

## QM 128 2 part moldmaking material

### Description

QM 128 is a two-component, room temperature, condensation cure, silicone material. The cured rubber has excellent mechanical properties and shelf-life stability. This material is an excellent choice for the molding of intricate patterns, skin molding and applications where high durometer, dimensional stability and extremely tough rubber are required. A variety of catalysts are offered with this material.

### Key Features

- High tear strength
- Low viscosity
- Fast de-mold time

### Key Applications

- Complies with FDA indirect food contact regulation CFR 177.2600, when used with QM Cat Clear FG. Refer to QM Cat Clear FG data sheet for typical properties.

### Application

Molds of statue, picture frames, furniture,, technical articles, prototypes, polyester, PU and epoxy

### Use and Cure Information

#### CURE CHARACTERISTICS

The standard catalyst for the QM 100\* series is QM Cat Purple catalyzed 10:1 (base:catalyst) by weight. QM Cat Blue is recommended for those needing a longer working time or those hand mixing larger quantities. Faster cure can be obtained using DBT, a higher level of QM Cat Purple, or QM Cat Red 3. However, rapid cure of condensation cure moldmaking rubber often results in a small sacrifice of physical properties or an increase in hardness. The curing process begins as soon as the catalyst is mixed with the base. The material will cure as described in the data above under normal temperature (25°C) and humidity conditions (50% RH). Because this system is sensitive to heat and humidity, a change in cure speed may be observed if one or both of these variables are altered. A large difference in temperature (+/- 5°C) or humidity (> 60% - 70%) may alter the cure profile of the material. In addition, if the product is to be used with aggressive resins such as high styrene polyester resins, it is recommended that the rubber be allowed to cure for 48 hours.

\*QM 100, QM 135 and QM 140 each require their own specific catalyst. Please see individual data sheets for details.

#### MIXING

All condensation cure catalysts should be thoroughly mixed prior to catalyzation. CHT recommends that the catalyzed material be tested on a small area of the mold prior to use. QM 128 should be thoroughly mixed with the chosen catalyst using a 10:1 ratio (base:catalyst) by weight. Shake the catalyst well before use. Material should be mixed in a clean, compatible metal or plastic container. The volume of the container should be 3 - 4 times the volume of the material to be mixed. This allows for expansion of the siloxane material during de-aeration. Mix thoroughly by hand or with mixing equipment while minimizing air entrapment until a homogeneous mixture is obtained.

#### DE-AERATION

Air trapped during mixing should be removed by vacuum at 29 inches of mercury. During the process, the material will expand, and intermittent evacuation may be required. Typically, after releasing the vacuum 2 - 3 times, the mass will collapse on itself at which time the vacuum should be left on for an additional 2 - 4 minutes.

Property	Test Method	Value
<b>Uncured Product</b>		
Cure Profile		<b>3 days, 25°C, 50% humidity</b>
Cure Type		<b>Condensation</b>
De-mould Time / Full Cure at 23°C/73°F		<b>16 - 24 hrs</b>
Density A	BS ISO 2781	<b>1.31</b>
Density B	BS ISO 2781	<b>1.00</b>
Mix Ratio By Weight		<b>10:1</b>
Rheology		<b>Liquid</b>
Tack Free Time / Skin Formation at 23°C/73°F		<b>6 - 8 hr</b>
Viscosity A	Brookfield	<b>35000 cP</b>
Viscosity B	Brookfield	<b>100 cP</b>
Viscosity Mixed	Brookfield	<b>30000 cP</b>
<b>Cured Product</b>		
Color		<b>Blue</b>
Density	BS ISO 2781	<b>1.30 g/cm3</b>
Elongation at Break	ISO 37	<b>400 %</b>
Hardness Shore A	ASTM D 2240-95	<b>28</b>
Linear Shrinkage (%)		<b>&lt;0.3 %</b>
Tear Resistance (N/mm)	BS ISO 34-1	<b>24.3 N/mm / 140 ppi</b>
Tensile Strength	ISO 37	<b>3.45 N/mm2 / 500 psi</b>
<b>Storage</b>		
Max Storage Temperature		<b>38 °C / 100 °F</b>
Shelf Life		<b>12 mths</b>

The content set out in the technical data sheet does not contain information upon which you should rely. It is provided for general information purposes only and does not constitute a product specification. You must obtain professional or specialist advice before taking any action based on the information provided in the technical data sheet.

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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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UNCATALYZED				
TEST	QM 128	QM CAT PURPLE	QM CAT BLUE	QM CAT RED 3
Color	Beige	Purple	Blue	Red
Viscosity	35,000 cps	100 cps	100 cps	100 cps
Specific Gravity	1.31	1.00	1.00	1.00

CATALYZED			
MIX RATIO 10:1 by weight			
PROPERTY	QM CAT PURPLE	QM CAT BLUE	QM CAT RED 3
Color	Light Purple	Light Blue	Light Red
Viscosity	30,000 cps	30,000 cps	30,000 cps
Specific Gravity	1.30	1.30	1.30
Work life at 25°C *	35 minutes	45 minutes	7 minutes
Durometer shore A, 24 hours	24	24	24
Tack-free time	4 - 6 hours	6 - 8 hours	45 - 60 minutes
Demold time	12 - 16 hours	16 - 24 hours	4 - 6 hours

\* Work life is defined as the amount of time required for the material to double in catalyzed viscosity.

CURED PROPERTIES	
3 DAYS @ 25°C	
Durometer, Shore A	28
Tensile Strength	500 psi
Elongation	400%
Tear B	140 ppi
Linear Shrinkage	< 0.3%

Thixotropic and styrene resistant specialty catalysts are also available. Please see individual catalyst data sheets for more information.

### Storage

See product label and/or CoA for specific "Use By Date". Product should be stored in its original, unopened container. Storage beyond the date specified on the label does not necessarily mean that the product is no longer usable. In this case, the properties required for the intended use should be checked for quality assurance reasons.

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