TECHNICAL DATA SHEET



QM 245 2 part moldmaking material

Description	Property	Test Method	Value
This is a pourable 2-part addition cure silicone elastomer system. After mixing parts '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 electrical properties. Key Features	Uncured Product Color A Color B Cure Profile Cure Type		Beige Dark red 3 days at 25°C Addition
Excellent tear resistanceCasting resin resistance	De-mould Time / Full Cure at 23°C/73°F		6 - 8 hrs
 Fast de-mold time Good mold flexibility Application Polyester, PU and epoxy casting resins, prototypes and technical 	Mix Ratio By Weight Rheology Specific Gravity A Specific Gravity B		10:1 Liquid 1.34 0.96
articles, architectural, picture frames, furniture Use and Cure Information IMPORTANT:	Viscosity A Viscosity B	Brookfield Brookfield	50,000 cP 2,000 cP
The 'A' part of product contains the platinum catalyst; great care should be taken when using automatic dispensing equipment. Please ensure that it is	Viscosity Mixed Work life at 25°C to Double Initial Viscosity	Brookfield	30,000 cP 45 minutes
not contaminated by residual hydride containing rubber in the dispensing equipment, as curing will result. If in doubt, it's advised to thoroughly purge the equipment with a suitable hydrocarbon solvent or silicone fluid.	Cured Product 3 days at 25°C Color		Red
Mixing	Elongation at Break	ISO 37	400 %
Both the 'A' and 'B' parts should be well stirred to ensure the material is uniform and any settlement of the fillers have been	FDA Tested	CFR (21] 177.2600	CFR 177.2600
remixed. Place the required amount of 'A' and 'B' parts by weight at the mix ratio shown opposite, 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	Hardness Shore A Linear Shrinkage (%) Max Working Temp Min Working Temp	ASTM D 2240-95	45 <0.1 % 204 °C / 399 °F -55 °C / -67 °F
the mixing vessel helps prevent overflow during this operation. In case of automatic dispensing with static mixing head, the two components should be degassed before processing.	Tensile Strength	ISO 37	4.14 N/mm2 / 600 psi
Recommended vacuum conditions are 30-50 mbar intermittently over 5-10 minutes. Cast the mixture either by gravity or pressure injection. In order to achieve optimum performance, the same "A" and "B" side lot number should be used.	Storage Max Storage Temperature Shelf Life		38 °C / 100 °F 24 mths

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

The data offers a guide to the rate of cure at various temperatures, 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.

Health & 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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