

MM828

Condensation cure silicone moulding rubber 28 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.

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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Property

Uncured product

Property	Test Method	Value
Appearance		Viscous Liquid
Colour A Part		Grey
Cure Type		Condensation
De-Mould Time Hrs		1.75 hrs
Mix Ratio		20:1
Pot Life mins		15 mins
Viscosity A-Part mPas	Brookfield	18000 mPas
Viscosity B-Part mPas	Brookfield	50 mPas
Viscosity Mixed mPas	Brookfield	800 mPas

Cured product

After 7 days cure at 23° +/-2° C and 50+/-5% humidity

CTE Linear ppm/°C		259 ppm/°C
CTE Volumetric ppm/°C		778 ppm/°C
Duro Shore A	ASTM D 2240-95	28
Elongation %	ISO 37	150 %
FDA	CFR (21) 177.2600	No
Linear Shrinkage %		0.5 %
Max Working Temp +°C	AFS_1540B	200 °C
Min Working Temp - °C		-50 °C
SG	BS ISO 2781	1.24
Tear kN/m	BS ISO 34-1	2.5 kN/m
Tensile MPa	ISO 37	1 MPa

Storage

Max storage temperature °C	40 °C
Shelf life	12 mths

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