

## MM228

### Characterization

MM228 is a pourable 2 component addition cure silicone elastomer system. After mixing components A and B in the correct proportions, the system will cure at ambient temperatures within 24 hours, but the rate of cure can be accelerated by heat. The cured rubber exhibits excellent physical and electronic properties and is ideal for use as a moulding rubber.

### Technical Data

	MM228 A A-Component	MM228 B B-Component		
Appearance	Translucent	Translucent		
Viscosity	18,000	1,000	mPa·s	Brookfield HBTD
<b>Catalysed Mass</b>				
Mixing ratio	10:1		in weight shares	
Cure Type	Addition			
Colour	Translucent			
Mixed Viscosity	13,000		mPa·s	Brookfield HBTD
FDA	No		CFR (21) 177.2600	
Pot Life	55		Min.	
De-Mould Time	5		h	
Max Cure at 25°C	24		h	
Max Cure at 100°C	30		Min	
<b>Vulcanisate after 7 days at 23°C +/- 2°C and 50% +/-5% humidity</b>				
CTE Linear	267		ppm/°C	
CTE Volumetric	801		ppm/°C	
Duro Shore A	28			ASTM D 2240-95
Working Temp.	-60 to 200		°C	AFS-1540B
Tensile	5.06		MPa	ISO 37
Elongation	746		%	ISO 37
Modulus Youngs	0.62		MPa	
Tear	31		kN/m	ISO 34-1
Linear Shrinkage	0.06		%	
SG	1.12			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**

With a proper storage the product will hold for approx. 12 months if stored max. at 30 °C and protected from frost in a dry place in closed original containers.

## **Properties**

- Good abrasion resistant properties
  - Good dimensional stability
  - Very low viscosity
  - Can be diluted with TAMPO 50 FLUID
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## **Application Technique**

### **Processing**

Important:

Component A of the product contains the platinum catalyst; great care should be taken when using automatic dosing equipment. Please ensure that it is not contaminated by residual hydride containing rubber in the dosing equipment, as curing will result. If in doubt, it's advised to thoroughly purge the equipment with a suitable hydrocarbon solvent or silicone fluid.

Both components A and B should be well stirred to ensure the material is uniform and any settlement of the fillers have been remixed. Place the required amount of components A and B by weight at the mix ratio shown above, in a clean plastic or metal container of approximately 3 times their volume, and mix until the colour of the mixture is uniform. For best results, we recommend degassing. Degas by intermittent evacuation, the larger volume of the mixing vessel helps prevent overflow during this operation. In case of automatic dispensing with a static mixing head, the two components should be degassed before processing. Recommended vacuum conditions are 30-50 mbar intermittently over 5-10 min. Cast the mixture either by gravity or pressure injection.

### **Inhibition of Cure**

Great care must be taken when handling and mixing all addition cured silicone elastomer systems, ensuring that all the mixing tools (vessels and spatulas) are clean and constructed in materials which do not interfere with the curing mechanism. The cure of the rubber can be inhibited by the presence of compounds of nitrogen, sulphur, phosphorus and arsenic; organotin catalysts and PVC stabilizers; epoxy resin catalysts and even contact with materials containing certain of these substances e.g. moulding clays, sulphur vulcanised rubbers, condensation cure silicone rubbers, onion and garlic.

## **Curing Conditions**

Mixing of the components at temperatures between 15 and 25 °C is recommended to ensure adequate pot life for degassing and handling. The pot life can be extended to several hours by chilling the components before mixing.

**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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