Technical Data Sheet

MM810

Condensation cure silicone moulding rubber 11 Shore A low tear

Introduction

This is a two-component low tear room temperature condensation cure silicone system. The cured rubber is suitable for the mould making of patterns with fine details, where some dimensional stability is required. Low tear silicone moulding rubbers are cost effective for the production of moulds only requiring a few impressions. They find uses in the reproduction of plane surface objects

Key Features

- Easy demoulding
- Easily degassed
- Low viscosity
- Fine detail pick up

Use and Cure Information

The curing process starts as soon as the catalyst is added. Under normal conditions of temperature and humidity typical curing characteristics are described below. If the product is to be used in contact with aggressive chemicals, such as high styrene polyester resins or epoxies, it is recommended that the rubber be allowed to cure for 48 hours before use.

Pour the catalysed rubber into the mould from one point, ensuring air is not entrapped. Allow the rubber to cure before removing from the mould. To allow the rubber to achieve its maximum physical properties and chemical resistance leave the partially cured rubber to age at room temperature for at least a further 12 hours.

How to Use

Charge the base rubber into a clean plastic or metal container, approximately 3-4 times its volume.

Add standard catalyst in the proportion of 5 parts by weight of catalyst to 100 parts by weight of the rubber base. Mix thoroughly, slowly at first to avoid splashing and taking care to avoid excessive air entrapment. After catalysation any entrapped air may be removed by intermittent evacuation for several minutes. The use of a sufficiently large container permits degassing without overflow.

Property	Test Method	Value
Uncured product		
Appearance		**Viscous Liquid**
Colour A Part		**Grey**
Cure Type		**Condensation**
De-Mould Time Hrs		**2 hrs**
Max Cure Hrs @ 25 °C		**2 hrs**
Mix Ratio		**20:1**
Pot Life mins		**15 mins**
Viscosity A-Part mPas	Brookfield	**10000 mPas**
Viscosity B-Part mPas	Brookfield	**50 mPas**
Viscosity Mixed mPas	Brookfield	**6000 mPas**
Cured product		
After 7 days cure at 23°+/-2°C and 50+/-5% humidity		
CTE Linear ppm/°C		**253 ppm/°C**
CTE Volumetric ppm/°C		**759 ppm/°C**
Duro Shore A	ASTM D 2240-95	**11**
Elongation %	ISO 37	**250 %**
FDA	CFR (21) 177.2600	**No**
Linear Shrinkage %		**0.5 %**
Max Working Temp +°C	AFS_1540B	**180 °C**
Min Working Temp - °C		**-50 °C**
SG	BS ISO 2781	**1.27**
Tear kN/m	BS ISO 34-1	**2 kN/m**
Tensile MPa	ISO 37	**0.8 MPa**
Storage		
Max storage temperature °C		**40 °C**
Shelf life		**12 mths**

Catalysts

Use the following catalyst available from ACC Silicones

Code	Colour	Pot Life	De-Mould
MM CAT L5 NT	Clear	>60 mins	<24 hrs

Health and Safety

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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