

Econosil®

For Low Temperature Metal Direct Casting

Technical Datasheet



Castaldo Econosil® Jewelry Molding Rubber is a harder, firmer but still flexible version of our Castaldo Super High Strength™ silicone jewelry molding rubber at a lower cost.

Econosil is the fast & easy way to mold and cast almost anything in metal. Use it to make:

Toy soldiers - Chess pieces - Fantasy figures - Cabinet knobs - Fishing lures - Jewelry - Machine and tool parts - Everything and anything!

Econosil withstands temperatures up to 660°F/ 350°C. It can be used to cast lead, pewter, tin, zinc and other low temperature melting alloys.

Econosil a brick-red/brown color and is lined with special release paper on both sides. Complete instructions are enclosed in each box. For a more complete description and detailed instructions, please refer to our free technical bulletin.

Econosil Jewelry Molding Rubbers is available in two formats: Traditional strips: 18" x 2 7/8" x approximately 3/8" / 45.7 cm x 7.3 cm x approximately 6 mm. Packaged in attractive, consumer-oriented boxes weighing 5 lbs. / 2.27 kg. It is packed 10 boxes to a carton for a total net weight of 50 lbs. / 22.7 kg.

New squares: 11.8" x 11.8" x 3/8" / 30 cm x 30 cm x 7 mm and weighing 1 kg. / (2.27 lbs) per square. Special sizes are available on request. The new squares are packaged in boxes containing 5 kg. / 11.0 lbs. and 20 kg. / 44.0 lbs.

Name

Econosil

Shore A Hardness	48-50
Vulcanizes at	165 - 176°C
Rubber Shrinkage	Low 1.1%
Break Elongation	555%
Break Tensile Strength	6.2 n/mm²
Break Tear Strength	19.4 n/mm²
Uses	Economy grade. Firm molds, filigree & thin channels. High precision.

*Shrinkage rates given are for the rubber mould itself. Final casting shrinkage rates depend on mouldmakers and caster's skill, knowledge, precision and attention to detail.



Silicone Molding Rubber



Castaldo Silicone Molding Rubber is soft and pliable, with a consistency like putty or modeling clay.

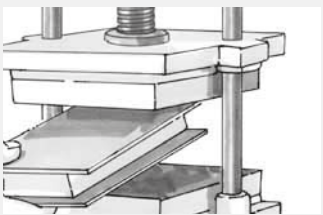
Mold frame packing with Castaldo Silicone Molding Rubber is fast, easy and requires no tools.



Placing and embedding the model exactly as you want it is simple.



Curing Castaldo Silicone Jewelry Molding Rubber Molds involves no mixing, limited working times or de-bubbling. Simply put it in your vulcanizer at 330°-150°F (165°-177°C) for 15 minutes per 1/4 inch (6mm).



Castaldo Silicone Jewelry Molding Rubber Molds are easy to cut, reducing hand fatigue and increasing control. Users say they "Cut like butter".



Parting lines are easily controlled and corrected by hand when used with the powder separation technique.



Finished molds can be simple or complex with cores, straight plugs or even spiral plugs. Castaldo Silicone Jewelry Rubber Molds are strong and tear resistant and can last for years and years.

BURNING IN SPRUES: CASTALDO® silicone jewelry molding rubbers can be burned in the usual manner to add sprues or correct details but higher temperatures are needed. Use adequate ventilation!

CAUTION: Vapors given off during vulcanization may produce temporary eye, nose and throat irritation among certain susceptible individuals. Use with adequate ventilation.

STORAGE: As with any unvulcanized rubber compound, store away from any source of heat and light. Unvulcanized shelf life is at least one year if properly stored except for low-temperature cure compounds. The storagelife of those compounds can be severely shortened by unintentional exposure to heat in shipping and storage.