristics.

- (1) Because the color of each component is different, it's possible to check the mixing state visually.
- (2) It is easy to weigh because the mixing ratio is 1:1 (by weight).
- (3) It has fast curability and reaches practical strength in about 15 minutes.
- (4) A rubbery cured material with less shrinkage is obtained.
- (5) It is excellent in releasability and can be used as a small simplified mold for polyurethane casting resin such as Hei-Cast series.

2. Basic characteristics

Item		Values	Notes
Appearance	A component	White putty	Silicone compound
	B component	Yellow putty	Silicone compound
	Cured material	Yellow rubbery	
Specific gravity (25°C)	A component	1.39	JIS K-6911 Weight conversion in water
	B component	1.37	
	Cured material	1.38	
Mixing ratio	A:B	1 : 1	Weight ratio
Pot life	25°C	3-4 mins.	Time to maintain plastic deformation
Cure time	25°C	15 mins.	
Hardness	Shore A	60	Wallace hardness meter
Tensile strength	MPa	2.0	JIS K-6251
Elongation	%	120	
Tear strength	N/mm	10	JIS K-6252
Linear shrinkage	%	0.1~0.2	In-house test

3. How to use

(1) Weighing

The mixing ratio of A component and B component is 1:1 by weight.

Weigh out even amounts of A component and B component each.

Even if the ratio deviates slightly from the prescribed ratio, it hardens without any problem.

(2) Mixing

Knead well both components with hand until the mixture becomes even color.

When using gloves, use polyethylene ones. If using rubber gloves, curing inhibition may occur.

(3) Embedment/mold making

Knead thoroughly for about one minute, then move to the operation for embedding or mold-making.

If the pot life passes, the mixture will not be deformed and will not be suitable for the shape of the object. Pot life depends greatly on temperature.

(4) Removal (use as mold)

It reaches practical strength in 10 to 15 minutes, and then it can be removed from the object.

4. Handling precautions

- (1) Even if both materials are only in contact with each other for a while, it will harden. Therefore, be sure to store them in each separate container.
- (2) Always seal the container after use and store it in a cool and dark place.

5. Safety and health precautions

- (1) If the material gets into eyes, rinse immediately with flowing water for about 15 minutes and consult an ophthalmologist.
- (2) Do not transfer it to other containers to avoid accidental ingestion.
Also, if you swallow it by mistake, do induce vomiting immediately.
- (3) When disposing of raw materials, mix and cure the A component and B component, and dispose of them as waste according to disposal methods of each district.

6. Packing form

A component 1 kg

B component 1 kg

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