

## MM 4400

### Character

MM4400 is a two component room temperature, condensation cure, silicone paste system. The cured rubber is a medium hardness material ideal for vertical moulding making of architectural materials, columns and statues.

### Technical Data

	MM 4400 A-Component	MM CAT 4400 B-Component		
Appearance	Grey	Yellow		
	<b>Catalysed Mass</b>			
Mixing ratio	20:1			in weight shares
Cure Type	Condensation			
Colour	Yellow			
FDA	No			CFR (21) 177.2600
Pot Life	15		Min.	
De-Mould Time	1		h	
Max Cure @ 25°C	1		h	
	<b>Vulcanisate after 7 days at 23°C +/- 2°C and 50% +/-5% humidity</b>			
CTE Linear	268		ppm/°C	
CTE Volumetric	804		ppm/°C	
Duro Shore A	16			ASTM D 2240-95
Working Temp.	-50 to 200		°C	AFS-1540B
Tensile	1.5		MPa	ISO 37
Elongation	400		%	ISO 37
Tear	8		kN/m	ISO 34-1
Linear Shrinkage	0.5		%	
SG	1.2			BS ISO 2781

The above given values are product describing data. Please consult the 'delivery specification' for binding product specifications. Further data about product properties, toxicological, ecological data as well as data relevant to safety can be found in the safety data sheet.

### Storability / Storage

When proper storage approx. 12 months if stored properly at < 40°C and protected from frost and dry in closed original containers.

## Properties

- Thixotropic Paste
- 20:1 mix ratio
- Ideal for taking impressions of vertical surfaces
- Catalyst in easy to use tubes

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## Application Technique

### Processing

MM 4400 is manually mixed with the 5% of curing agent MM CAT 4400, and applied within the pot life time; it is advisable use small quantities (200-300g) each time, just to prevent a procuring of the products that should make it useless. Reaching of the perfect mixture can be established when the colour is uniform. The catalysed mass is manually pressed onto the pattern. In case of necessity of very detailed reproductions is advisable use as follows:

1. Clean and degrease the pattern (this step is anyway suggested for a good impression result).
2. Paint one or two coats of pourable product in addition with MMTA2 thixotropic agent; this step is necessary just to reach the perfect details definition of the pattern's surface.  
The products used in this way are all the MM900 series.
3. Before the painted coats are cured, start the application of catalysed MM4400, in order to give fast thickness to the mould; usually the desired thickness is about 20-30 mm.
4. Once cured, is possible build up a mother mould in fibreglass or gypsum.  
This process allows a faster solution in case of big dimension objects and is widely used in monumental restoration.

**It is absolutely important to check the compatibility in preliminary tests if unknown substrates are used.**

### Safety

Please observe our EC safety data sheets and the safety remarks on our container labels when handling our products. The dangerous goods regulations and the accident prevention regulations of the professional associations must be particularly observed. Keep the EC safety data sheet of the applied product at hand since it provides you with useful instructions for the safe use and disposal of the product as well as for actions to be taken in case of accidents.

**We reserve the right to modify the product and technical leaflet.**

**Our department for applied technique is always at your service for further information and advice.**

Our technical advice and recommendations given verbally, in writing or by trials are believed to be correct. They are neither binding with regard to possible rights of third parties nor do they exempt you from your task of examining the suitability of our products for the intended use. We cannot accept any responsibility for application and processing methods which are beyond our control.

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