



CUSTOMER SERVICES BULLETIN

GI-1000 ULTRA FAST CATALYST

DESCRIPTION

GI-Ultra-Fast Catalyst (GI-UFC) has been formulated to dramatically accelerate the speed at which the GI series RTV silicone rubbers cure. Standard working times for the GI series rubbers range between one and three hours with demold times between 16 and 24 hours. GI-UFC can give a working time of 10 minutes and a demold time of 30 minutes.

DIRECTIONS

GI-Ultra-Fast Catalyst can be used *in place of* the standard GI series Activator or *in combination with* the standard Activator. The rate of cure can be changed by *altering the amount* of GI-UFC or by *varying the ratio* of the standard Activator and GI-UFC as shown in the tables below.

The first 2 tables show the cure rates of GI-1000B and GI-1120B with *different levels* of GI-UFC. The third table on the back of this page shows the cure rate of GI-1000B using *various blends* of GI-1000B and GI-UFC.

All values are accurate to within plus or minus 10% and are measured at 70 °F/50% R.H. Higher temperatures and/or higher humidity will increase the speed of cure. There will be some natural variability in the cure rates of the different lot numbers of Bases and Activators. *When determining the level of GI-UFC or the ratio of GI-UFC/standard Activator, it is recommended to err on the side of longer working times and cure times.*

AMOUNT OF ULTRA-FAST CATALYST

GI-1000B	5%	8%	10%	12%	15%
Working Time (mins.)	49	17	13	9	7
Demold time (mins.)	210	75	50	35	30
Shore A Hardness					
30 minutes	--	--	--	0	1
45 minutes	--	--	0	4	8
60 minutes	--	--	3	10	12
90 minutes	--	3	13	16	17
2 hours	--	11	18	19	19
3 hours	--	20	23	23	23
4 hours	2	24	24	24	25
24 hours	30	30	30	30	30

AMOUNT OF ULTRA-FAST CATALYST

GI-1120B	5%	8%	10%	12%	15%
Working Time (mins.)	63	22	15	11	8
Demold time (mins.)	360	100	70	55	40
Shore A Hardness					
30 minutes	--	--	--	--	--
45 minutes	--	--	--	--	--
60 minutes	--	--	--	0	0
90 minutes	--	--	0	1	2
2 hours	--	0	1	3	4
3 hours	--	3	5	6	7
4 hours	--	6	9	9	9
24 hours	16	16	16	16	16

AMOUNT OF ULTRA-FAST CATALYST

GI-1000B with GI-1000A GI-UFC	8%	6%	5%	4%	2%
	2%	4%	5%	6%	8%
Working Time (mins.)	34	22	18	15	13
Demold time (mins.)	165	105	75	60	55
Shore A Hardness					
30 minutes	--	--	--	--	--
45 minutes	--	--	--	--	--
60 minutes	--	--	--	0	0
90 minutes	--	0	3	7	9
2 hours	--	5	10	15	15
3 hours	0	15	18	20	21
4 hours	8	20	22	22	24
24 hours	30	30	30	30	30

The information contained in the product bulletin is based on sources believed to be accurate. It is offered in good faith but without guarantee since the conditions of use are beyond our control. All risks of use are assumed by the buyer.

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