

TECHNICAL DATA SHEET

MM 4400 2 part moulding compound

Description

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

Key Features

- Thixotropic paste
- 10:1 mix ratio
- Ideal for taking impressions of vertical surfaces
- Catalyst packed in easy to use tubes

Use and Cure Information

MM4400 is manually mixed with the 5% of curing agent MM CAT4400, and applied within the pot life time; it is advisable use small quantities (200-300 gr.) each time, just to prevent a procuring of the product 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 Thixotroping 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 MM 900 series.

3. Before the painted coats are cured, start the application of catalyzed 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

Health & Safety

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Safety Data Sheets available on request.

Packaging

CHT Moulding Rubbers are available in a variety packaging including bulk containers. Please contact our sales department for more information.

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Revision No 2
Download Date 25 Oct 2021

Property

Uncured Product

Appearance

Cure Profile

Cure Type

De-mould Time / Full Cure
at 23°C/73°F

Mix Ratio By Weight

Pot Life mins at
23°C/73°F

Cured Product

Color

Density

Elongation at Break

Hardness Shore A

Linear Shrinkage (%)

Max Working Temp

Min Working Temp

Tear Resistance (N/mm)

Tensile Strength

Storage

Max Storage
Temperature

Shelf Life

Test Method

Value

Yellow Putty
**23°C and 50%
humidity**
Condensation

1 hr hrs

10:1

15 min mins

Yellow

BS ISO 2781

1.2 g/cm3

ISO 37

400 %

ASTM D
2240-95

16

BS ISO 34-1

0.5 %

BS ISO 34-1

200 °C / 392 °F

BS ISO 34-1

-50 °C / -58 °F

BS ISO 34-1

8 N/mm / 46 ppi

ISO 37

**1.5 N/mm2 / 218
psi**

40 °C / 104 °F

12 mths

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The CHT technical service department is available to offer further information and advice and should it be needed to look at modifying current products or custom formulate a new one to meet your specific requirements. Please contact the technical service department.

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